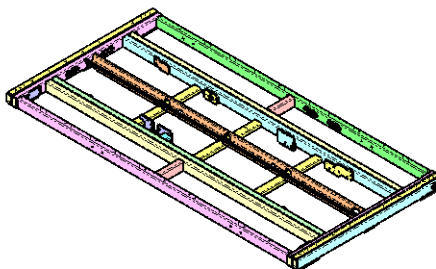
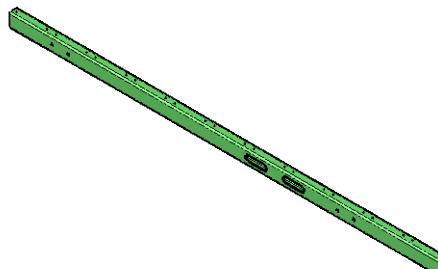
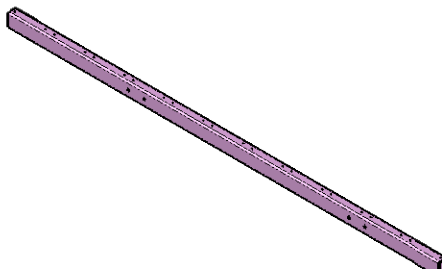
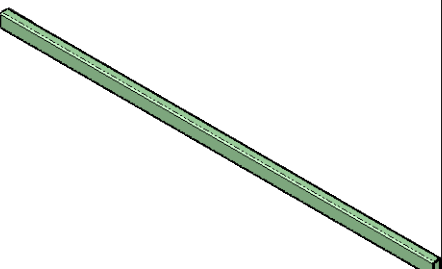
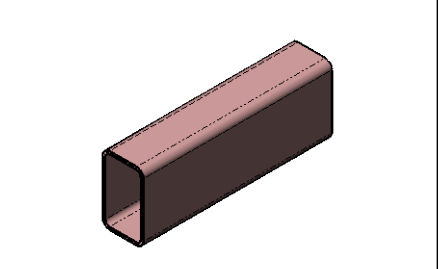
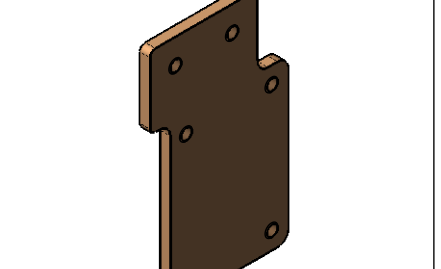
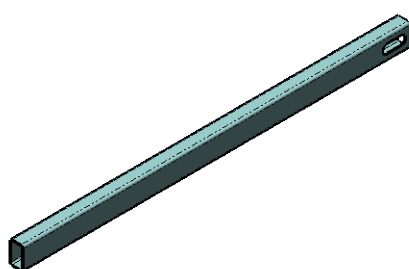
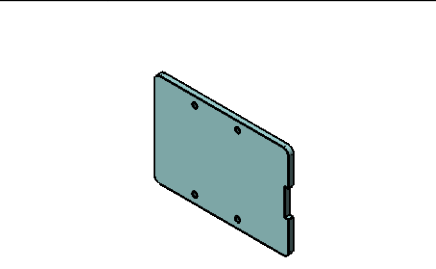
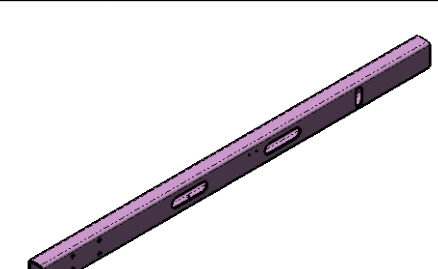
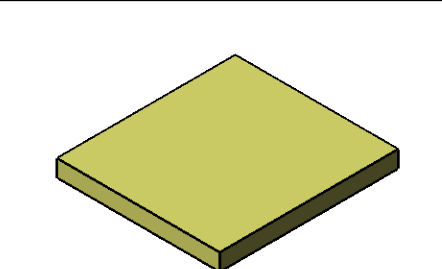
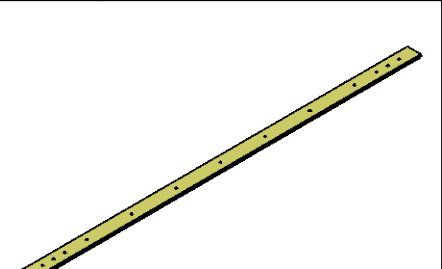
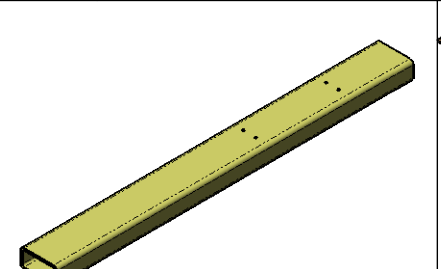
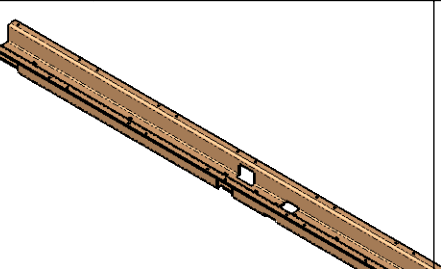
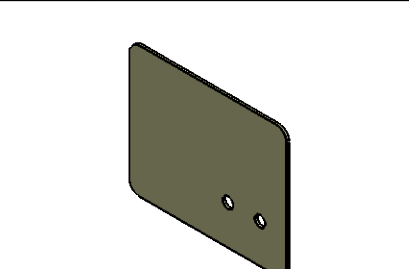
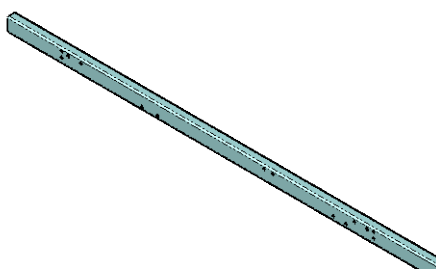
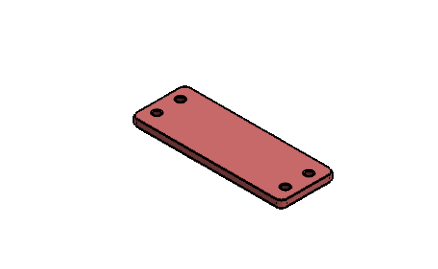
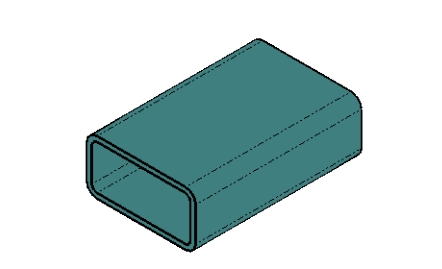
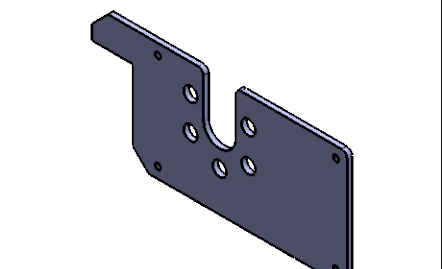
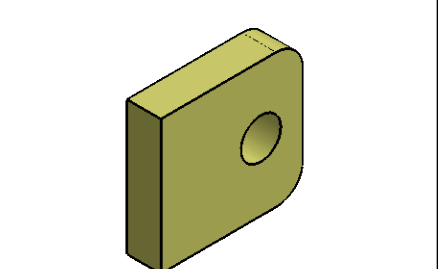
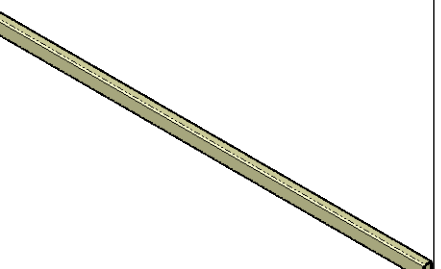
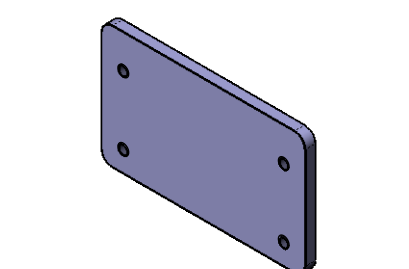


