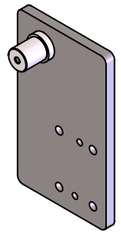
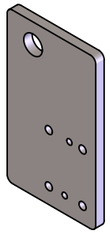
METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY	PAGE
PROCESS INSTRUCTIONS	ROS	Idler Plate Weldment	Y201724--B	OI	3/8/2019	JD APPROVED BY CRM	1 OF 2

MACH	ROS			MACH	ROS			MACH	ROS			MACH				MACH				MACH				MACH			
BOM	DRIVE UNIT			BOM	DRIVE UNIT			BOM	DRIVE UNIT			BOM				BOM				BOM				BOM			
MAIN PART	Idler Plate Weldment			MAIN PART	IDLER BRACKET 2			MAIN PART	IDLER SHAFT			MAIN PART				MAIN PART				MAIN PART				MAIN PART			
SUB PART				SUB PART				SUB PART				SUB PART				SUB PART				SUB PART				SUB PART			
DWG NO	Y201724--B	QTY	1 /M	DWG NO	Y20172401B	QTY	1 /M	DWG NO	Y20172402A	QTY	1 /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	**BLACK PRIMER**			PAINT				PAINT				PAINT				PAINT				PAINT				PAINT			
TIME				TIME				TIME				TIME				TIME				TIME				TIME			
PART FLOW	HW→P			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			

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			

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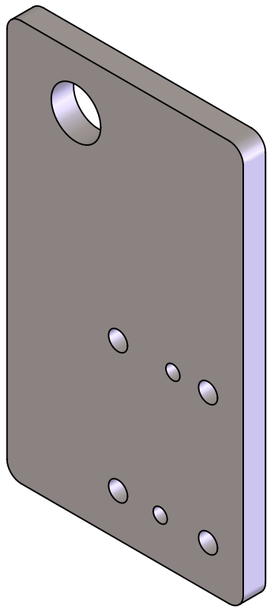
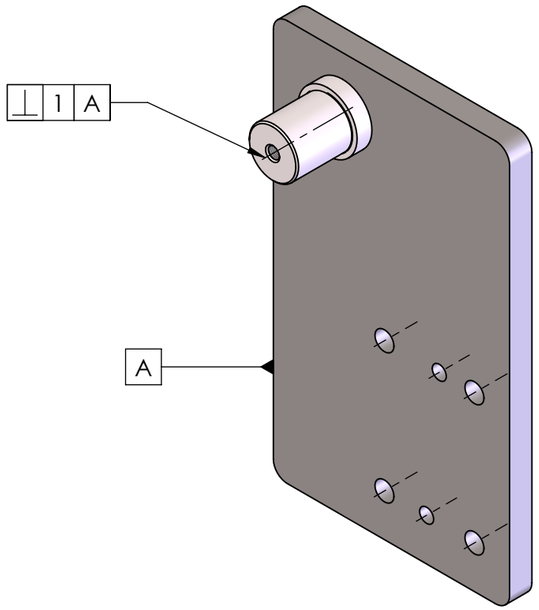
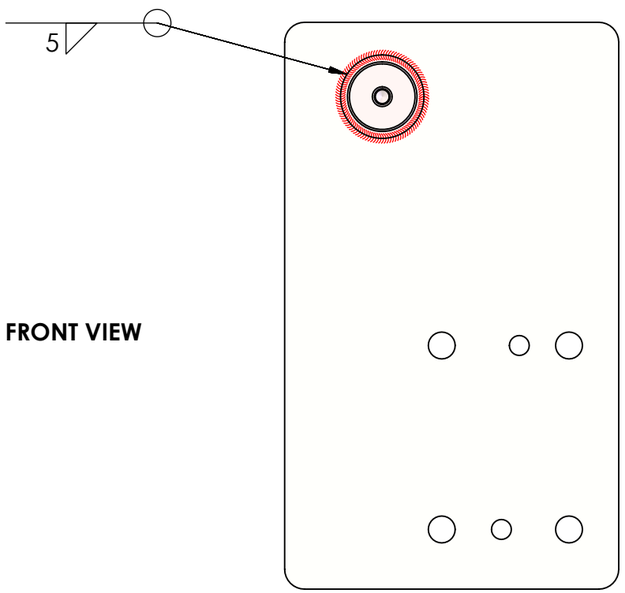
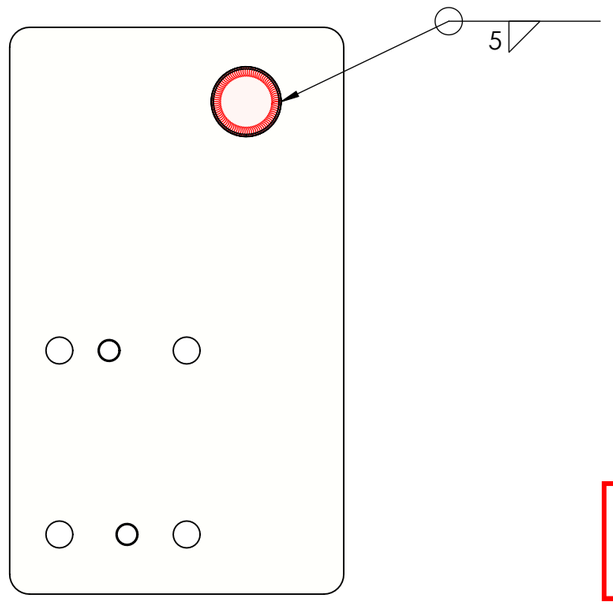
PROCESS INSTRUCTIONS	ROS	Idler Plate Weldment	Y201724--B	OI	3/8/2019	JD APPROVED BY CRM	2 OF 2







FRONT VIEW



BACK VIEW

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