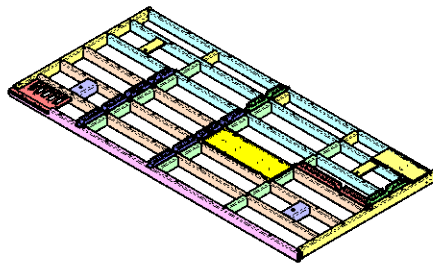
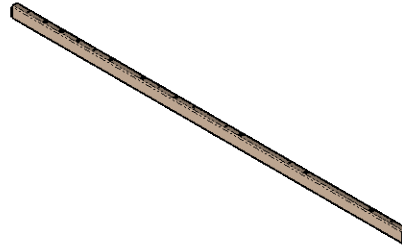
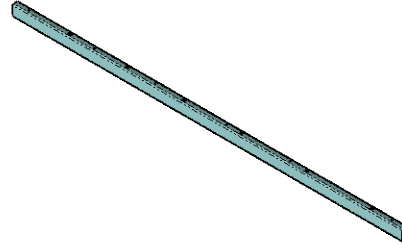
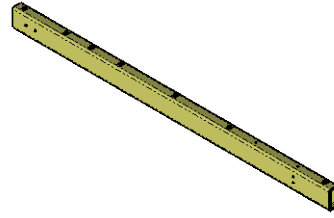
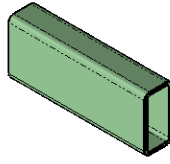
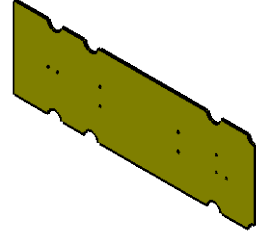
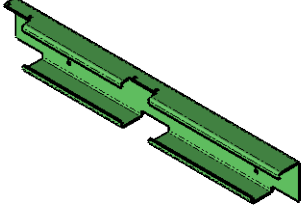
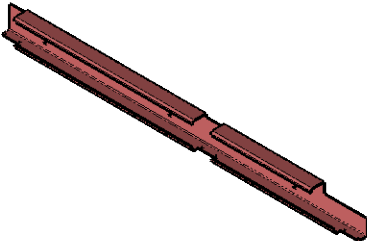
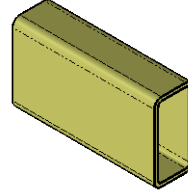
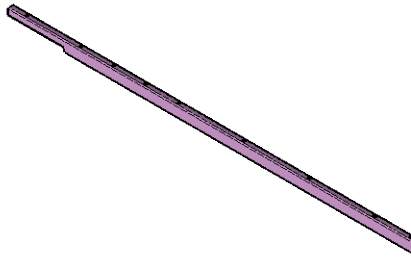
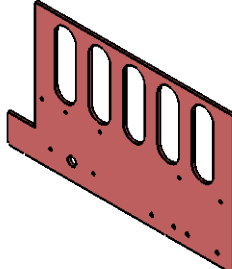