Metal Fabrication				Machine Model				Process Inst Name				Process Inst NO.				REV.		DATE		PREPARED BY: Leon Jiang				PAGE									
Process Instruction				AMS4020CL				SUCTION TRAV FRAME				HW-Y201961--A				OI		07/31/19		APPROVED BY: Caesar M				1/11									
MACH				MACH				MACH				MACH				MACH				MACH													
BOM				BOM				BOM				BOM				BOM				BOM													
Main Part	ST FRAME WELDMENT			Main Part	LONG TUBE			Main Part	LONG TUBE 2			Main Part	DRIVE TUBE			Main Part	RIB TUBE			Main Part	SPROCKET PLATE			Main Part	SIDE TUBE								
Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part									
DWG NO	Y201961--A	QTY	1 /M	DWG NO	Y20196101A	QTY	1 /M	DWG NO	Y20196102A	QTY	1 /M	DWG NO	Y20196103A	QTY	1 /M	DWG NO	Y20196104-	QTY	2 /M	DWG NO	Y20196105-	QTY	2 /M	DWG NO	Y20196106A	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				Length					
Paint	RT			Paint				Paint				Paint				Paint				Paint				Paint				Paint			Paint		
Time				Time				Time				Time				Time				Time				Time				Time			Time		
Part Flow				Part Flow	RI=>T			Part Flow	RI=>T			Part Flow	RI=>T			Part Flow	OUT			Part Flow	BL-LC=>PF			Part Flow	BL-LC=>T								
																																	
MACH				MACH				MACH				MACH				MACH				MACH				MACH									
BOM				BOM				BOM				BOM				BOM				BOM				BOM									
Main Part	TENSION BRACKET MOUNT PLATE			Main Part	LONG RIB TUBE			Main Part	WHEEL MOUNT BLOCK			Main Part	TOP PLATE			Main Part	CENTER TUBE 1			Main Part	ST CABLE TROUGH			Main Part	LARGE TUBE CAP								
Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part									
DWG NO	Y20196107-	QTY	2 /M	DWG NO	Y20196108A	QTY	2 /M	DWG NO	Y20196109-	QTY	2 /M	DWG NO	Y20196110A	QTY	2 /M	DWG NO	Y20196111A	QTY	3 /M	DWG NO	Y20196112A	QTY	2 /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				Length					
Paint				Paint				Paint				Paint				Paint				Paint				Paint				Paint			Paint		
Time				Time				Time				Time				Time				Time				Time				Time			Time		
Part Flow	BL-LC=>T			Part Flow	RI=>T			Part Flow	BL-LC			Part Flow	OUT			Part Flow	RI=>T			Part Flow	BL-LC=>T=>B			Part Flow	BL-LC								
																																	
