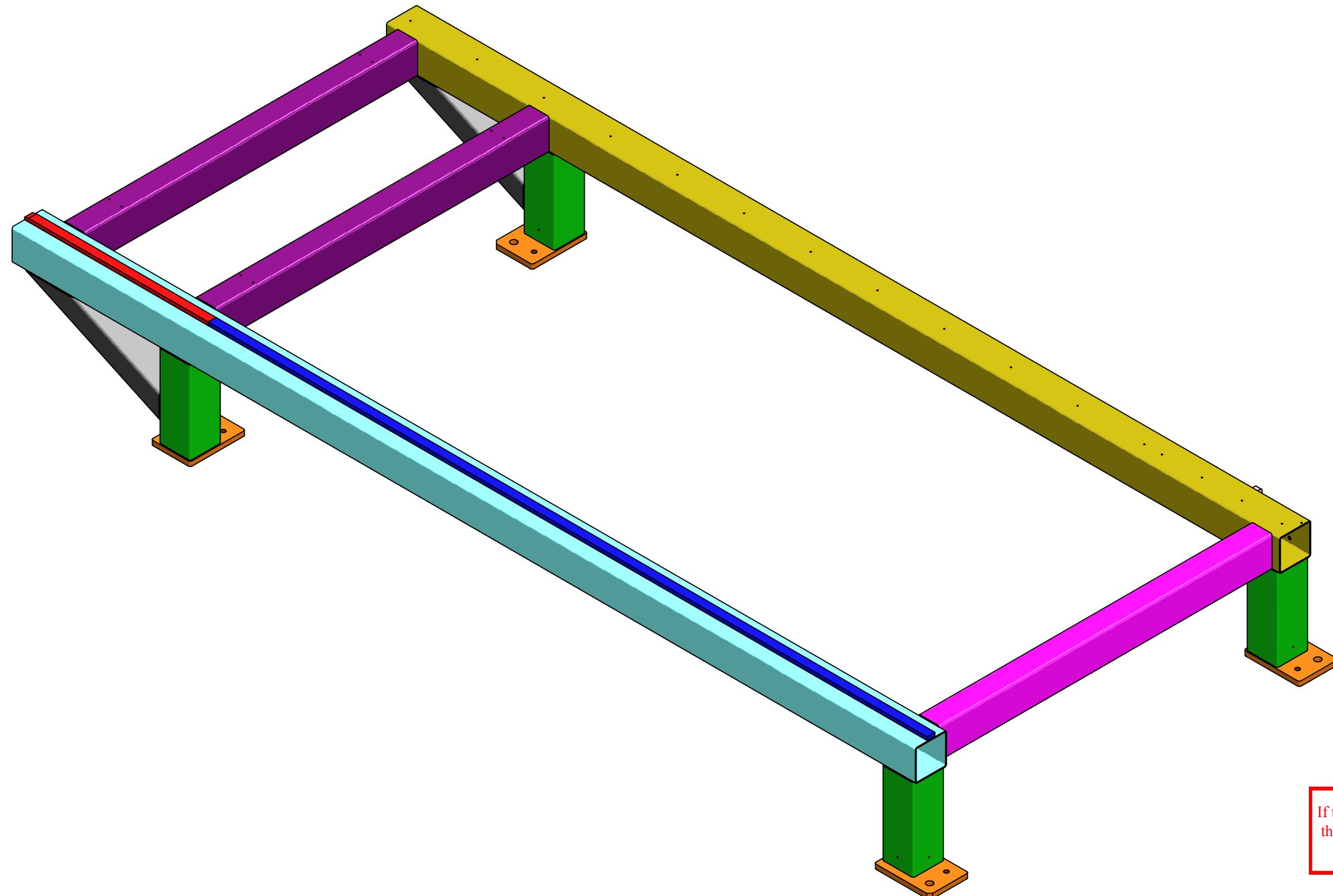
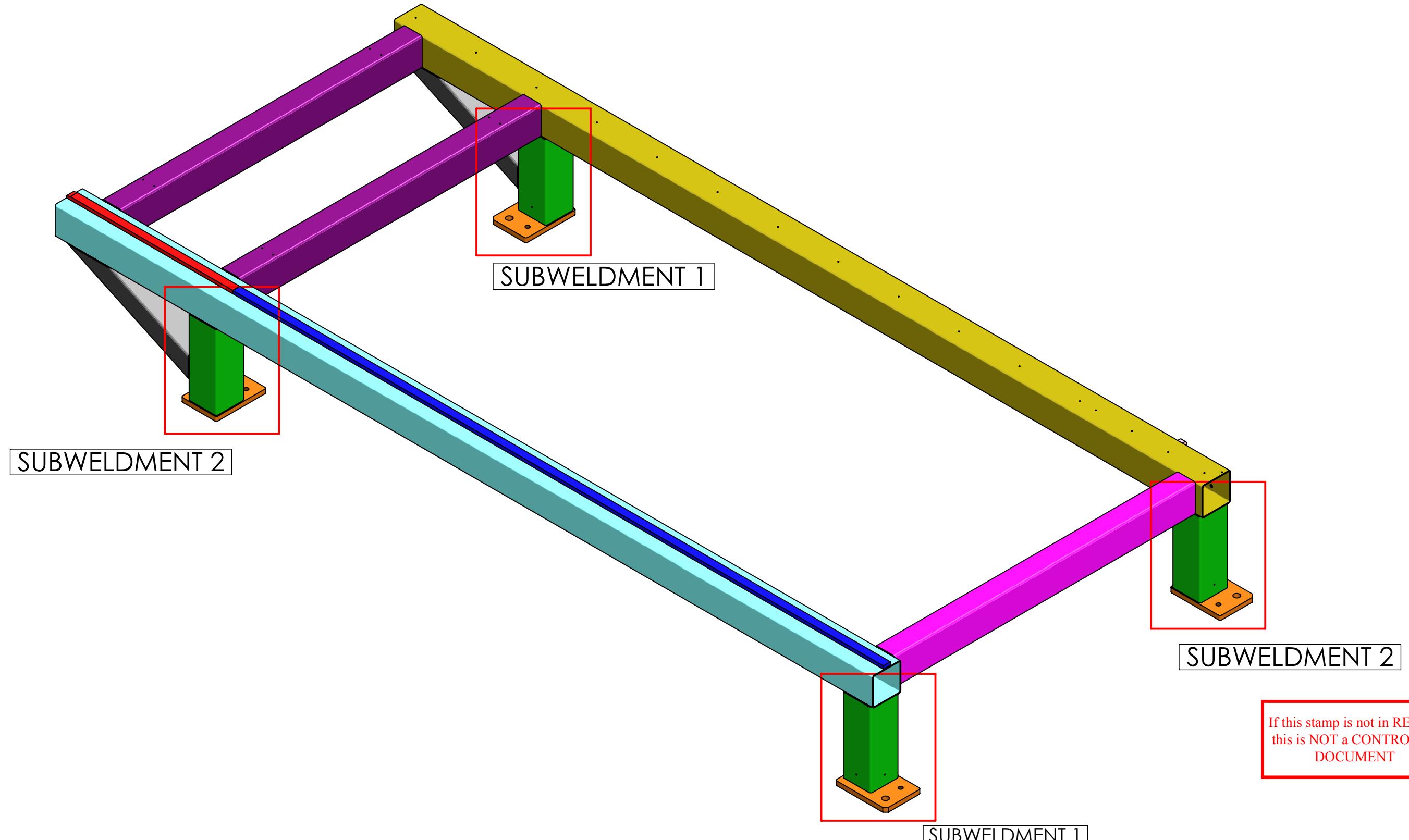