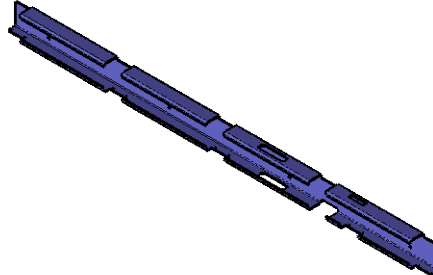
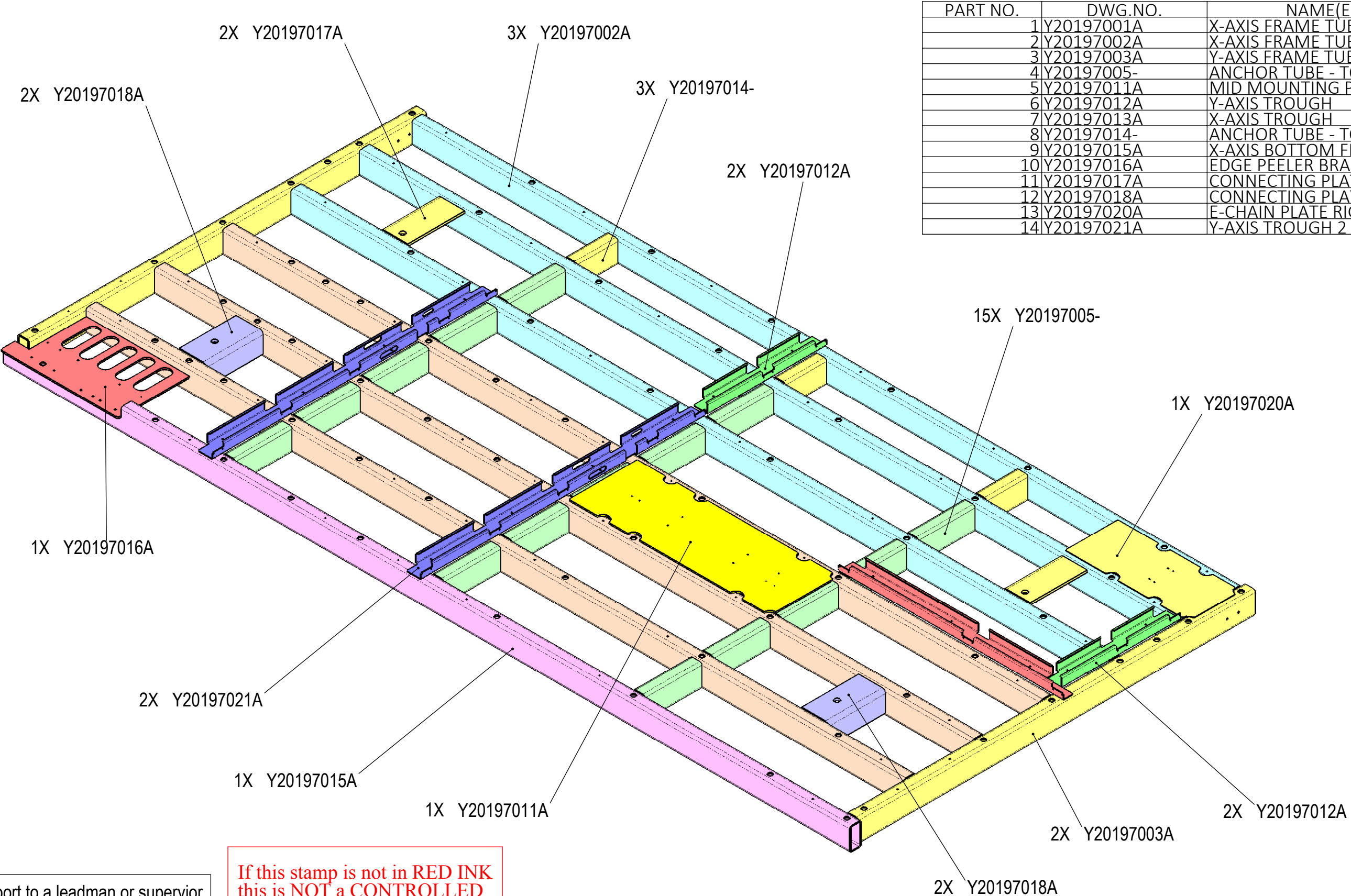


Metal Fabrication				Machine Model				Process Inst Name				Process Inst NO.				REV.		DATE		PREPARED BY: Leon Jiang				PAGE										
Process Instruction				AMS4020CL				4020 SUCTION FRAME				HW-Y201970--A				OI		07/29/19		APPROVED BY: Caesar M				1/6										
MACH				MACH				MACH				MACH				MACH				MACH														
BOM				BOM				BOM				BOM				BOM				BOM														
Main Part	SUCTION FRAME			Main Part	X-AXIS FRAME TUBE			Main Part	X-AXIS FRAME TUBE 2			Main Part	Y-AXIS FRAME TUBE			Main Part	ANCHOR TUBE - TOP 1			Main Part	MID MOUNTING PLATE			Main Part	Y-AXIS TROUGH									
Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part										
DWG NO	Y201970--A	QTY	1 /M	DWG NO	Y20197001A	QTY	3 /M	DWG NO	Y20197002A	QTY	3 /M	DWG NO	Y20197003A	QTY	2 /M	DWG NO	Y20197005-	QTY	15/M	DWG NO	Y20197011A	QTY	1 /M	DWG NO	Y20197012A	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														
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	OUT			Part Flow	BL-LC=>T			Part Flow	BL-LC=>T=>B									
																																		