MACH				MACH				MACH				MACH				MACH				MACH				MACH									
BOM				BOM				BOM				BOM				BOM				BOM				BOM									
Main Part	IDLER TUBE			Main Part	TENSIONER BRACKET			Main Part	MOTOR SUPPORT TUBE			Main Part	MOTOR MOUNT PLATE			Main Part	TENSION TAB			Main Part	LONG TUBE 3			Main Part	FB MOTOR MOUNT PLATE								
Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part									
DWG NO	Y20196114A	QTY	1 /M	DWG NO	Y20196115-	QTY	2 /M	DWG NO	Y20196116-	QTY	1 /M	DWG NO	Y20196117A	QTY	1 /M	DWG NO	Y20196118-	QTY	2 /M	DWG NO	Y20196119-	QTY	2 /M	DWG NO	Y20196121-	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				Length					
Paint				Paint				Paint				Paint				Paint				Paint				Paint				Paint			Paint		
Time				Time				Time				Time				Time				Time				Time				Time			Time		
Part Flow	RI=>T			Part Flow	BL-LC=>T			Part Flow	OUT			Part Flow	BL-LC=>PF			Part Flow	BL-LC			Part Flow	RI=>T			Part Flow	BL-LC=>T								
																																	

Metal Fabrication

Machine Model

Process Inst Name

Process Inst NO.

REV.

DATE

PREPARED BY: Leon Jiang

PAGE

Process Instruction

AMS4020CL

SUCTION TRAV FRAME

HW-Y201961--A

OI

07/31/19

APPROVED BY: Caesar M

3/11

2X Y20196121-

1X Y20196116-

2X Y20196119-

3X Y20196111A

2X Y20196112A

2X Y20196110A

2X Y20196123-

2X Y20196115-

1X Y20196103A

2X Y20196107-

1X Y20196102A

1X Y20196117A

2X Y20196105-

2X Y20196106A

2X Y20196109-

2X Y20196106A

2X Y20196108A

4X Y20196126-

1X Y20196122-

2X Y20196104-

1X Y20196101A

4X Y20196124-

2X Y20196119-

1X Y20196114A

4X Y20196113A

1X Y20196125-

PART NO.	DWG.NO.	NAME(ENG)	QTY.
1	Y20196101A	LONG TUBE	1
2	Y20196102A	LONG TUBE 2	1
3	Y20196103A	DRIVE TUBE	1
4	Y20196104-	RIB TUBE	2
5	Y20196105-	SPROCKET PLATE	2
6	Y20196106A	SIDE TUBE	2
7	Y20196107-	TENSION BRACKET MOUNT PLATE	2
8	Y20196108A	LONG RIB TUBE	2
9	Y20196109-	WHEEL MOUNT BLOCK	2
10	Y20196110A	TOP PLATE	2
11	Y20196111A	CENTER TUBE 1	3
12	Y20196112A	ST CABLE TROUGH	2
13	Y20196113A	LARGE TUBE CAP	4
14	Y20196114A	IDLER TUBE	1
15	Y20196115-	TENSIONER BRACKET	2
16	Y20196116-	MOTOR SUPPORT TUBE	1
17	Y20196117A	MOTOR MOUNT PLATE	1
18	Y20196118-	TENSION TAB	2
19	Y20196119-	LONG TUBE 3	2
20	Y20196121-	FB MOTOR MOUNT PLATE	2
21	Y20196122-	PILLOW BLOCK PLATE	1
22	Y20196123-	DUAL SPROCKET PLATE	2
23	Y20196124-	BRACKET GUSSET	4
24	Y20196125-	E CHAIN SUPPORT PLATE	1
25	Y20196126-	EXT WHEEL MOUNT BLOCK	4