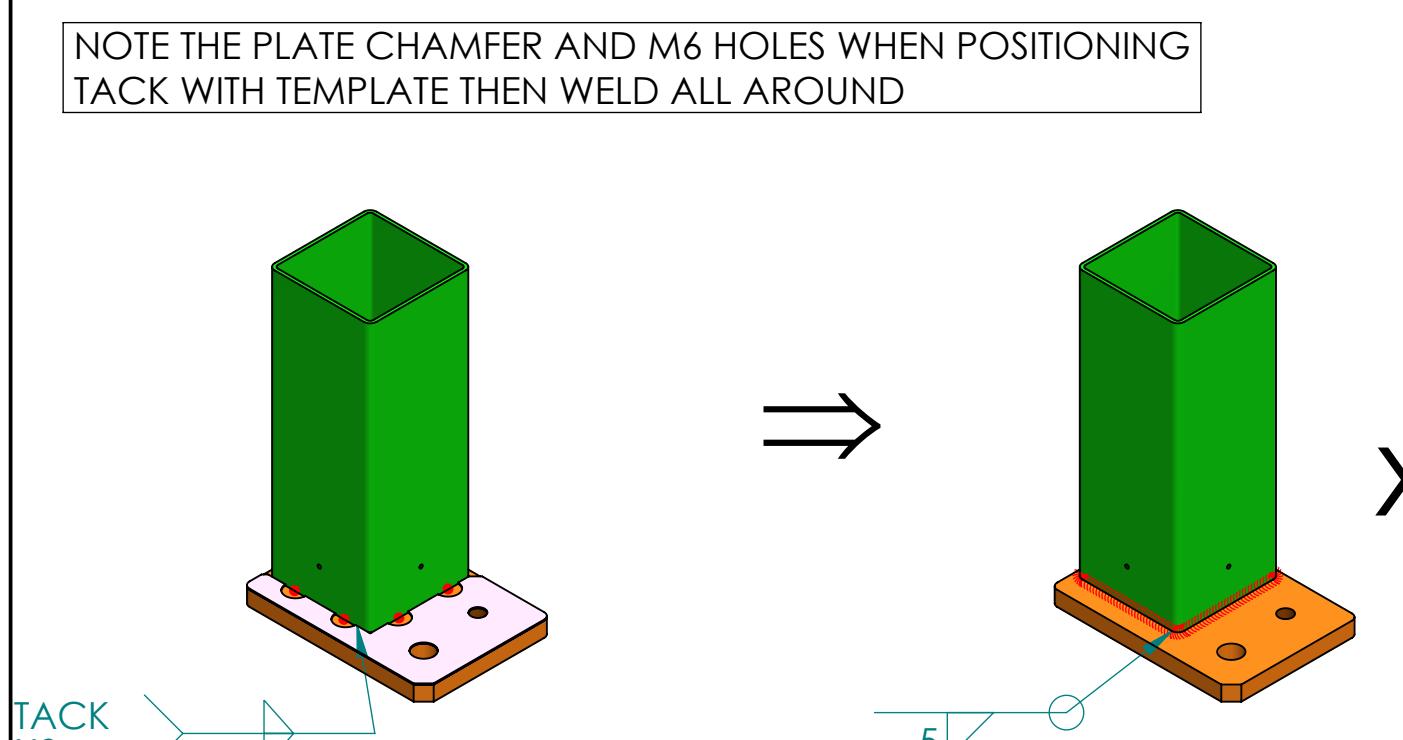
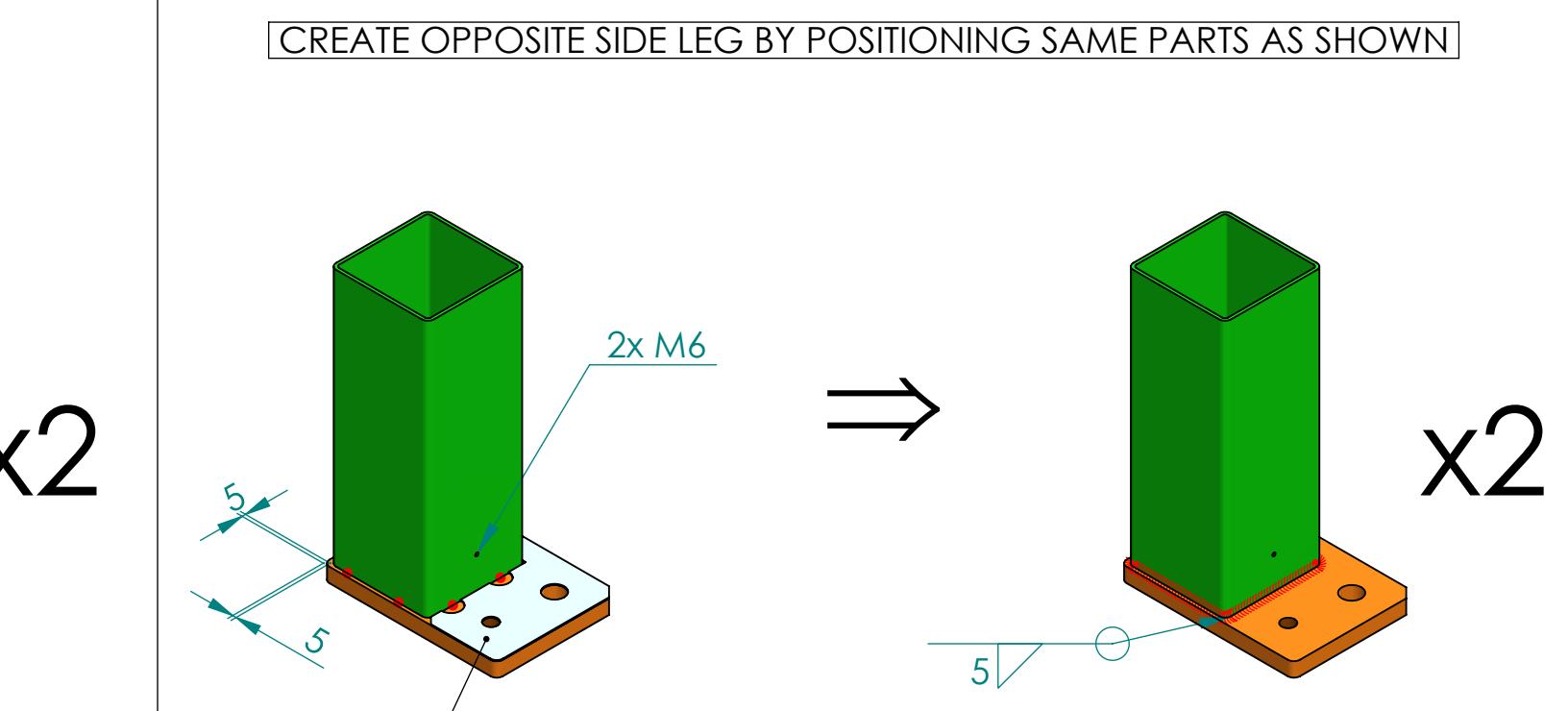
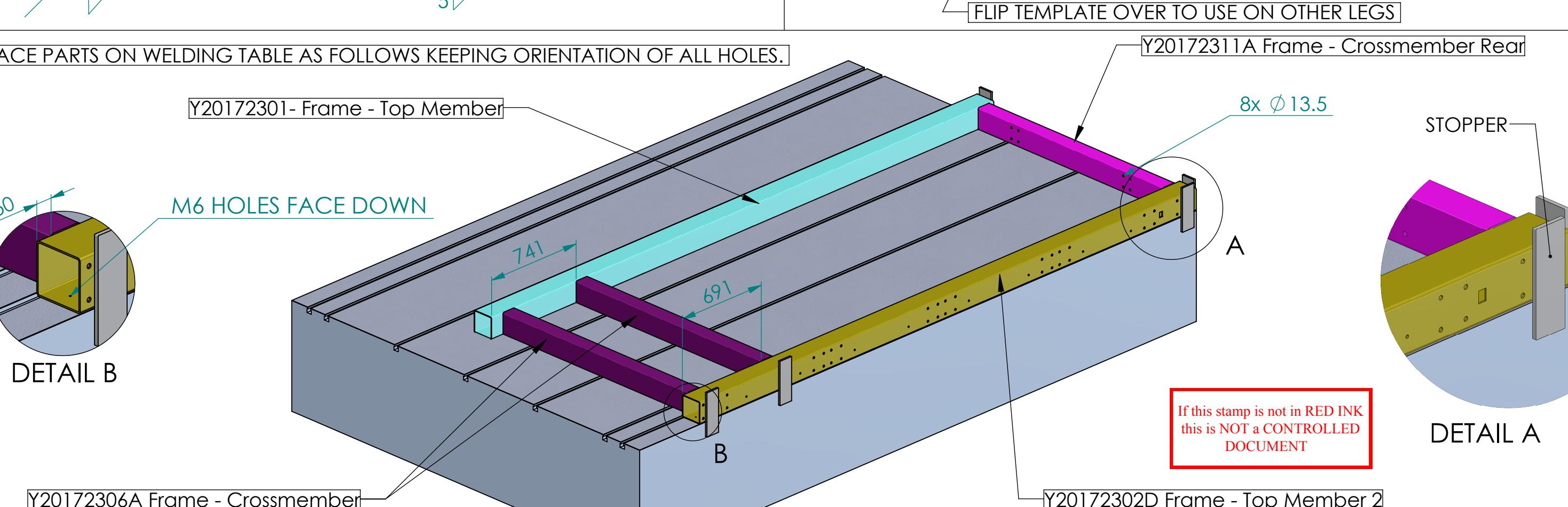
METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY JD	APPROVED BY CRM	COVER
PROCESS INSTRUCTIONS	ROS	ROS Frame Weldment	Y201723--D	A01	3/7/2019			

