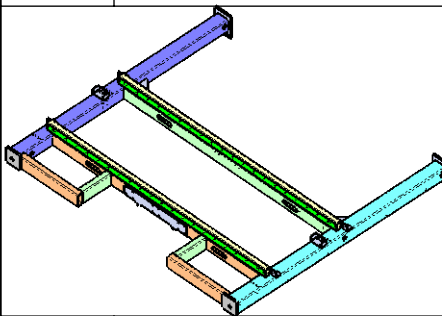
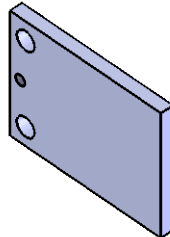
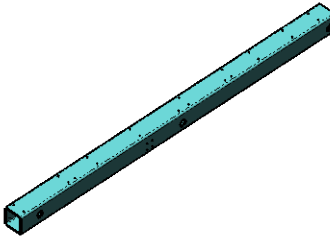
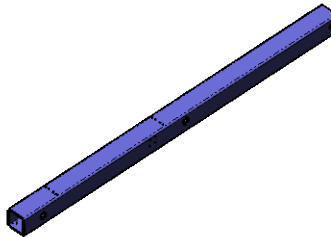
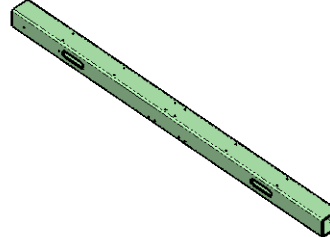
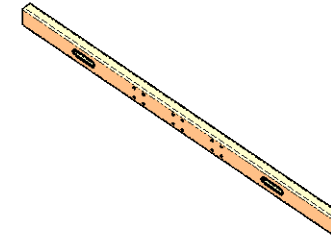
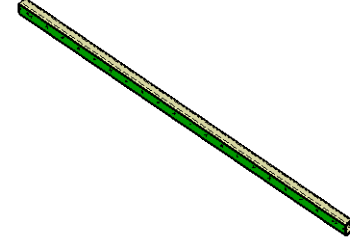

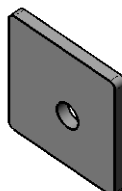
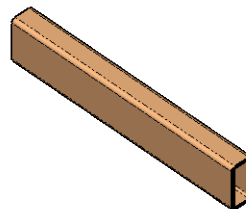
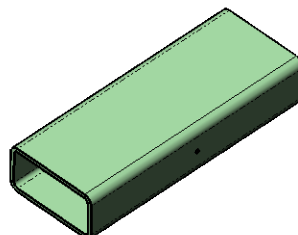

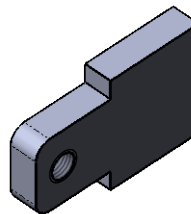

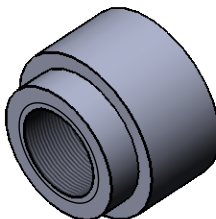
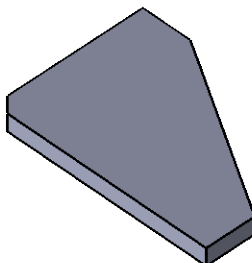
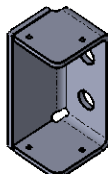
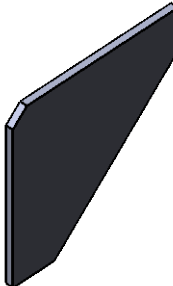
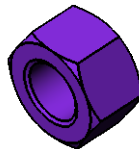


Metal Fabrication				Machine Model				Process Inst Name				Process Inst NO.				REV.		DATE		PREPARED BY: Leon Jiang				PAGE			
Process Instruction				AMS4020CL				MAIN FRAME LHS				HW-Y201962--B				OI		08/01/19		APPROVED BY: Caesar M				1/12			
MACH				MACH				MACH				MACH				MACH				MACH							
BOM				BOM				BOM				BOM				BOM				BOM							
Main Part	MAIN FRAME WELDMENT			Main Part	FOOT PLATE			Main Part	FRONT TUBE 1			Main Part	FRONT TUBE 2			Main Part	SIDE TUBE 1			Main Part	SIDE TUBE 2			Main Part	RAIL TUBE		
Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part			
DWG NO	Y201962--B	QTY	1 /M	DWG NO	Y20160008C	QTY	2 /M	DWG NO	Y20196201B	QTY	1 /M	DWG NO	Y20196202B	QTY	1 /M	DWG NO	Y20196206A	QTY	1 /M	DWG NO	Y20196207A	QTY	1 /M	DWG NO	Y20196208A	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	BT			Paint				Paint				Paint				Paint				Paint				Paint			
Time				Time				Time				Time				Time				Time				Time			
Part Flow				Part Flow	OUT			Part Flow	OUT			Part Flow	OUT			Part Flow	OUT			Part Flow	OUT			Part Flow	OUT		
																											