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

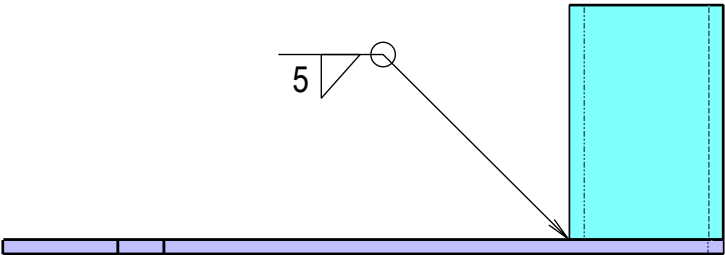
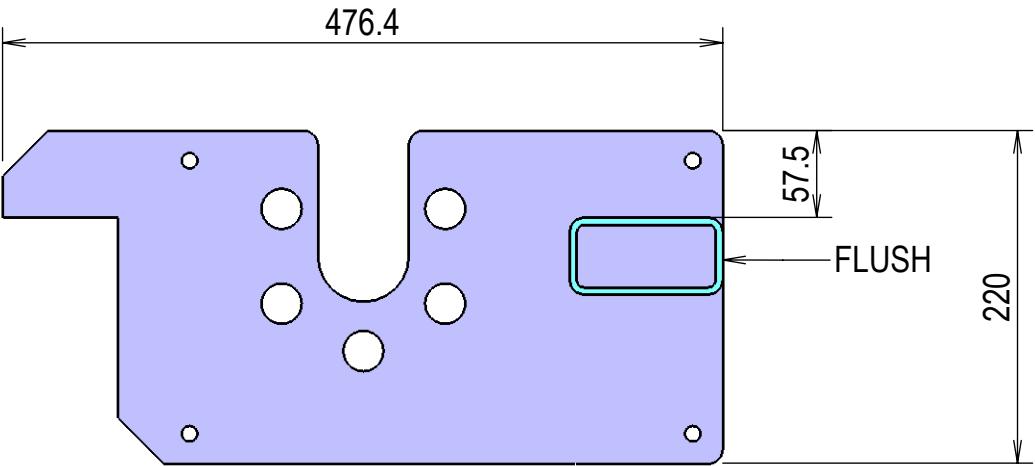
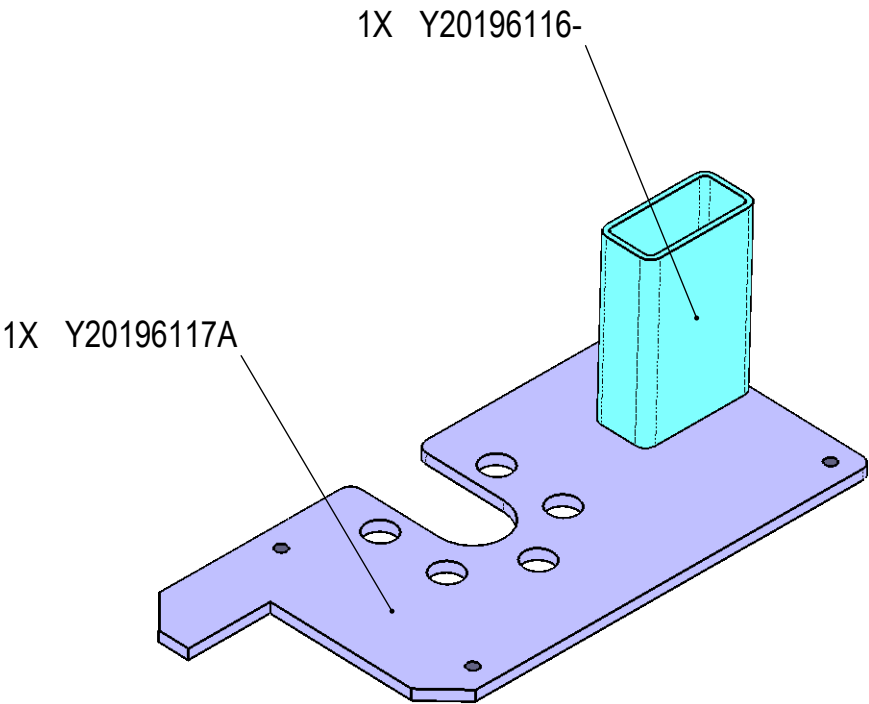
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DOCUMENT

F4.2-03-07 Rev OI

ISO-9001

Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	SUCTION TRAV FRAME	HW-Y201961--A	OI	07/31/19	APPROVED BY: Caesar M	4/11