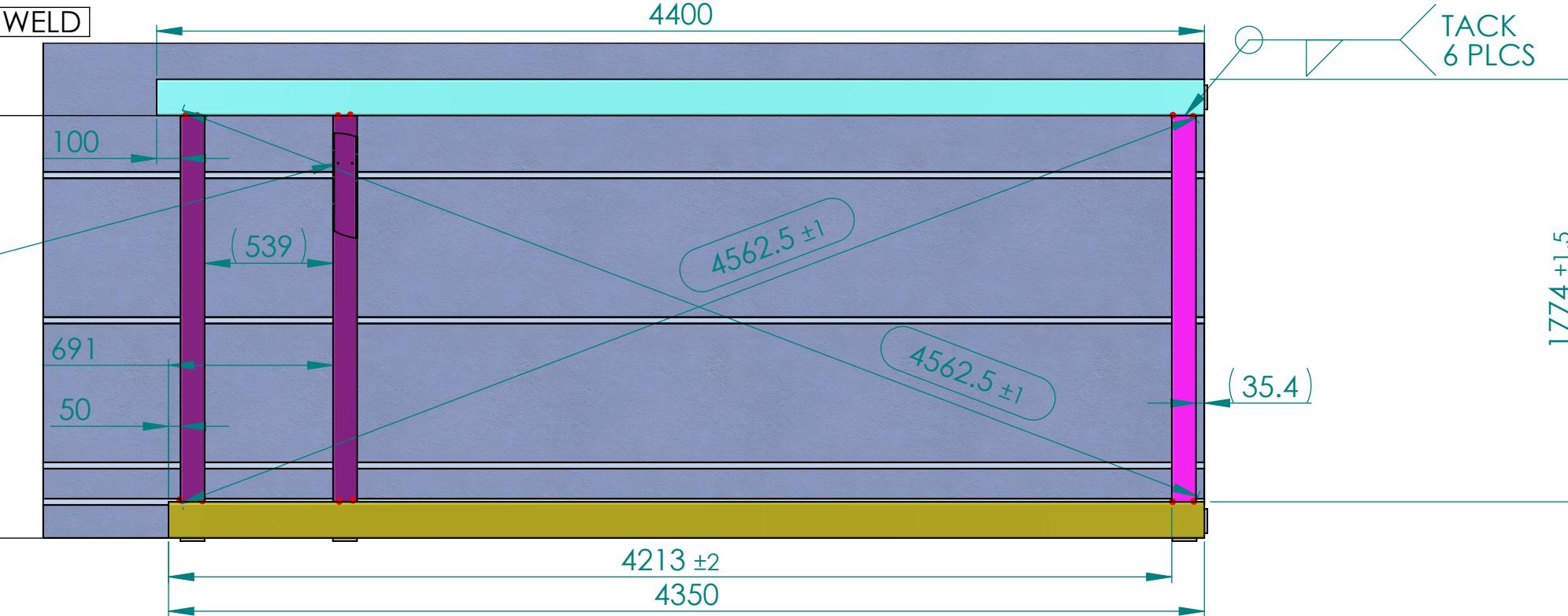
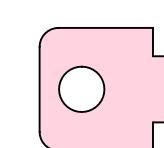
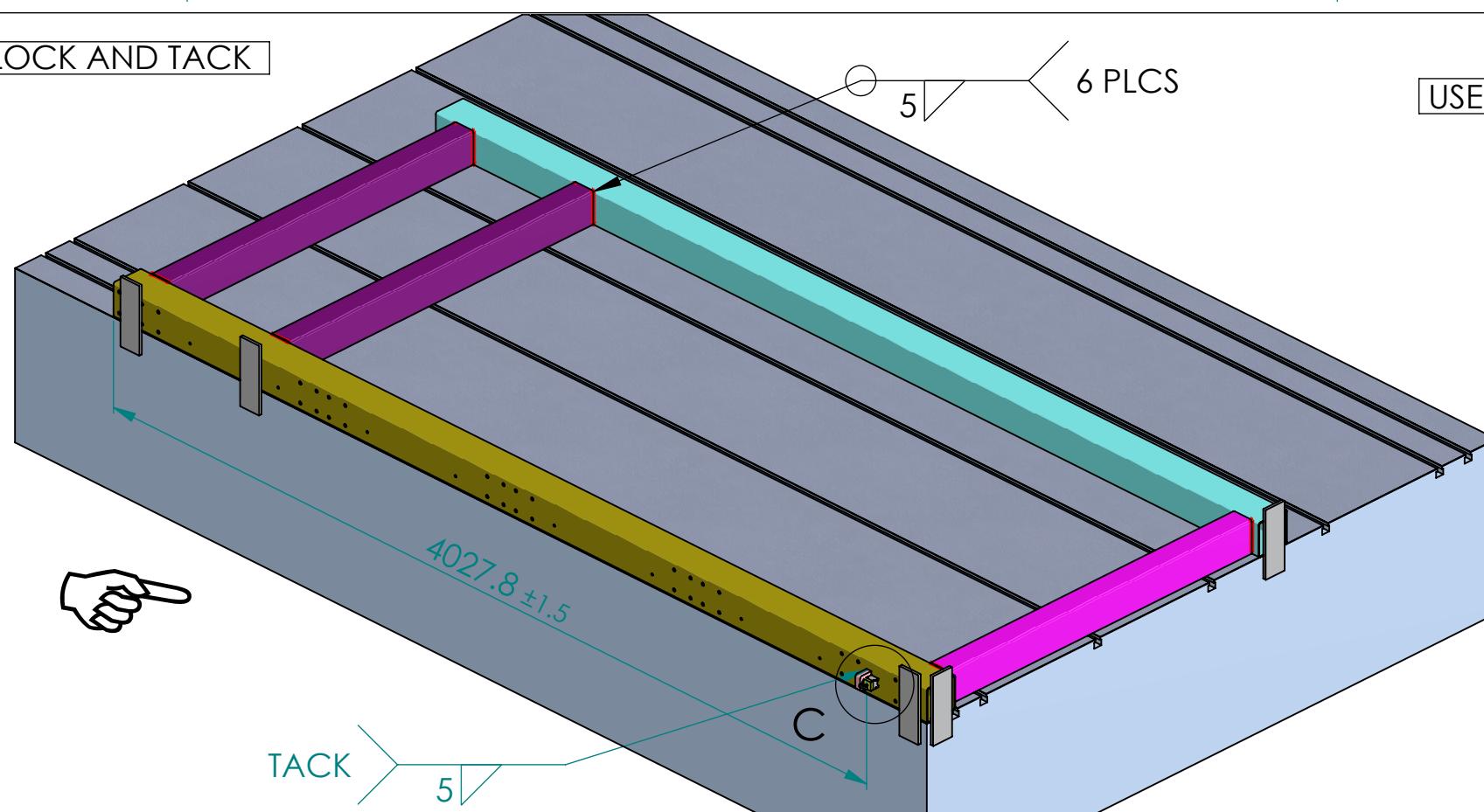
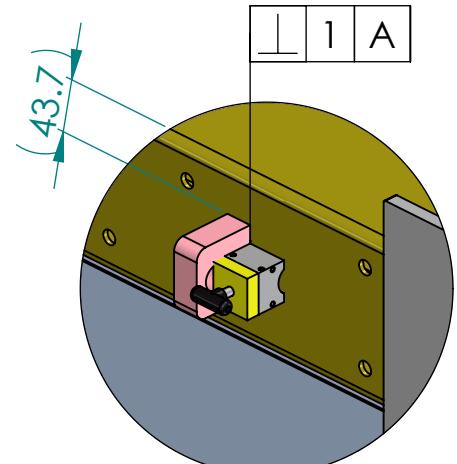


