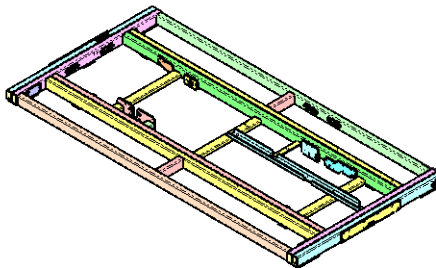
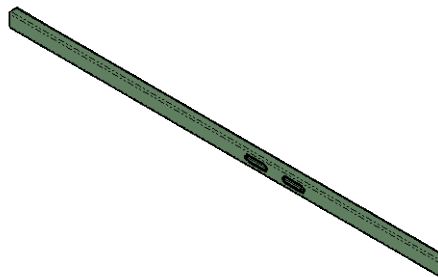
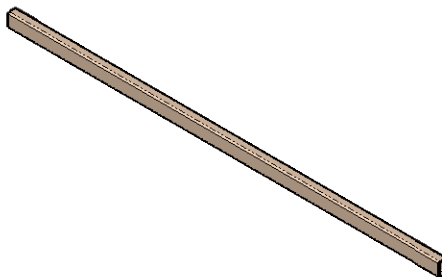
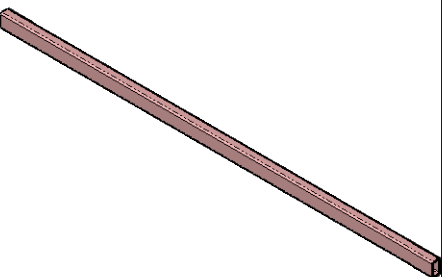
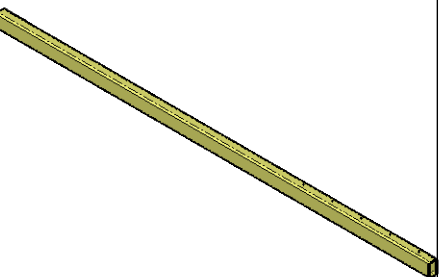
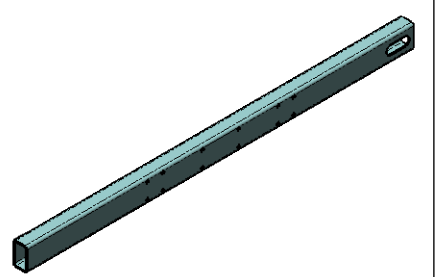
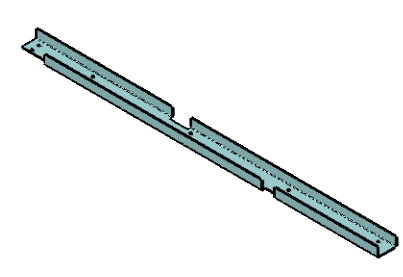
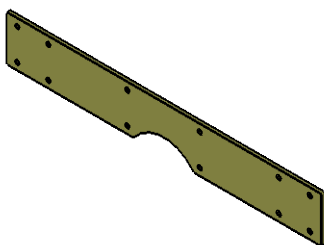
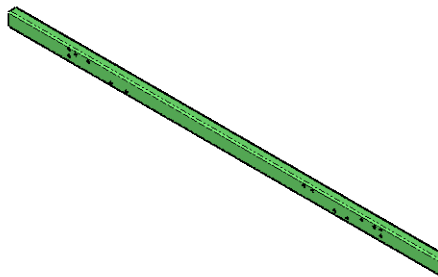
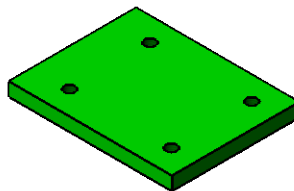
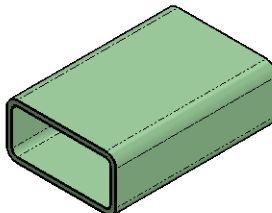
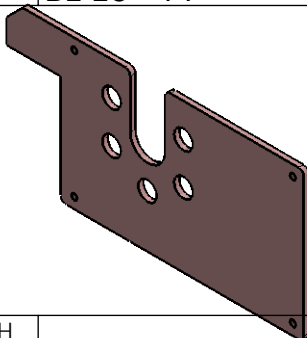
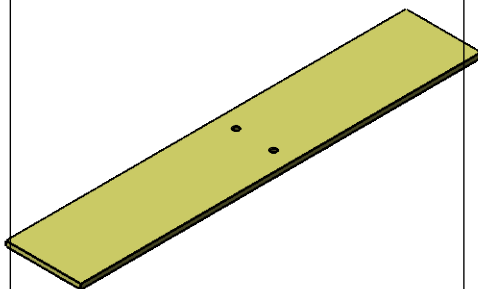