SUB WELDMENT 1



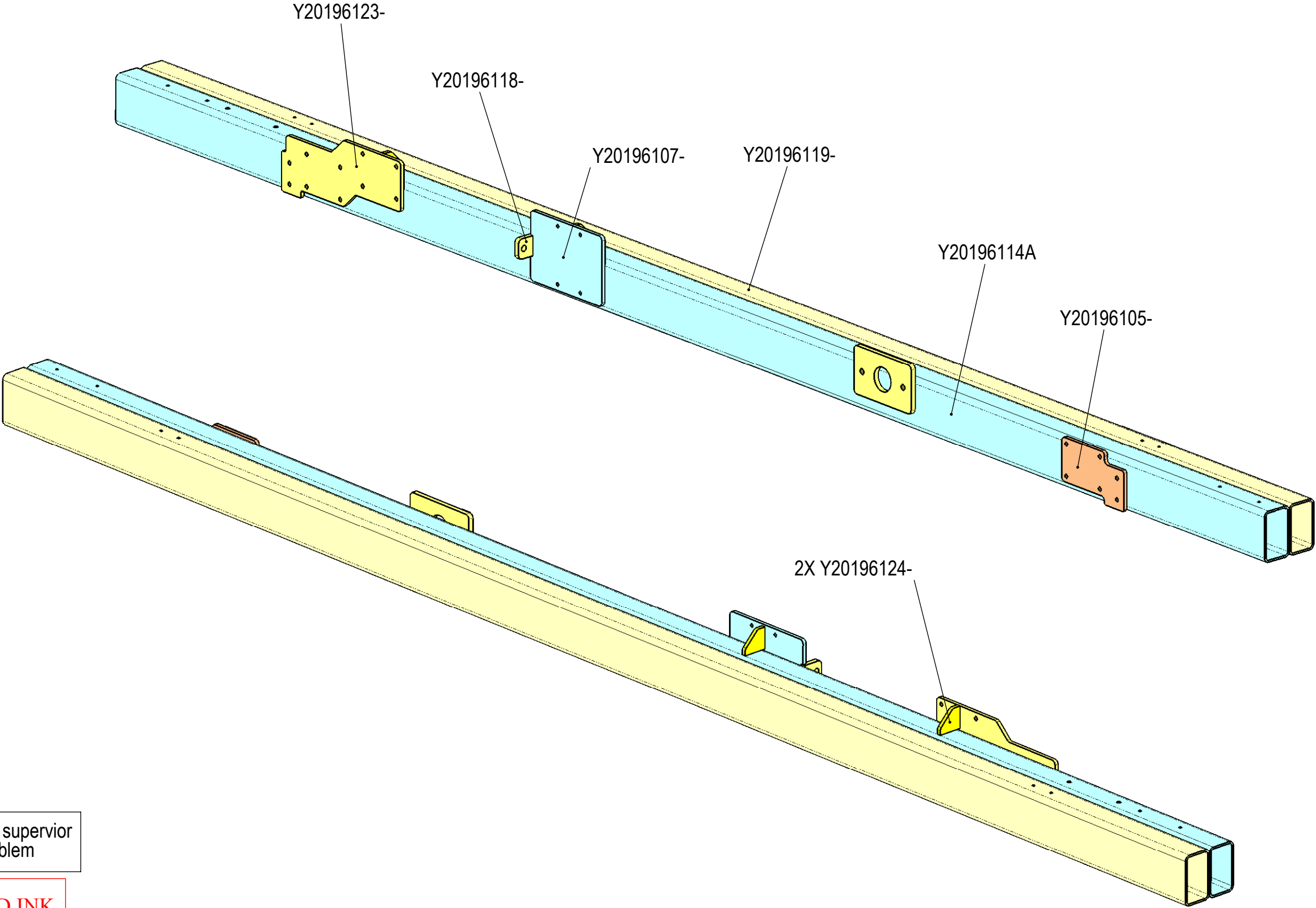
Always report to a leadman or supervisor
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DOCUMENT

NOTE: PRESS THE PLATE TO GET FLATNESS

Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
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SUB WELDMENT 2

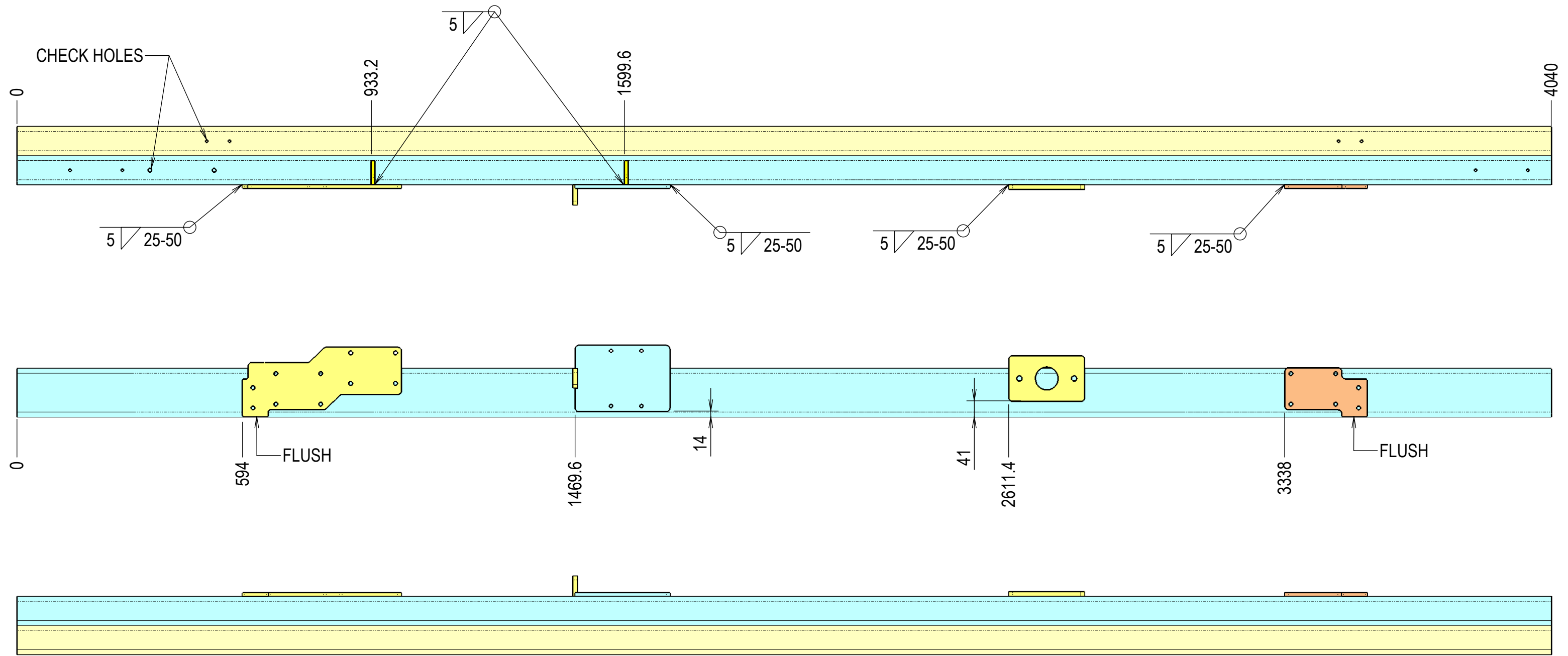


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DOCUMENT

Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
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SUB WELDMENT 2