MACH				MACH				MACH				MACH				MACH				MACH				MACH			
BOM				BOM				BOM				BOM				BOM				BOM				BOM			
Main Part	RAIL SUPPORT ANGLE			Main Part	LIFTING PLATE			Main Part	TOP LONG TUBE			Main Part	SHORT TOP TUBE			Main Part	FORK TRAVERSER MOUNT PLATE			Main Part	PUSH BLOCK			Main Part	BOX MOUNT BRACKET		
Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part			
DWG NO	Y20196209A	QTY	4 /M	DWG NO	Y20196211A	QTY	2 /M	DWG NO	Y20196212A	QTY	2 /M	DWG NO	Y20196213-	QTY	2 /M	DWG NO	Y20196214A	QTY	1 /M	DWG NO	Y20196215A	QTY	2 /M	DWG NO	Y20196216A	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				Paint				Paint				Paint				Paint				Paint				Paint			
Time				Time				Time				Time				Time				Time				Time			
Part Flow	OUT			Part Flow	OUT			Part Flow	OUT			Part Flow	OUT			Part Flow	OUT			Part Flow	OUT			Part Flow	OUT		
																											
MACH				MACH				MACH				MACH				MACH				MACH				MACH			
BOM				BOM				BOM				BOM				BOM				BOM				BOM			
Main Part	EYE BOLT ROUND			Main Part	SUPPORT GUSSET			Main Part	JACK BOLT PLATE CENTER			Main Part	CORNER GUSSET			Main Part	M20 HEX NUT			Main Part				Main Part			
Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part				Sub Part			
DWG NO	Y20196217-	QTY	2 /M	DWG NO	Y20196218-	QTY	1 /M	DWG NO	Y20196221-	QTY	2 /M	DWG NO	Y20196414-	QTY	2 /M	DWG NO	P332000010	QTY	4 /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	OUT			Part Flow	OUT			Part Flow	OUT			Part Flow	OUT			Part Flow	F			Part Flow				Part Flow			
																											
																								Always report to a leadman or supervisor if there is any doubt or problem			
																								If this stamp is not in RED INK this is NOT a CONTROLLED DOCUMENT			

Metal Fabrication

Machine Model

Process Inst Name

Process Inst NO.

REV.