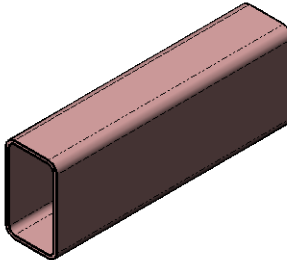
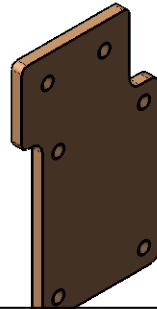
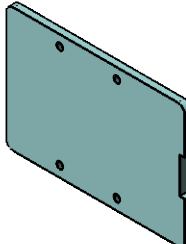
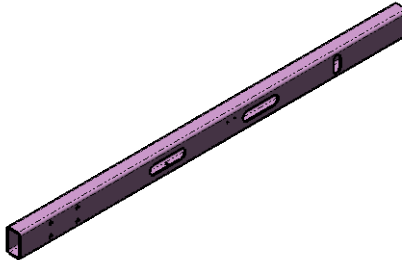
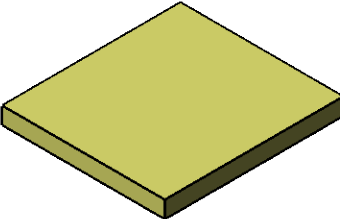
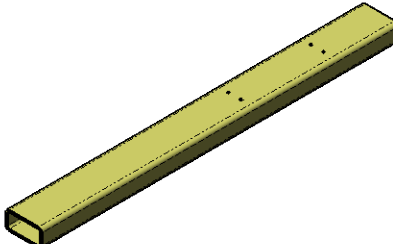
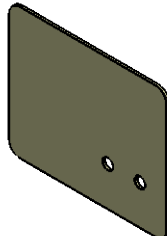
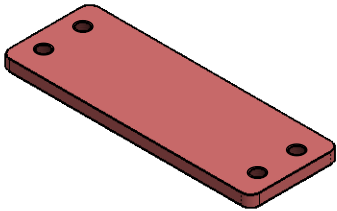
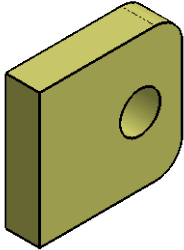
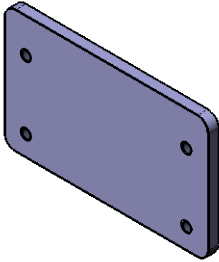
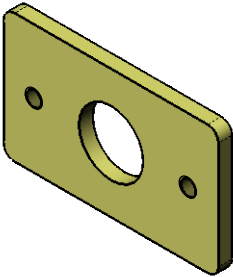
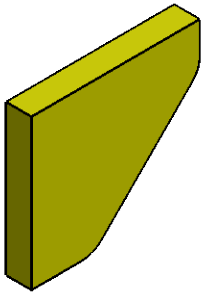
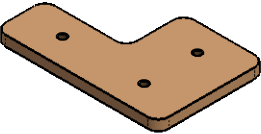
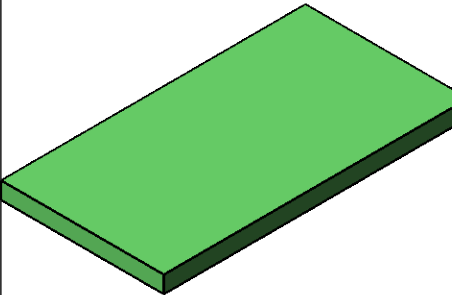


Metal Fabrication				Machine Model				Process Inst Name				Process Inst NO.				REV.		DATE		PREPARED BY: Leon Jiang				PAGE			
Process Instruction				AMS4020CL				FORK TRAVERSER FRAME				HW-Y201960--A				OI		07/31/19		APPROVED BY: Caesar M				1/11			
MACH BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM							
Main Part Sub Part	FT FRAME WELDMENT			Main Part Sub Part	LONG TUBE			Main Part Sub Part	LONG TUBE 2			Main Part Sub Part	DRIVE TUBE			Main Part Sub Part	LONG TUBE 3			Main Part Sub Part	SIDE TUBE			Main Part Sub Part	FT CABLE THROUGH		
DWG NO	Y201960--A	QTY	1 /M	DWG NO	Y20196001A	QTY	1 /M	DWG NO	Y20196002A	QTY	1 /M	DWG NO	Y20196003-	QTY	1 /M	DWG NO	Y20196004A	QTY	2 /M	DWG NO	Y20196006A	QTY	2 /M	DWG NO	Y20196011-	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	Mat Size			INIT/DATE
Length				Length				Length				Length				Length				Length				Length			
Paint	RT			Paint				Paint				Paint				Paint				Paint				Paint			
Time				Time				Time				Time				Time				Time				Time			
Part Flow				Part Flow	RI=>T			Part Flow	RI=>T			Part Flow	RI=>T			Part Flow	RI=>T			Part Flow	RI=>T			Part Flow	BL-LC=>T		
																											
MACH BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM			
Main Part Sub Part	FORK TRAVERSER MOUNT PLATE			Main Part Sub Part	IDLER TUBE			Main Part Sub Part	SCISSOR MOUNT BLOCK			Main Part Sub Part	MOTOR SUPPORT SHORT TUBE			Main Part Sub Part	FORK TRAVERSER MOTOR MOUNT PLATE			Main Part Sub Part	FT SENSOR BRACKET MOUNT PLATE			Main Part Sub Part	DUAL SPROCKET PLAT		
DWG NO	Y20196013A	QTY	2 /M	DWG NO	Y20196014-	QTY	1 /M	DWG NO	M20196015-	QTY	4 /M	DWG NO	Y20196016-	QTY	1 /M	DWG NO	Y20196017A	QTY	1 /M	DWG NO	Y20196018A	QTY	1 /M	DWG NO	Y20196023-	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	Mat Size			INIT/DATE
Length				Length				Length				Length				Length				Length				Length			
Paint				Paint				Paint				Paint				Paint				Paint				Paint			
Time				Time				Time				Time				Time				Time				Time			
Part Flow	BL-LC=>PF			Part Flow	RI=>T			Part Flow	BL-LC=>PF			Part Flow	OUT			Part Flow	BL-LC=>PF			Part Flow	BL-LC=>T			Part Flow	BL-LC=>PF		
																											
MACH BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM			
Main Part Sub Part	RIB TUBE			Main Part Sub Part	SPROCKET PLATE			Main Part Sub Part	TENSION BRACKET MOUNT PLATE			Main Part Sub Part	LONG RIB TUBE			Main Part Sub Part	WHEEL MOUNT BLOCK			Main Part Sub Part	CENTER TUBE 1			Main Part Sub Part	LARGE TUBE CAP		
DWG NO	Y20196104-	QTY	2 /M	DWG NO	Y20196105-	QTY	2 /M	DWG NO	Y20196107-	QTY	2 /M	DWG NO	Y20196108A	QTY	2 /M	DWG NO	Y20196109-	QTY	2 /M	DWG NO	Y20196111A	QTY	3 /M	DWG NO	Y20196113A	QTY	4 /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	Mat Size			INIT/DATE
Length				Length				Length				Length				Length				Length				Length			
Paint				Paint				Paint				Paint				Paint				Paint				Paint			
Time				Time				Time				Time				Time				Time				Time			
Part Flow	OUT			Part Flow	BL-LC=>PF			Part Flow	BL-LC=>PF			Part Flow	RI=>T			Part Flow	BL-LC			Part Flow	RI=>T			Part Flow	BL-LC		
																											