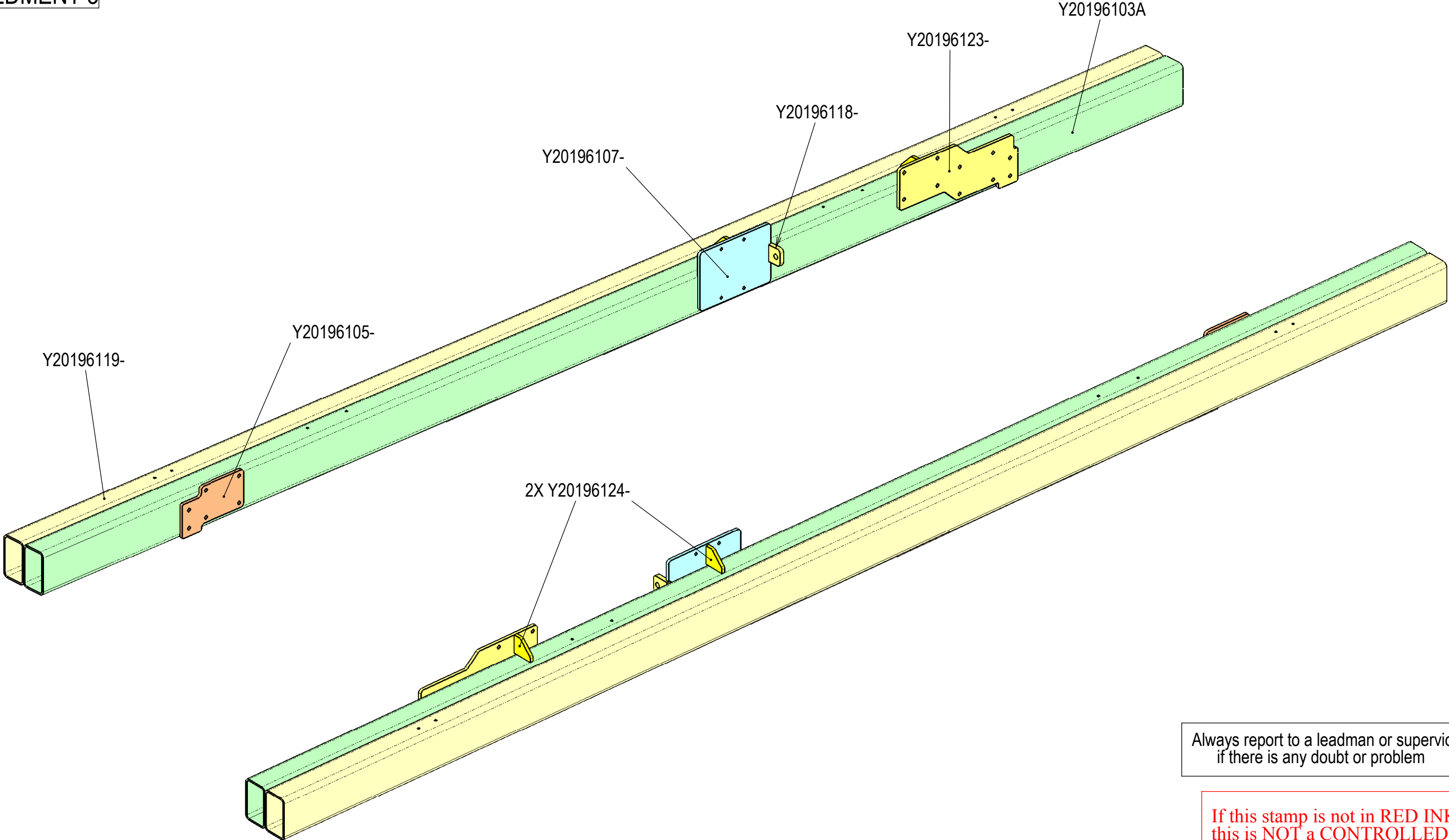


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Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
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SUB WELDMENT 3