MACH				MACH				MACH				MACH				MACH				MACH				MACH										
BOM				BOM				BOM				BOM				BOM				BOM				BOM										
Main Part	X-AXIS TROUGH			Main Part	ANCHOR TUBE - TOP 0			Main Part	X-AXIS BOTTOM FRAME TUBE			Main Part	EDGE PEELER BRACE PLATE			Main Part	CONNECTING PLATE TOP			Main Part	CONNECTING PLATE BOTTOM			Main Part	E-CHAIN PLATE RIGHT									
Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part										
DWG NO	Y20197013A	QTY	1 /M	DWG NO	Y20197014-	QTY	3 /M	DWG NO	Y20197015A	QTY	1 /M	DWG NO	Y20197016A	QTY	1 /M	DWG NO	Y20197017A	QTY	2 /M	DWG NO	Y20197018A	QTY	2 /M	DWG NO	Y20197020A	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														
Paint				Paint				Paint				Paint				Paint				Paint				Paint										
Time				Time				Time				Time				Time				Time				Time										
Part Flow	BL-LC=>T=>B			Part Flow	RI			Part Flow	RI			Part Flow	BL-LC=>T			Part Flow	BL-LC=>B			Part Flow	BL-LC=>B			Part Flow	BL-LC=>T									
																																		
MACH				MACH				MACH				MACH				MACH				MACH				MACH										
BOM				BOM				BOM				BOM				BOM				BOM				BOM										
Main Part	Y-AXIS TROUGH 2			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	Y20197021A	QTY	2 /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														
Paint				Paint				Paint				Paint				Paint				Paint				Paint										
Time				Time				Time				Time				Time				Time				Time										
Part Flow	BL-LC=>T=>B			Part Flow				Part Flow				Part Flow				Part Flow				Part Flow				Part Flow										
																																		

Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	4020 SUCTION FRAME	HW-Y201970--A	OI	07/29/19	APPROVED BY: Caesar M	2/6