Metal Fabrication				Machine Model				Process Inst Name				Process Inst NO.				REV.		DATE		PREPARED BY: Leon Jiang				PAGE			
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MACH				MACH				MACH				MACH				MACH				MACH							
BOM				BOM				BOM				BOM				BOM				BOM							
Main Part	TENSIONER BRACKET			Main Part	TENSION TAB			Main Part	FB MOTOR MOUNT PLATE			Main Part	PILLOW BLOCK PLATE			Main Part	BRACKET GUSSET			Main Part	E CHAIN SUPPORT PLATE			Main Part	EXT WHEEL MOUNT BLOCK		
Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part			
DWG NO	Y20196115-	QTY	2 /M	DWG NO	Y20196118-	QTY	2 /M	DWG NO	Y20196121-	QTY	2 /M	DWG NO	Y20196122-	QTY	1 /M	DWG NO	Y20196124-	QTY	4 /M	DWG NO	Y20196125-	QTY	1 /M	DWG NO	Y20196126-	QTY	4 /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		Mat Size		INIT/ DATE	
Length				Length				Length				Length				Length				Length				Length			
Paint				Paint				Paint				Paint				Paint				Paint				Paint			
Time				Time				Time				Time				Time				Time				Time			
Part Flow	BL-LC=>T			Part Flow	BL-LC			Part Flow	BL-LC=>PF			Part Flow	BL-LC=>PF			Part Flow	BL-LC			Part Flow	BL-LC=>T			Part Flow	BL-LC		
																											
MACH				MACH				MACH				MACH				MACH				MACH				MACH			
BOM				BOM				BOM				BOM				BOM				BOM				BOM			
Main Part				Main Part				Main Part				Main Part				Main Part				Main Part				Main Part			
Sub 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	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		Mat Size		INIT/ DATE	
Length				Length				Length				Length				Length				Length				Length			
Paint				Paint				Paint				Paint				Paint				Paint				Paint			
Time				Time				Time				Time				Time				Time				Time			
Part Flow				Part Flow				Part Flow				Part Flow				Part Flow				Part Flow				Part Flow			
MACH				MACH				MACH				MACH				MACH				MACH				MACH			
BOM				BOM				BOM				BOM				BOM				BOM				BOM			
Main Part				Main Part				Main Part				Main Part				Main Part				Main Part				Main Part			
Sub 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	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		Mat Size		INIT/ DATE	
Length				Length				Length				Length				Length				Length				Length			
Paint				Paint				Paint				Paint				Paint				Paint				Paint			
Time				Time				Time				Time				Time				Time				Time			
Part Flow				Part Flow				Part Flow				Part Flow				Part Flow				Part Flow				Part Flow			
																				<div>If this stamp is not in RED INK this is NOT a CONTROLLED DOCUMENT</div> <div>Always report to a leadman or supervisor if there is any doubt or problem</div>							

Metal Fabrication

Machine Model

Process Inst Name

Process Inst NO.

REV.

DATE

PREPARED BY: Leon Jiang

PAGE

Process Instruction

AMS4020CL

FORK TRAVERSER FRAME

HW-Y201960--A

OI

07/31/19

APPROVED BY: Caesar M

3/11

2X Y20196004A 1X Y20196016- 2X Y20196121-

1X Y20196003-

3X Y20196111A

1X Y20196018A

1X Y20196011-

2X Y20196115-

2X Y20196023-

2X Y20196118-

2X Y20196107-

1X Y20196002A

1X Y20196017A

2X Y20196105-

2X Y20196006A

2X Y20196109-

2X Y20196013A

2X Y20196108A

4X Y20196126-

1X Y20196122-

4X Y20196113A

4X M20196015-

2X Y20196004A

4X Y20196124-

1X Y20196001A

2X Y20196104-

1X Y20196014-

PART NO.	DWG.NO.	NAME(ENG)	QTY.
1	Y20196001A	LONG TUBE	1
2	Y20196002A	LONG TUBE 2	1
3	Y20196003-	DRIVE TUBE	1
4	Y20196004A	LONG TUBE 3	2
5	Y20196006A	SIDE TUBE	2
6	Y20196011-	FT CABLE THROUGH	1
7	Y20196013A	FORK TRAVERSER MOUNT PLATE	2
8	Y20196014-	IDLER TUBE	1
9	M20196015-	SCISSOR MOUNT BLOCK	4
10	Y20196016-	MOTOR SUPPORT SHORT TUBE	1
11	Y20196017A	FORK TRAVERSER MOTOR MOUNT PLATE	1
12	Y20196018A	FT SENSOR BRACKET MOUNT PLATE	1
13	Y20196023-	DUAL SPROCKET PLATE	2
14	Y20196104-	RIB TUBE	2
15	Y20196105-	SPROCKET PLATE	2
16	Y20196107-	TENSION BRACKET MOUNT PLATE	2
17	Y20196108A	LONG RIB TUBE	2
18	Y20196109-	WHEEL MOUNT BLOCK	2
19	Y20196111A	CENTER TUBE 1	3
20	Y20196113A	LARGE TUBE CAP	4
21	Y20196115-	TENSIONER BRACKET	2
22	Y20196118-	TENSION TAB	2
23	Y20196121-	FB MOTOR MOUNT PLATE	2
24	Y20196122-	PILLOW BLOCK PLATE	1
25	Y20196124-	BRACKET GUSSET	4
26	Y20196125-	E CHAIN SUPPORT PLATE	1
27	Y20196126-	EXT WHEEL MOUNT BLOCK	4