If this stamp is not in RED INK
this is NOT a CONTROLLED
DOCUMENT

METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY JD	APPROVED BY CRM	PAGE 1/6
PROCESS INSTRUCTIONS	AMS3105 ROS	ROS Frame Weldment	Y201723--D	A01	3/7/2019			



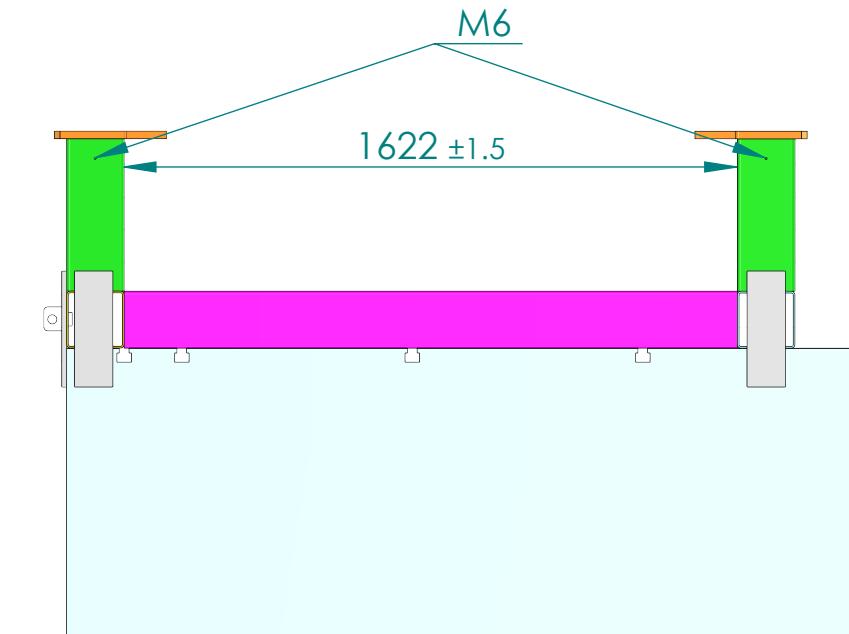
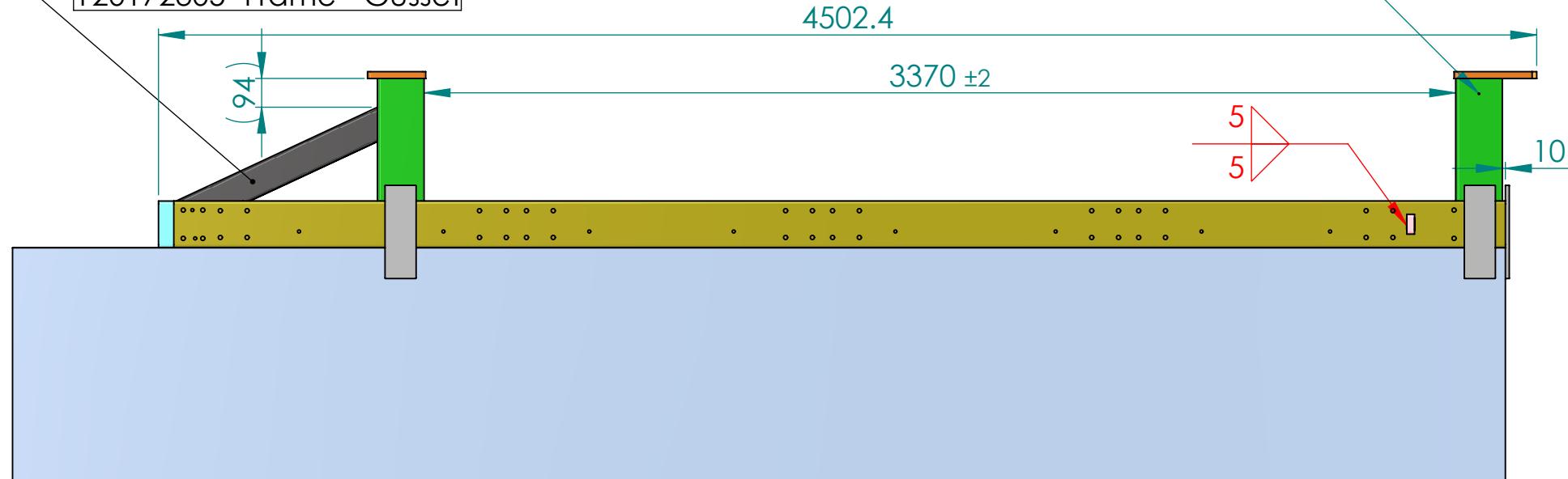
METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY JD	APPROVED BY CRM	PAGE 2/6
PROCESS INSTRUCTIONS	AMS3015 ROS	ROS Frame Weldment	Y201723--D	A01	3/7/2019			
NOTE THE PLATE CHAMFER AND M6 HOLES WHEN POSITIONING TACK WITH TEMPLATE THEN WELD ALL AROUND					CREATE OPPOSITE SIDE LEG BY POSITIONING SAME PARTS AS SHOWN			
								