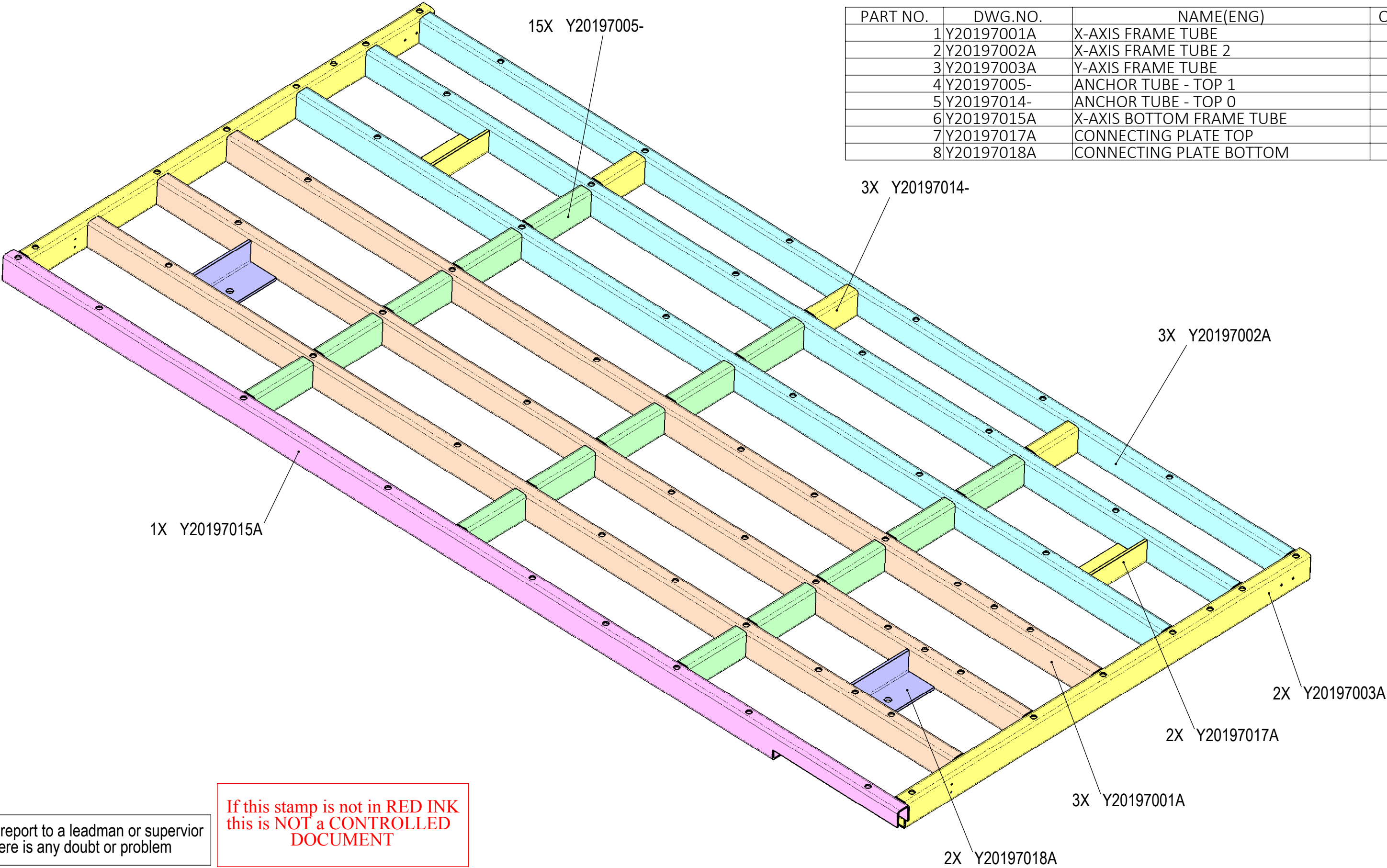
PART NO.	DWG.NO.	NAME(ENG)	QTY.
1	Y20197001A	X-AXIS FRAME TUBE	3
2	Y20197002A	X-AXIS FRAME TUBE 2	3
3	Y20197003A	Y-AXIS FRAME TUBE	2
4	Y20197005-	ANCHOR TUBE - TOP 1	15
5	Y20197011A	MID MOUNTING PLATE	1
6	Y20197012A	Y-AXIS TROUGH	2
7	Y20197013A	X-AXIS TROUGH	1
8	Y20197014-	ANCHOR TUBE - TOP 0	3
9	Y20197015A	X-AXIS BOTTOM FRAME TUBE	1
10	Y20197016A	EDGE PEELER BRACE PLATE	1
11	Y20197017A	CONNECTING PLATE TOP	2
12	Y20197018A	CONNECTING PLATE BOTTOM	2
13	Y20197020A	E-CHAIN PLATE RIGHT	1
14	Y20197021A	Y-AXIS TROUGH 2	2

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	4020 SUCTION FRAME	HW-Y201970--A	OI	07/29/19	APPROVED BY: Caesar M	3/6

PART NO.	DWG.NO.	NAME(ENG)	QTY.
1	Y20197001A	X-AXIS FRAME TUBE	3
2	Y20197002A	X-AXIS FRAME TUBE 2	3
3	Y20197003A	Y-AXIS FRAME TUBE	2
4	Y20197005-	ANCHOR TUBE - TOP 1	15
5	Y20197014-	ANCHOR TUBE - TOP 0	3
6	Y20197015A	X-AXIS BOTTOM FRAME TUBE	1
7	Y20197017A	CONNECTING PLATE TOP	2
8	Y20197018A	CONNECTING PLATE BOTTOM	2