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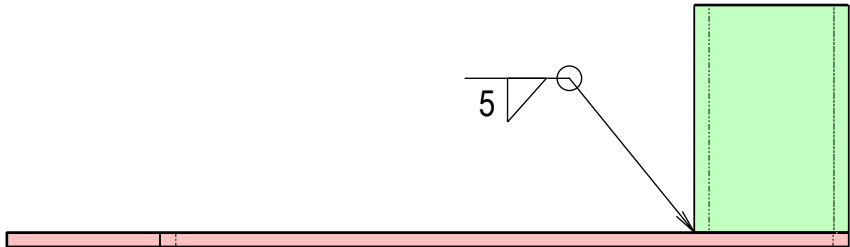
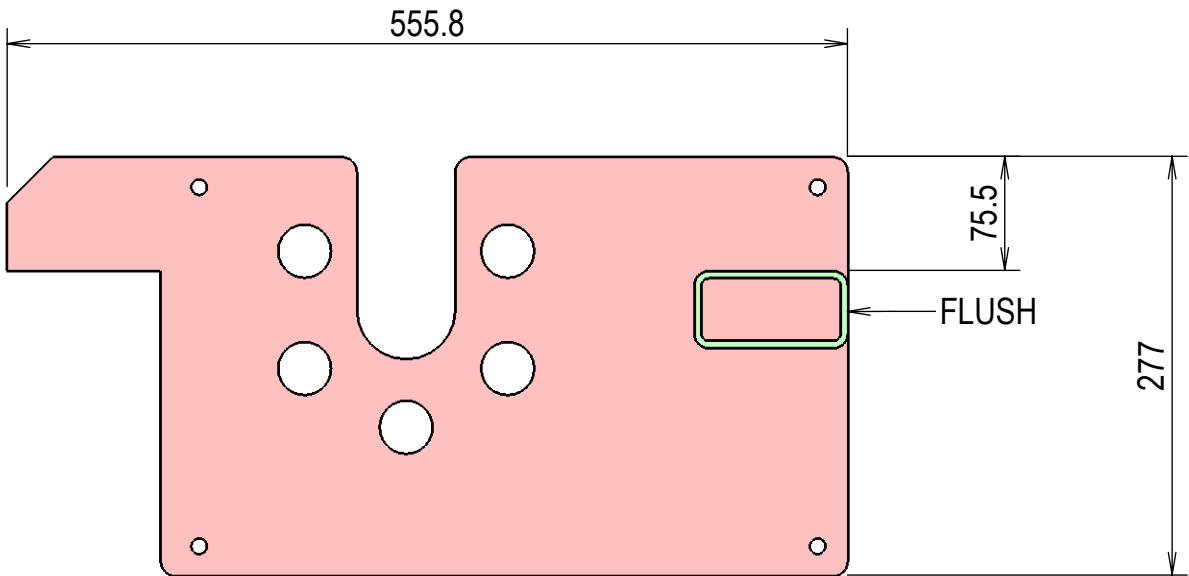
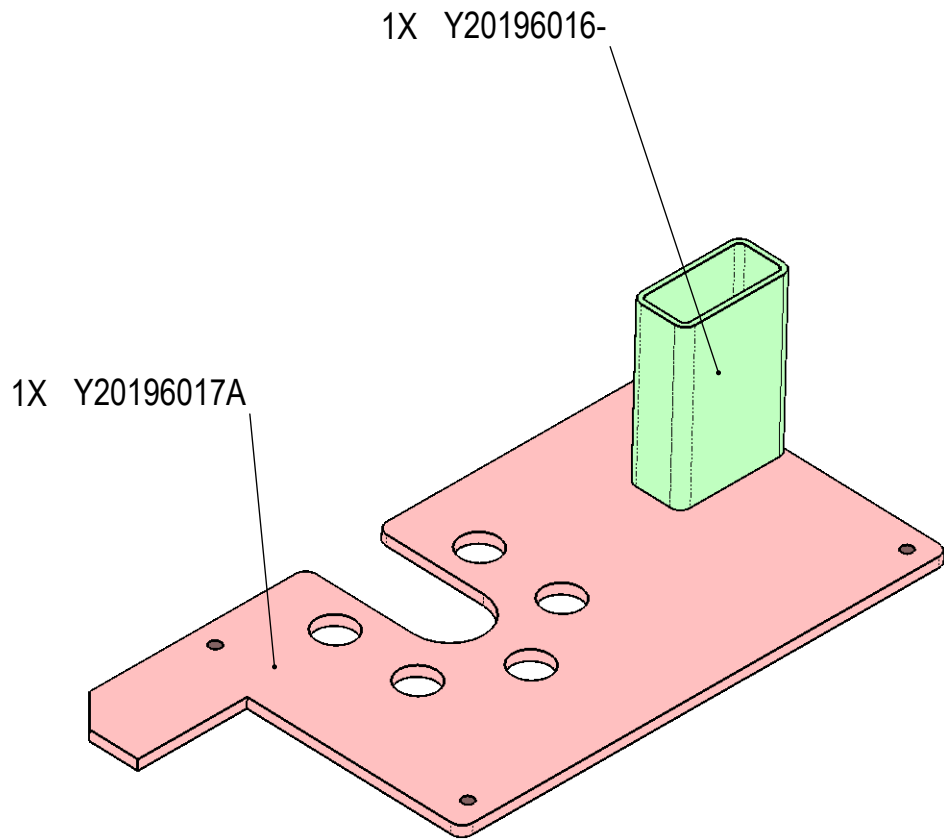
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SUB WELDMENT 1