PLACE PARTS ON WELDING TABLE AS FOLLOWS KEEPING ORIENTATION OF ALL HOLES.								

METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY JD	APPROVED BY CRM	PAGE 3/6	
PROCESS INSTRUCTIONS	AMS3015 ROS	ROS Frame Weldment	Y201723--D	A01	3/7/2019				
COINFIRM SQUARENESS BEFORE FINAL WELD									
// 2 A									
TAPPED HOLES FACE DOWN (BOTH TUBES)									
 <p>4400</p> <p>100</p> <p>(539)</p> <p>691</p> <p>50</p> <p>4213 ±2</p> <p>4350</p> <p>4562.5 ±1</p> <p>4562.5 ±1</p> <p>(35.4)</p> <p>1774 ±1.5</p> <p>TACK 6 PLCS</p> <p>A</p>									
PERFORM FINAL WELD ADD TENSION BLOCK AND TACK									
 <p>Y20172309A Tension Block</p>		 <p>4027.8 ±1.5</p> <p>C</p> <p>TACK 5 PLCS</p>				<p>USE C TO HOLD TENSION PLATE SQUARE</p>  <p>43.7</p> <p>C</p> <p>DETAIL C</p>			
<p>If this stamp is not in RED INK this is NOT a CONTROLLED DOCUMENT</p>									

METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY JD	APPROVED BY CRM	PAGE 4/6
PROCESS INSTRUCTIONS	AMS3015 ROS	ROS Frame Weldment	Y201723--D	A01	3/7/2019			

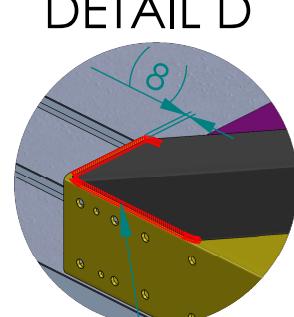
POSITION EARLIER SUBWELDMENTS AS SHOWN ADDING GUSSET SUPPORTS
 POSITION LEGS ENSURING TAPPED HOLES FACE CORRECT ORIENTATION
 FINISH WELDING TENSION BLOCK