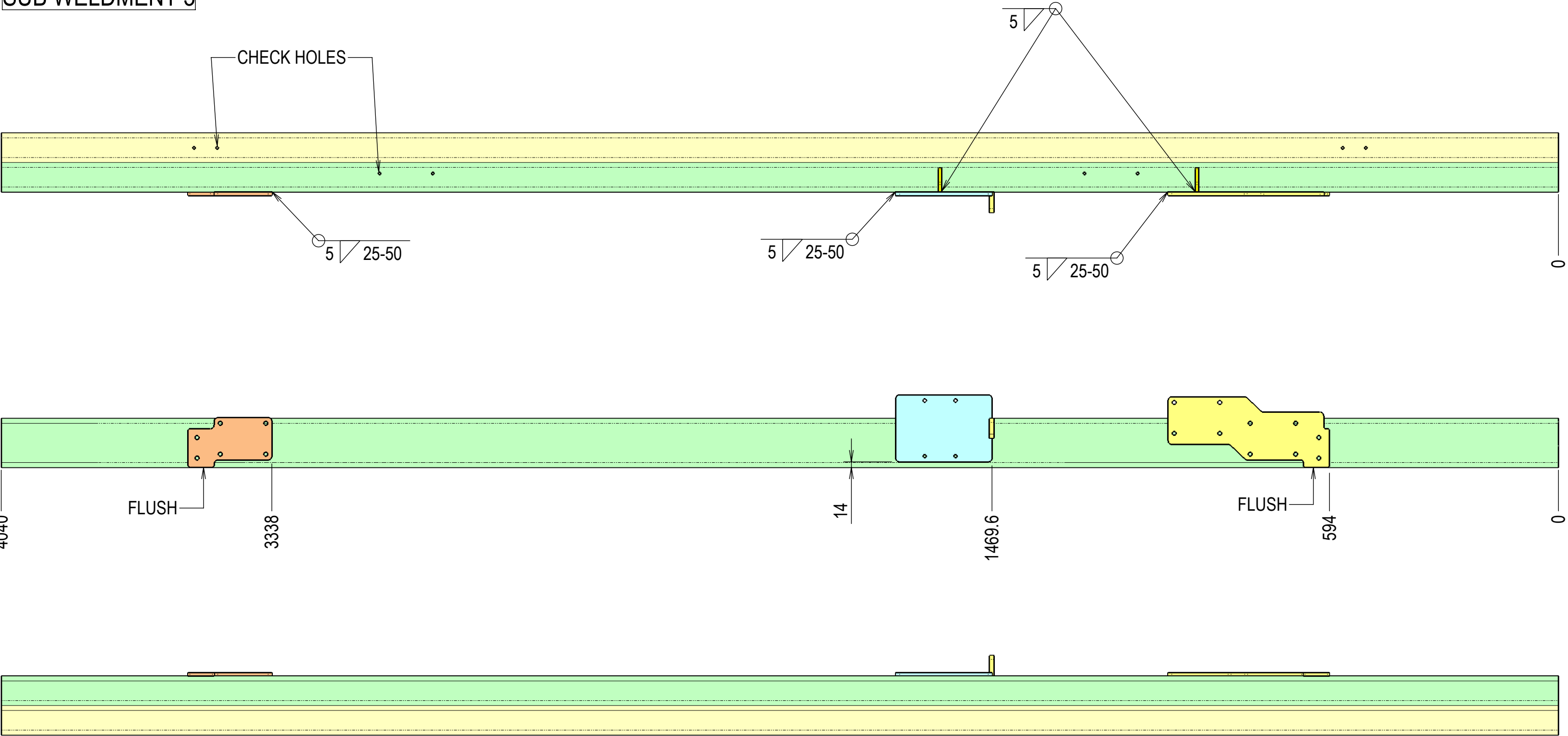


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Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	SUCTION TRAV FRAME	HW-Y201961--A	OI	07/31/19	APPROVED BY: Caesar M	8/11