NOTE: PRESS THE PLATE TO GET FLATNESS

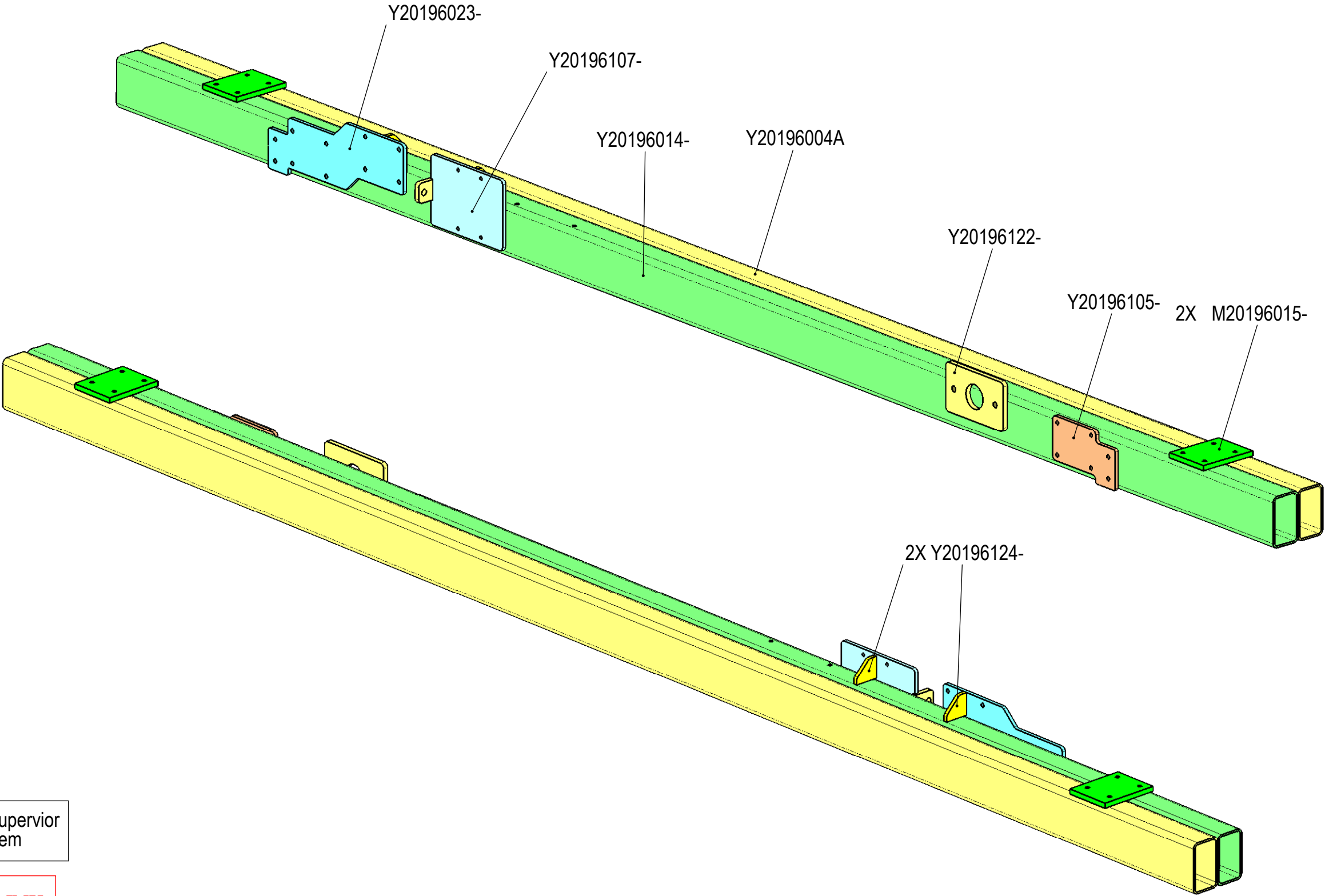
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SUB WELDMENT 2