Y20172305- Frame - Gusset

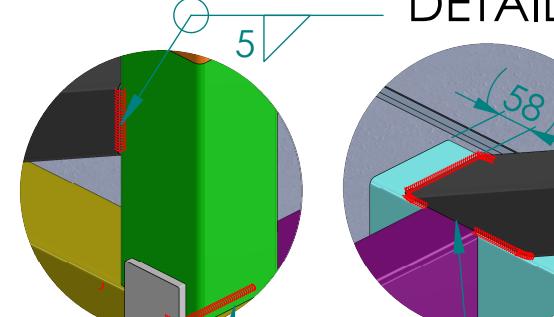


FLUSH LEGS WITH LONG TUBES UNLESS OTHERWISE NOTED. WELD

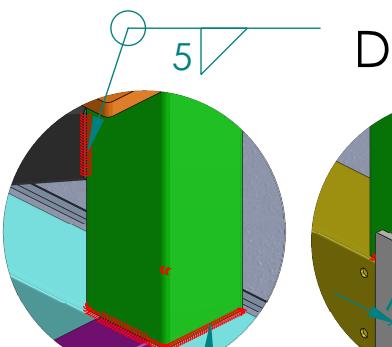
DETAIL D



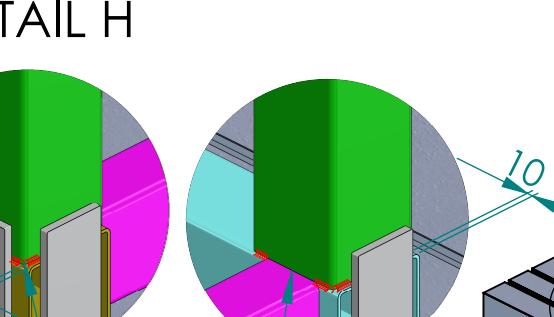