SUB WELDMENT 3

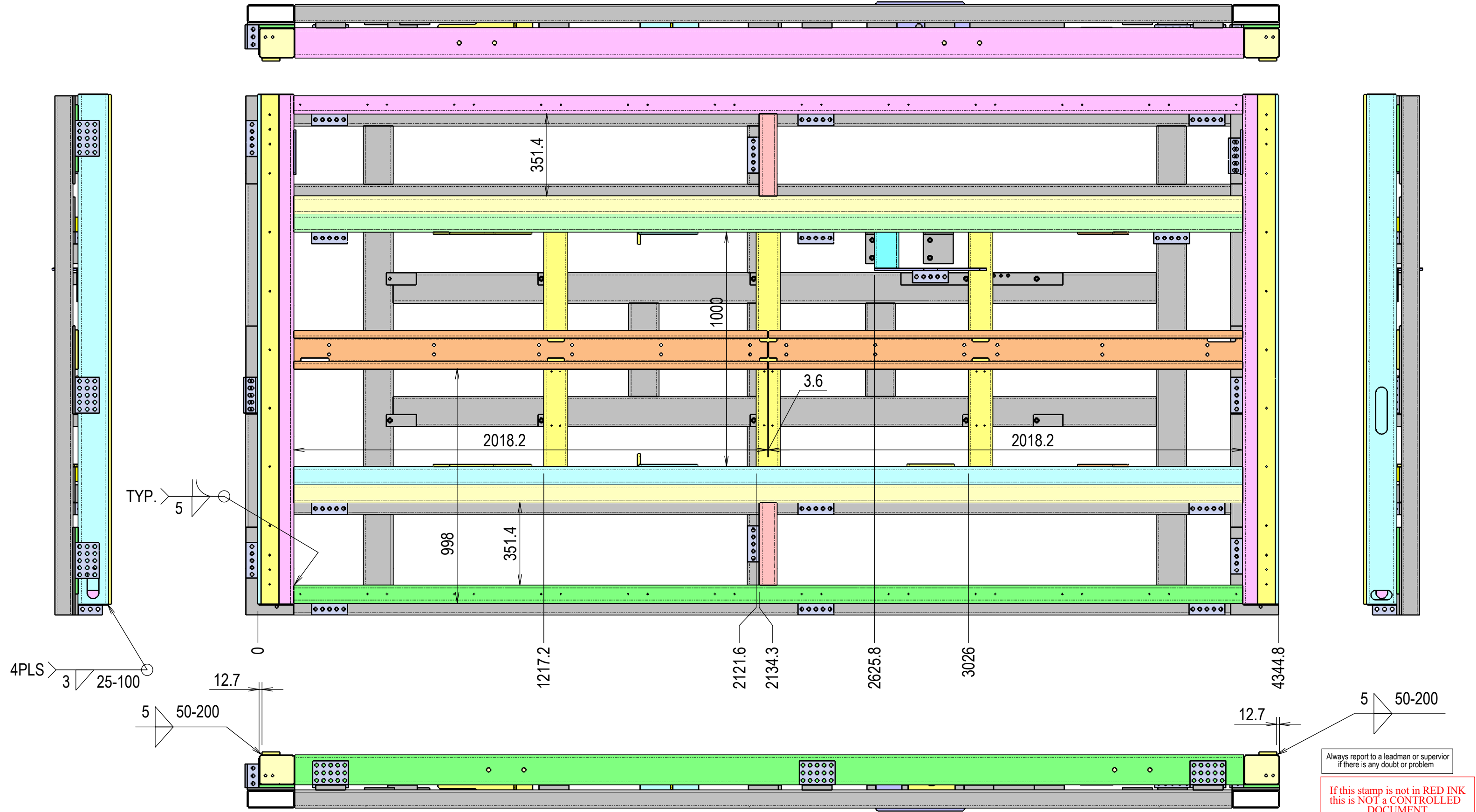


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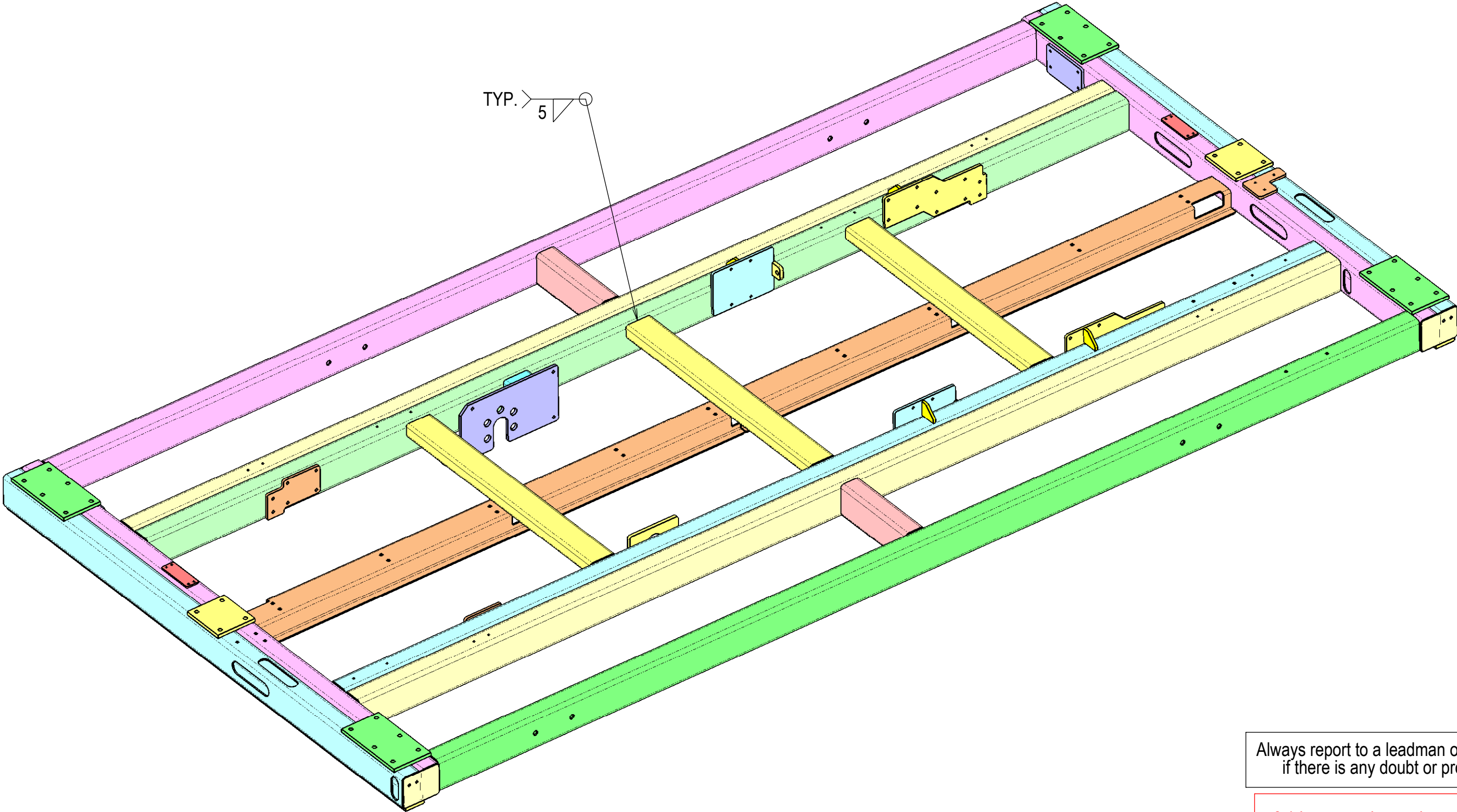
Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	SUCTION TRAV FRAME	HW-Y201961--A	OI	07/31/19	APPROVED BY: Caesar M	10/11

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 ↗



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

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