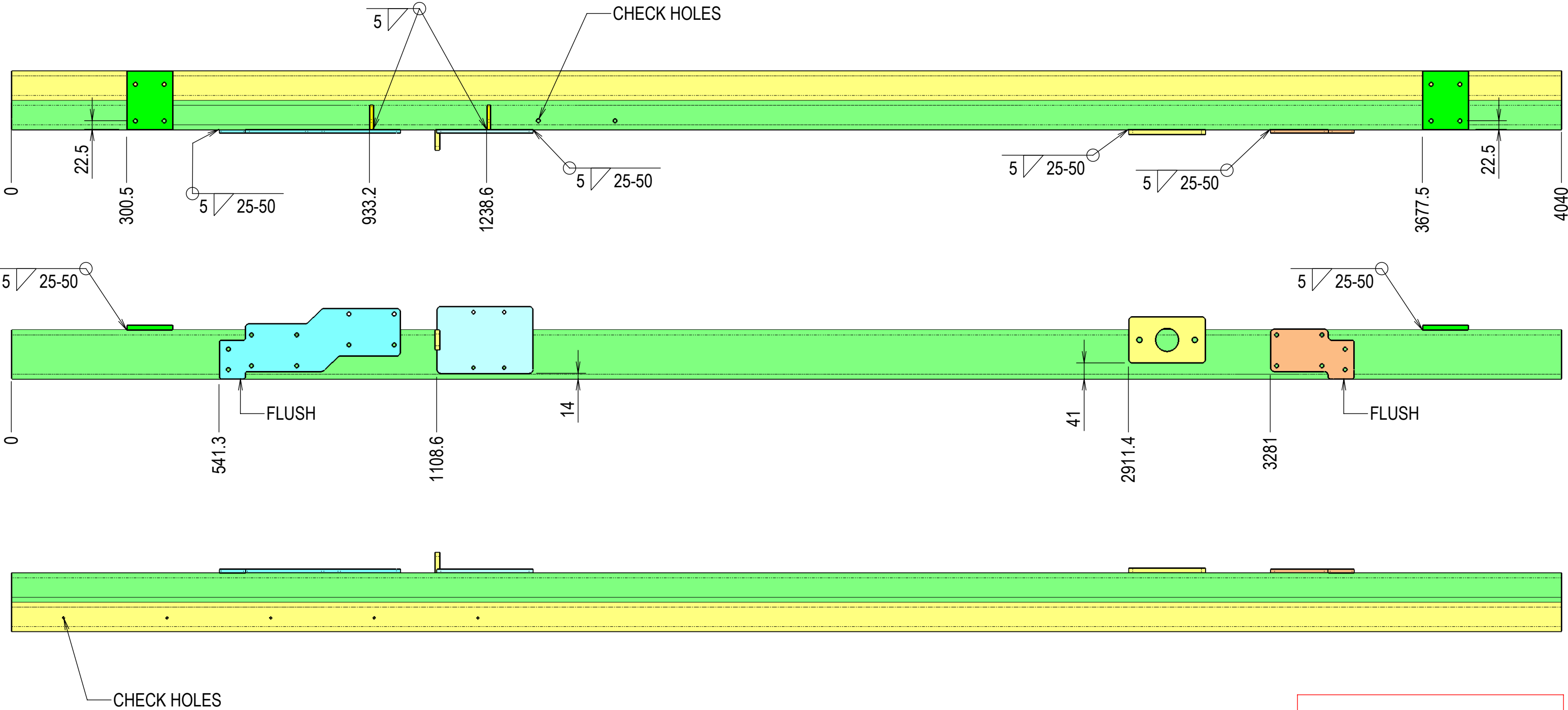


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SUB WELDMENT 2

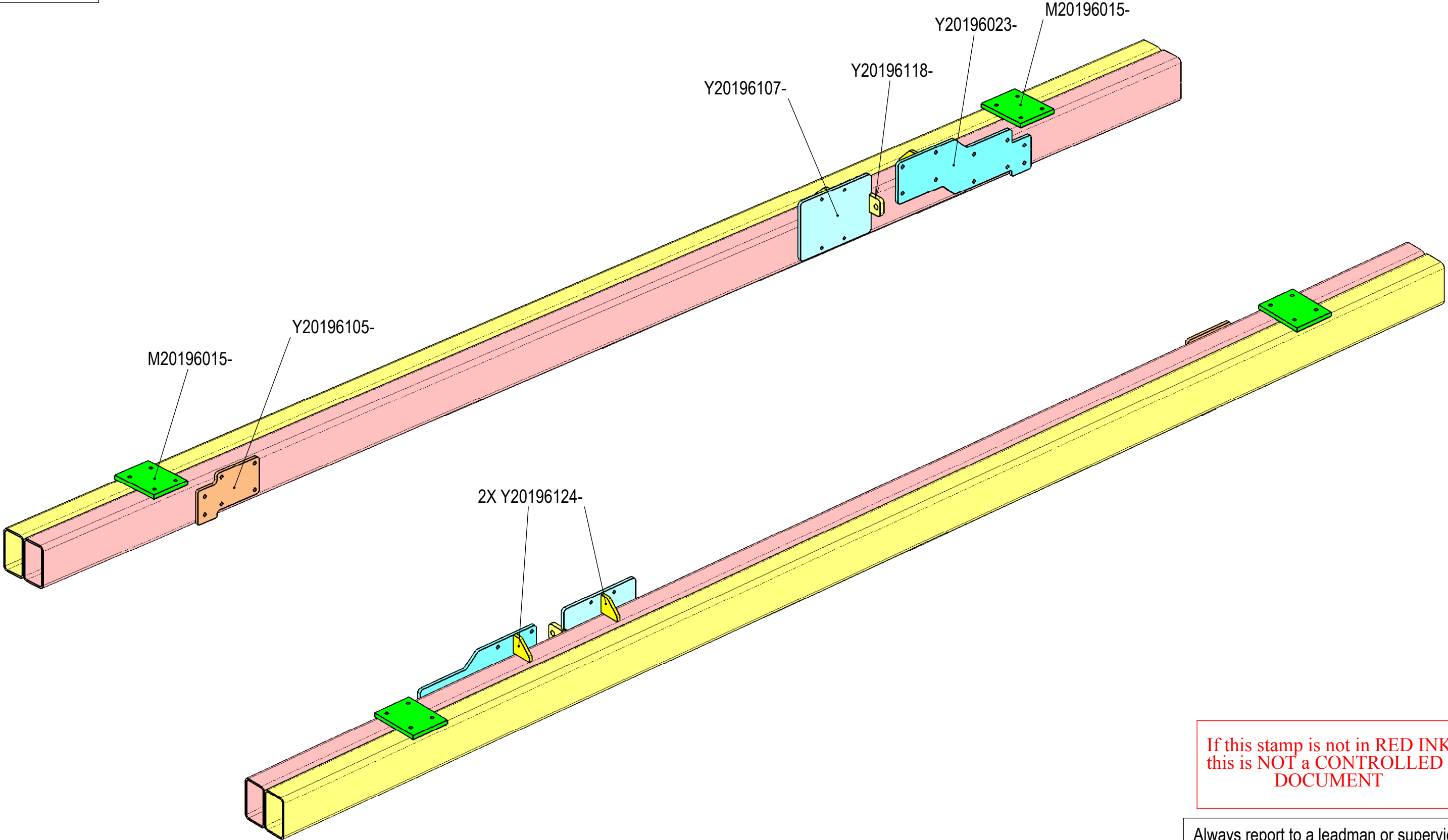


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SUB WELDMENT 3