DETAIL F



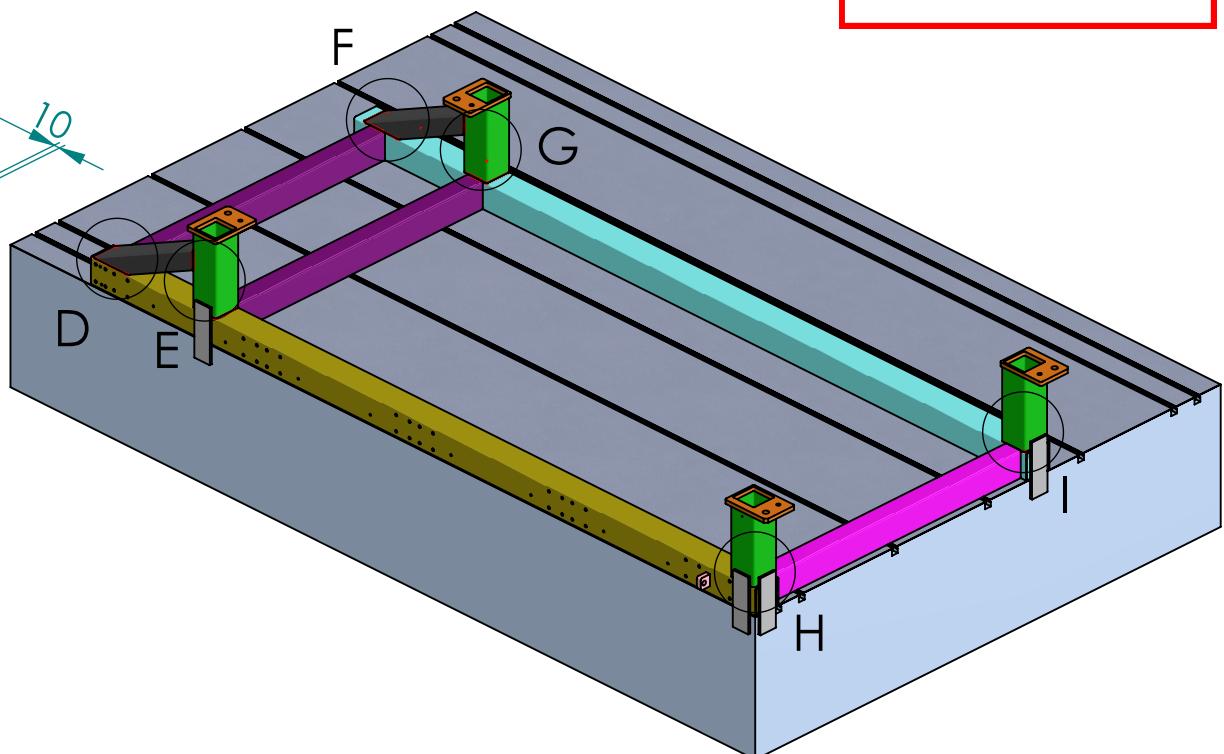
DETAIL H



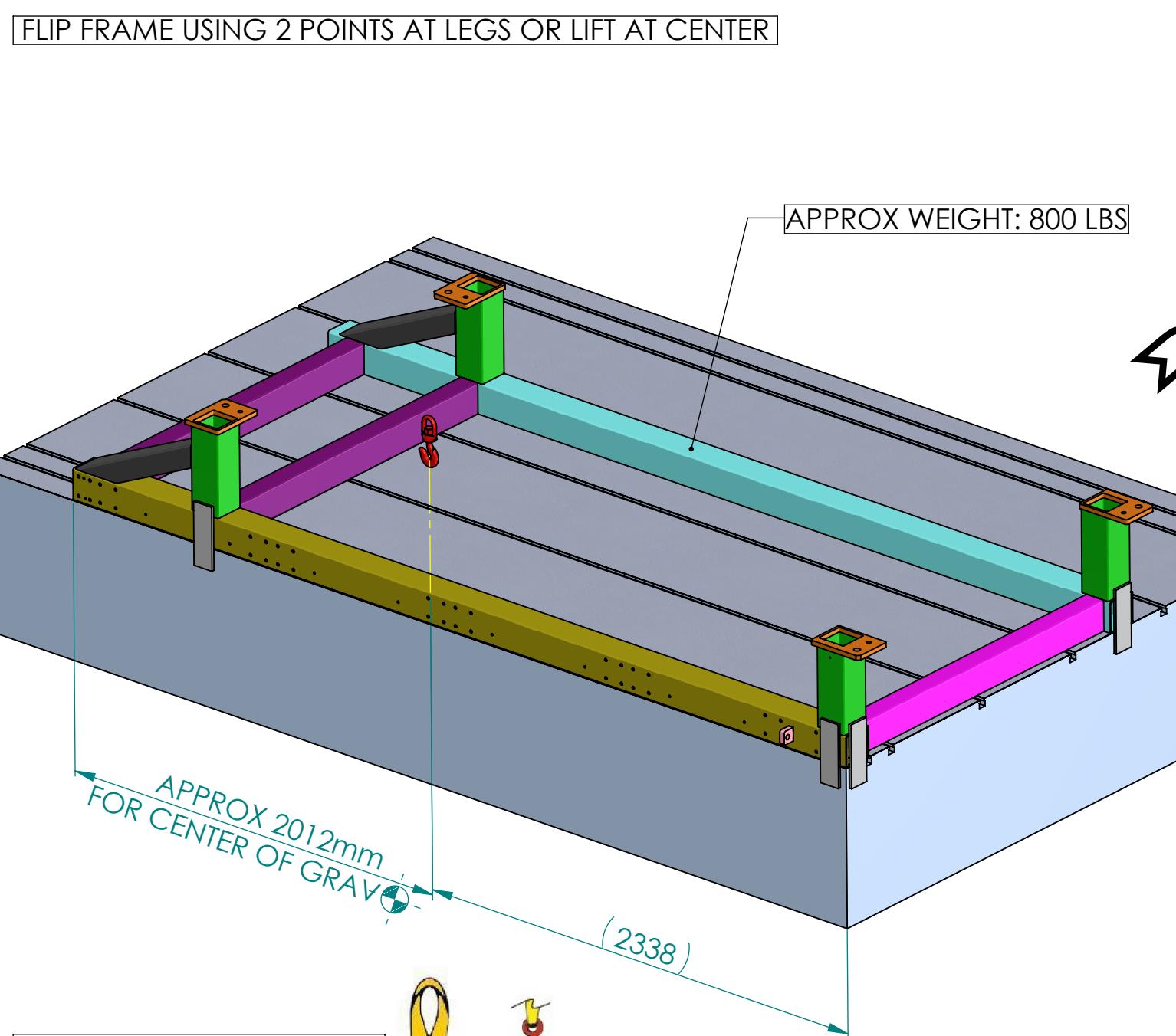
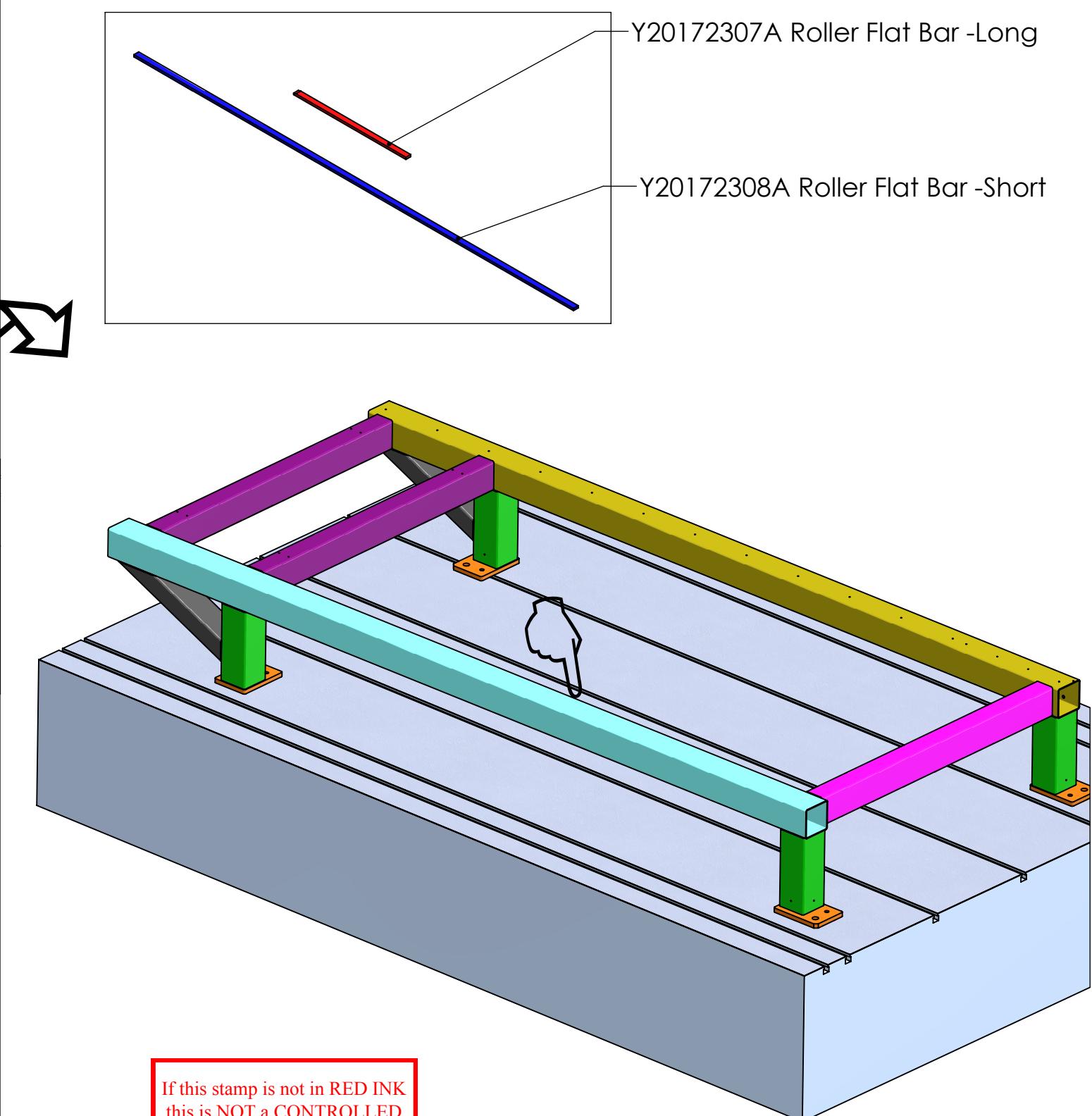
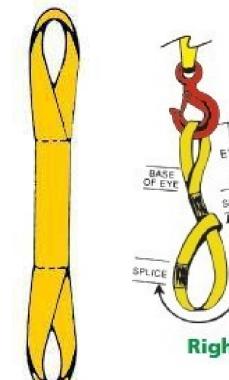
DETAIL E