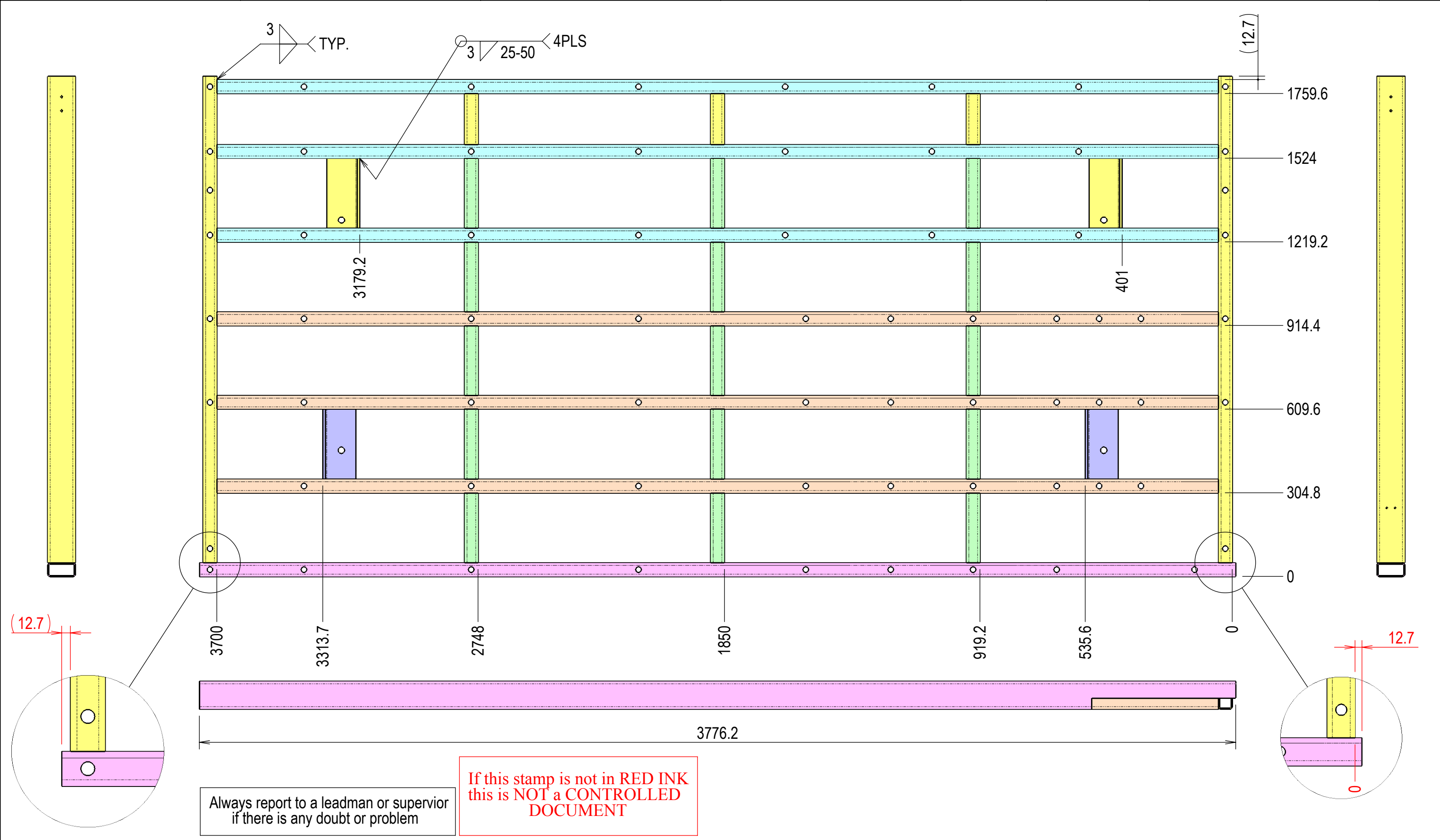


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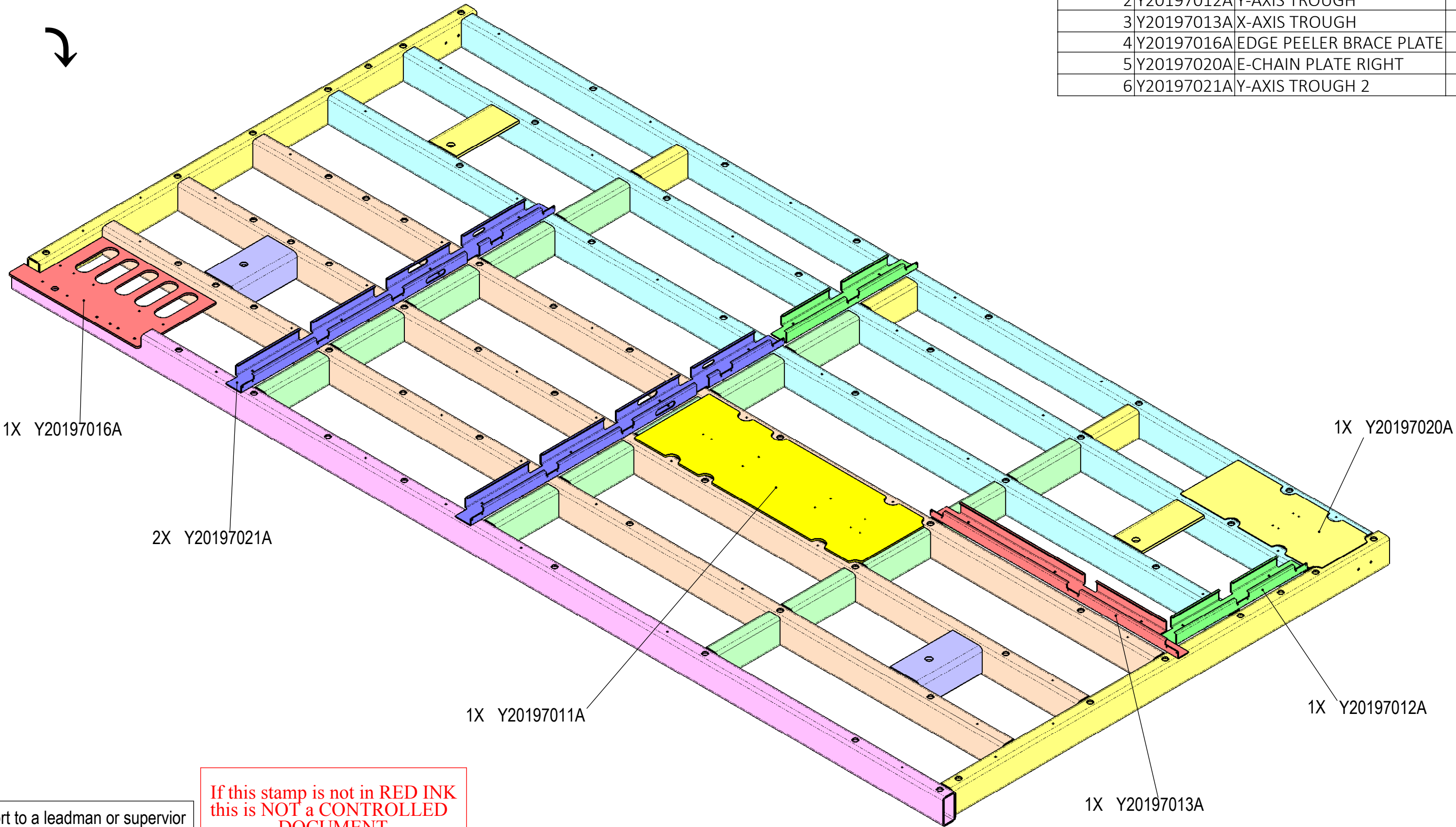
Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	4020 SUCTION FRAME	HW-Y201970--A	OI	07/29/19	APPROVED BY: Caesar M	4/6



Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	4020 SUCTION FRAME	HW-Y201970--A	OI	07/29/19	APPROVED BY: Caesar M	5/6

FLIP THE WELDMENT UPSIDE DOWN FROM LEFT TO RIGHT

PART NO.	DWG.NO.	NAME(ENG)	QTY.
1	Y20197011A	MID MOUNTING PLATE	1
2	Y20197012A	Y-AXIS TROUGH	1
3	Y20197013A	X-AXIS TROUGH	1
4	Y20197016A	EDGE PEELER BRACE PLATE	1
5	Y20197020A	E-CHAIN PLATE RIGHT	1
6	Y20197021A	Y-AXIS TROUGH 2	2



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