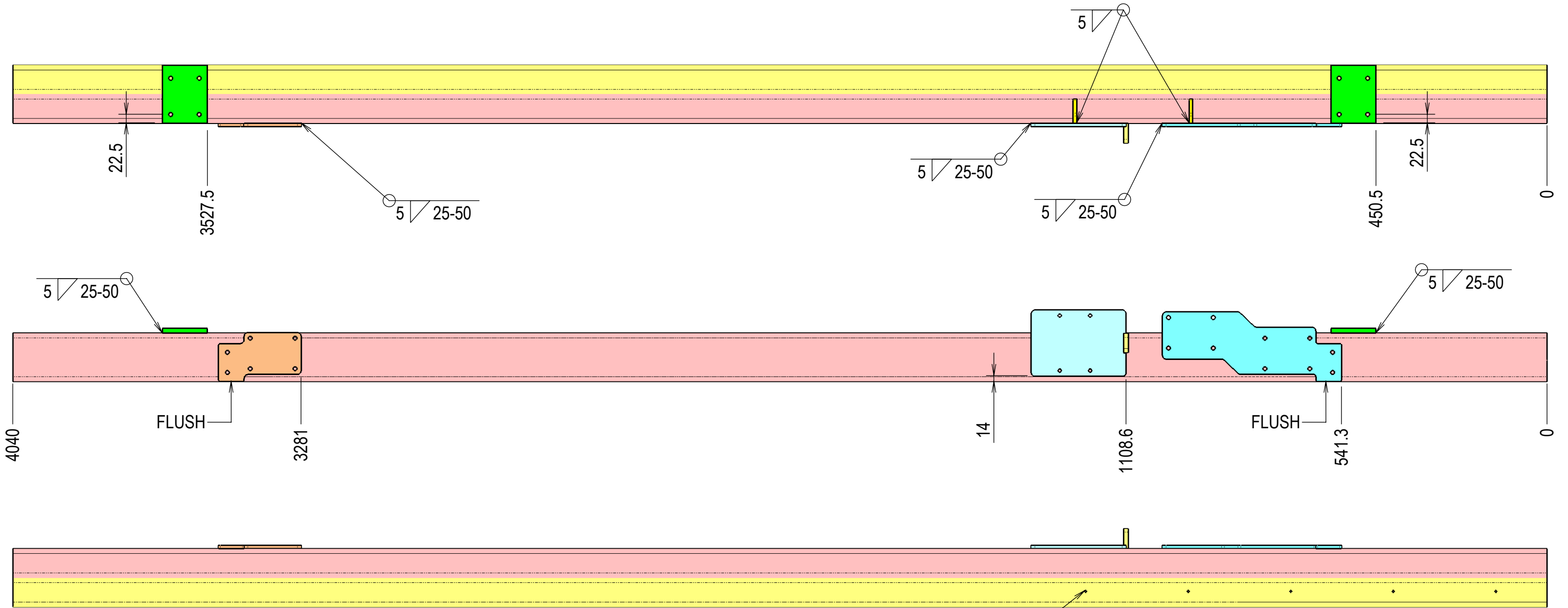


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SUB WELDMENT 3



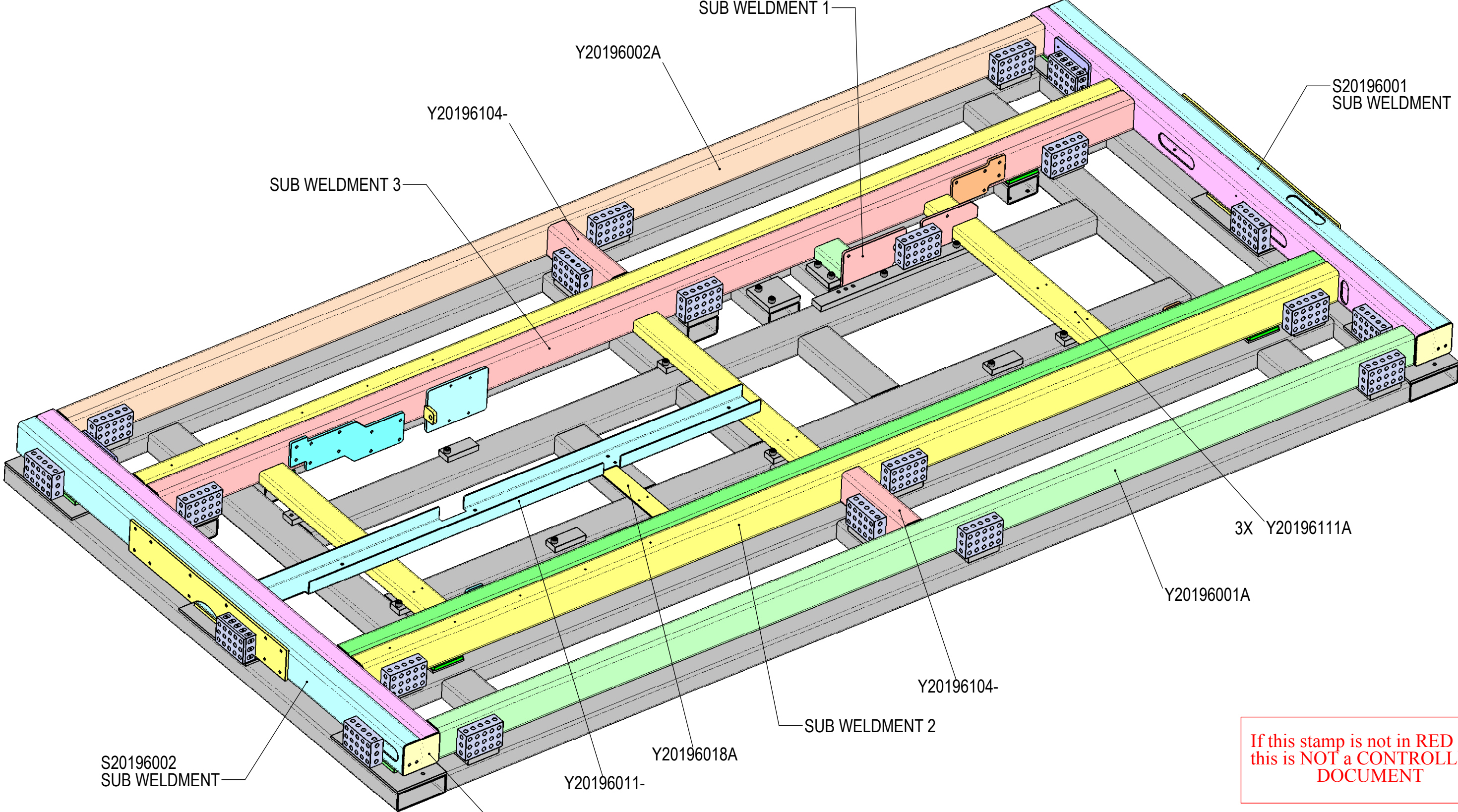
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FINAL WELDING