DETAIL G

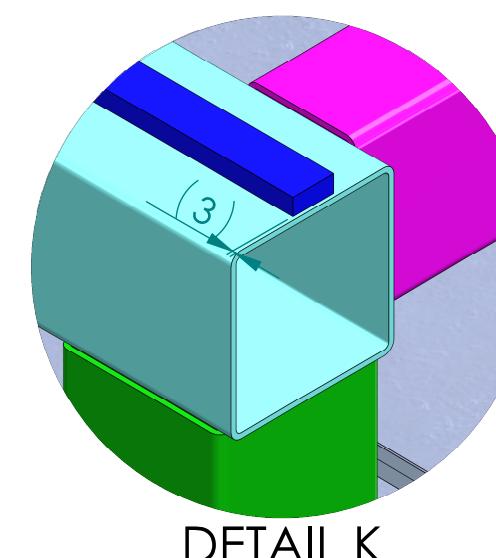
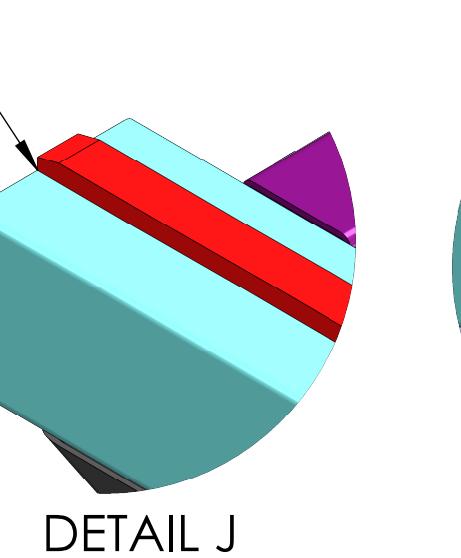
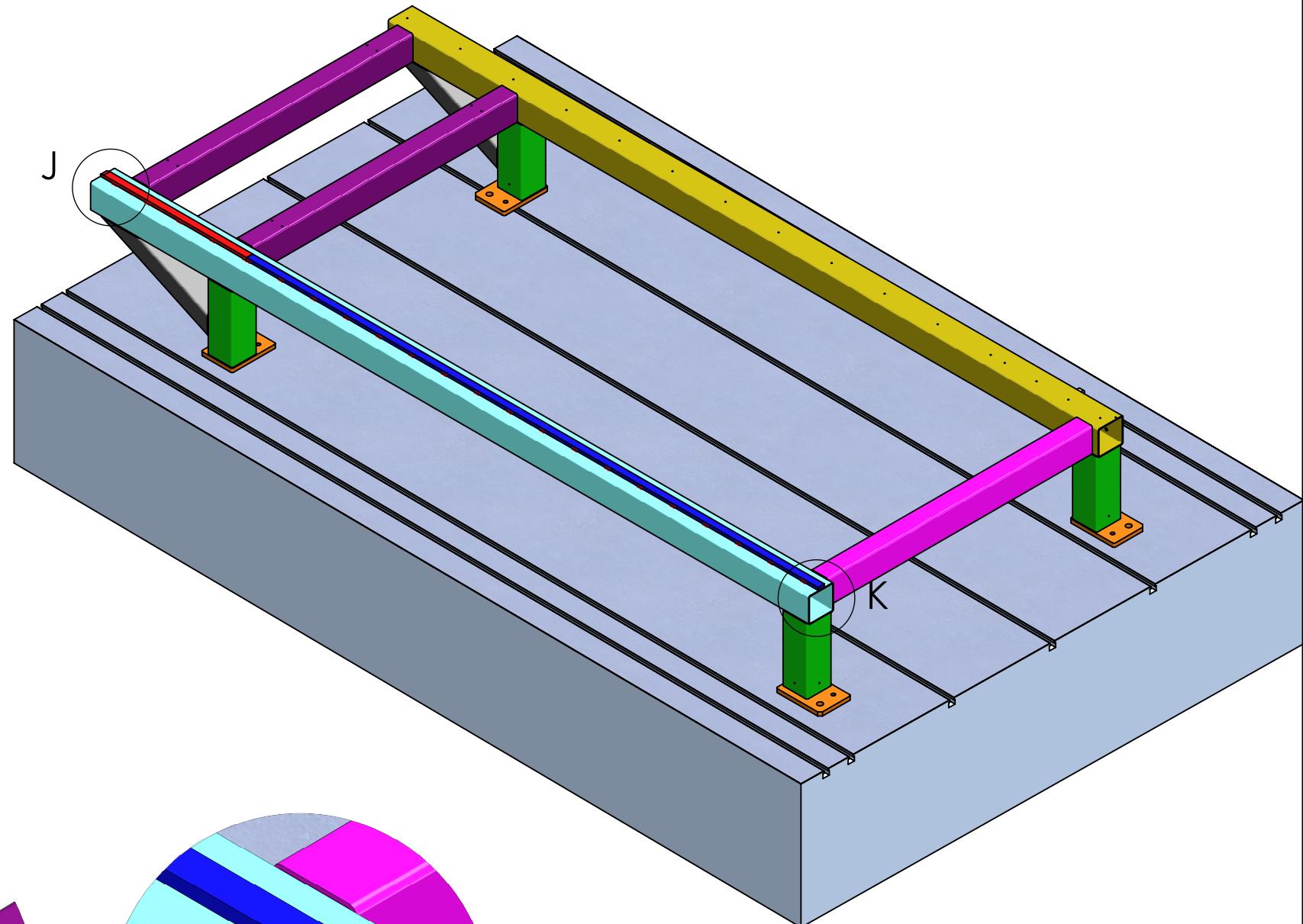
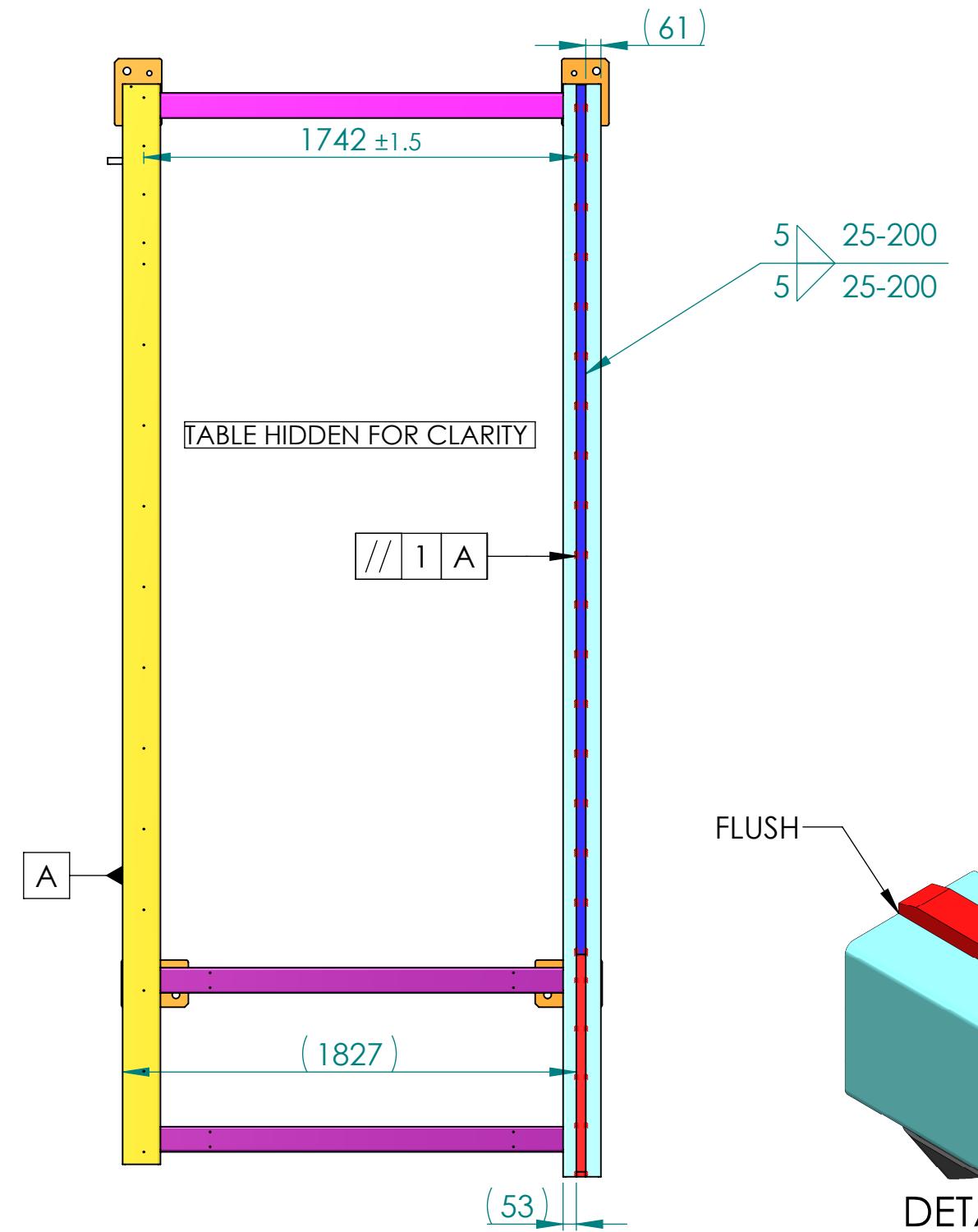


If this stamp is not in RED INK
 this is NOT a CONTROLLED
 DOCUMENT

METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY JD	APPROVED BY CRM	PAGE 5/6	
PROCESS INSTRUCTIONS	AMS3015 ROS	ROS Frame Weldment	Y201723--D	A01	3/7/2019				
FLIP FRAME USING 2 POINTS AT LEGS OR LIFT AT CENTER									
									
SUGGESTED EQUIPMENT: -SYNTHETIC WEB SLING 4" WIDTH -CHOKER METHOD			<div style="border: 2px solid red; padding: 5px; text-align: center;"> If this stamp is not in RED INK this is NOT a CONTROLLED DOCUMENT </div>						

METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY JD	APPROVED BY CRM	PAGE 6/6
PROCESS INSTRUCTIONS	AMS3015 ROS	ROS Frame Weldment	Y201723--D	A01	3/7/2019			

POSITION FLAT BARS AS SHOWN WITH CHAMFER ON GUSSET SIDE
STITCH WELD ENTIRE LENGTH



If this stamp is not in RED INK
this is NOT a CONTROLLED
DOCUMENT