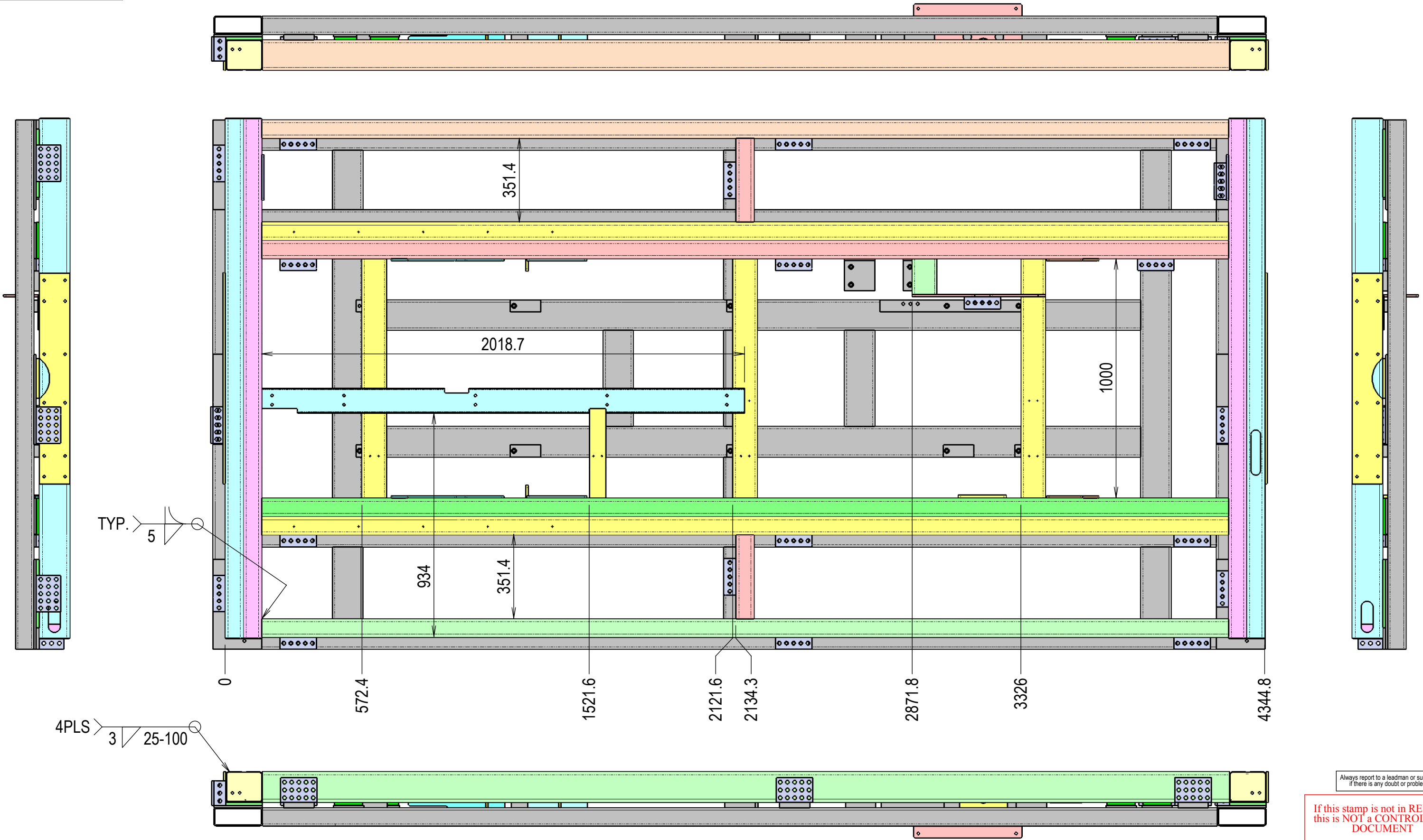


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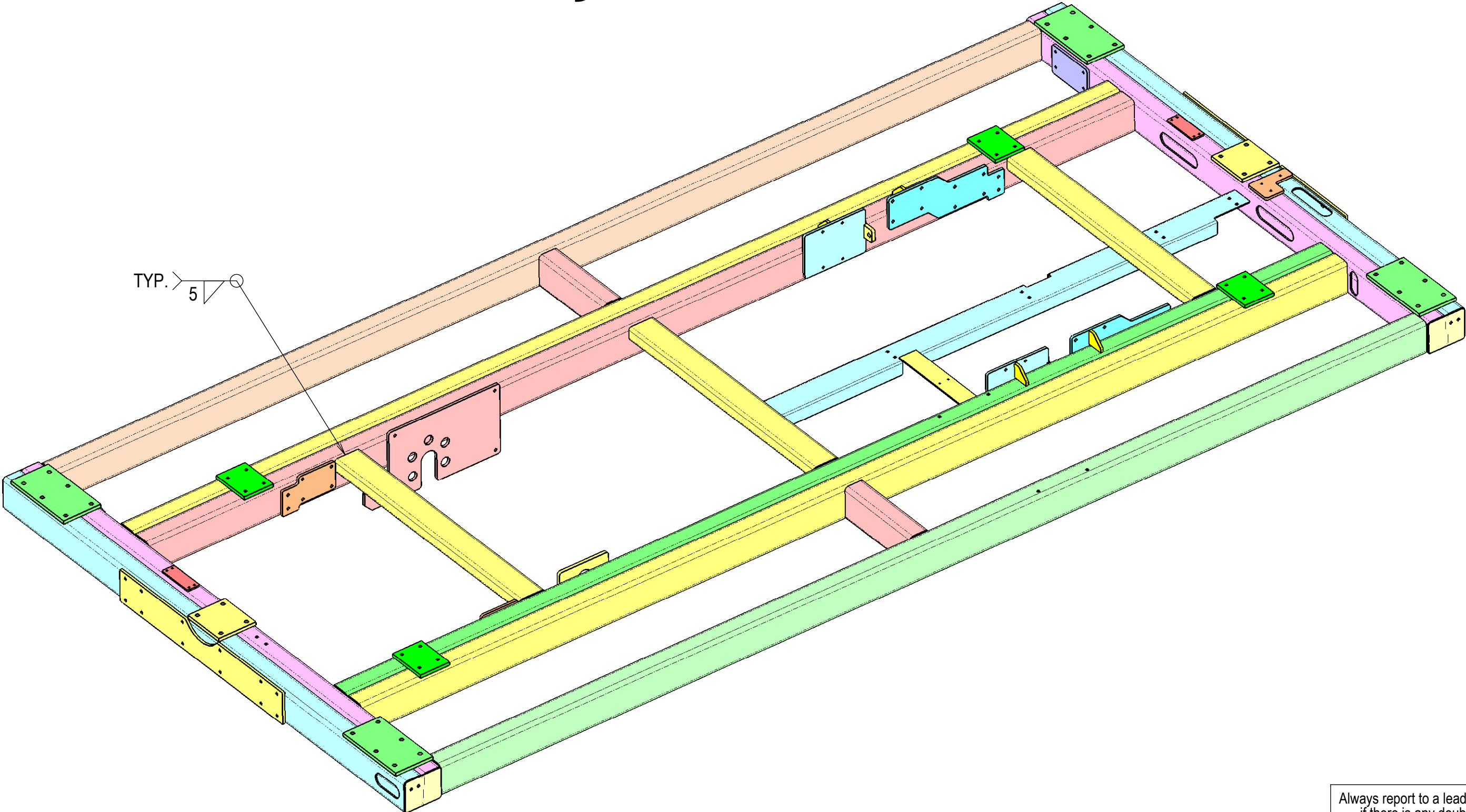
Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
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FINAL WELDING



Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
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FLIP THE WELDMENT TO FINISH WELDINGS AT BOTTOM ↗



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