DATE

PREPARED BY: Leon Jiang

PAGE

Process Instruction

AMS4020CL

MAIN FRAME LHS

HW-Y201962--B

OI

08/01/19

APPROVED BY: Caesar M

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LHS SUB WELDMENT

1X Y20196202B

2X Y20196414-

1X Y20196206A

2X Y20196208A

1X Y20196201B

1X Y20196207A

1X Y20196214A

2X Y20196215A

2X Y20196213-

2X Y20196212A

2X Y20196217-

2X Y20196211A

4X Y20196209A

2X Y20196221-

4X P332000010

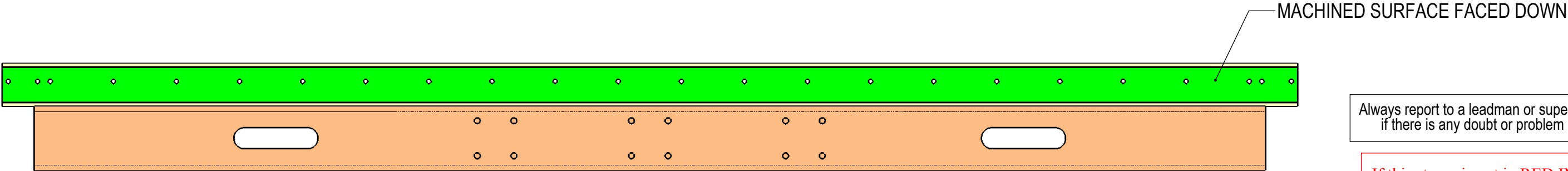
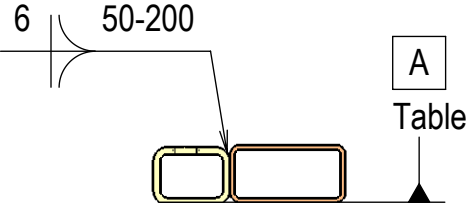
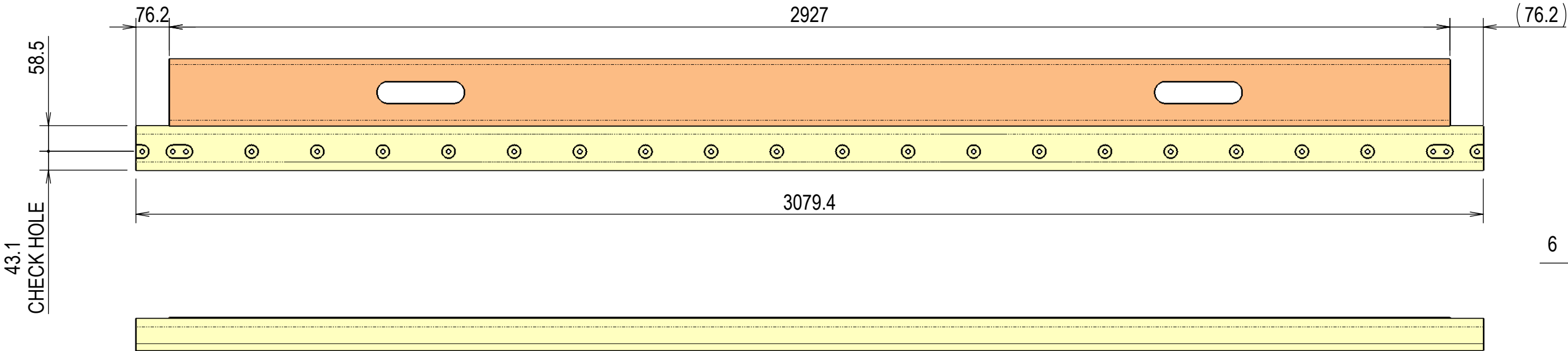
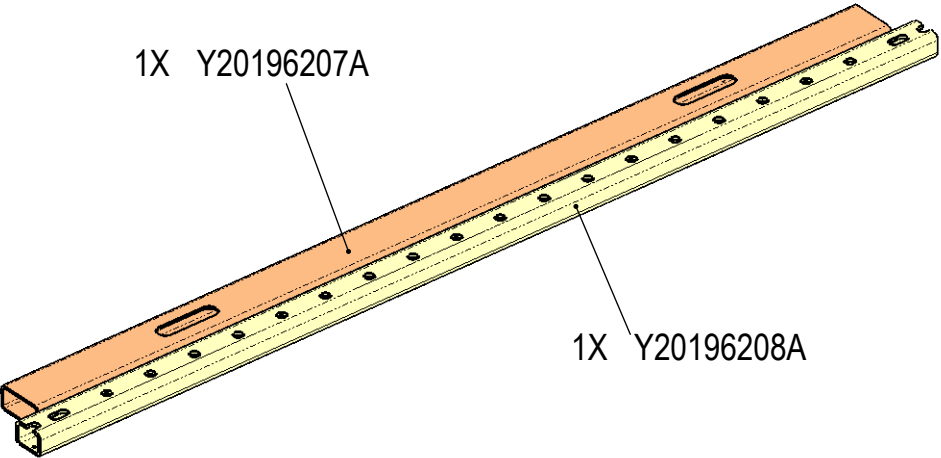
PART NO.	DWG.NO.	NAME(ENG)	QTY.
1	Y20160008C	FOOT PLATE	2
2	Y20196201B	FRONT TUBE 1	1
3	Y20196202B	FRONT TUBE 2	1
4	Y20196206A	SIDE TUBE 1	1
5	Y20196207A	SIDE TUBE 2	1
6	Y20196208A	RAIL TUBE	2
7	Y20196209A	RAIL SUPPORT ANGLE	4
8	Y20196211A	LIFTING PLATE	2
9	Y20196212A	TOP LONG TUBE	2
10	Y20196213-	SHORT TOP TUBE	2
11	Y20196214A	FORK TRAVERSER MOUNT PLATE	1
12	Y20196215A	PUSH BLOCK	2
13	Y20196216A	BOX MOUNT BRACKET	1
14	Y20196217-	EYE BOLT ROUND	2
15	Y20196218-	SUPPORT GUSSET	1
16	Y20196221-	JACK BOLT PLATE CENTER	2
17	Y20196414-	CORNER GUSSET	2
18	P332000010	NUT	4

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Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	MAIN FRAME LHS	HW-Y201962--B	OI	08/01/19	APPROVED BY: Caesar M	3/12

SUB WELDMENT 1

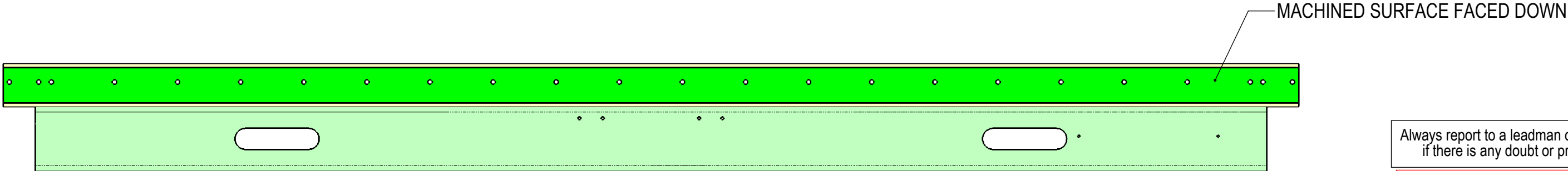
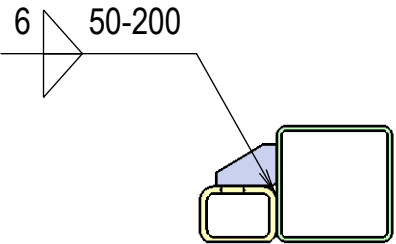
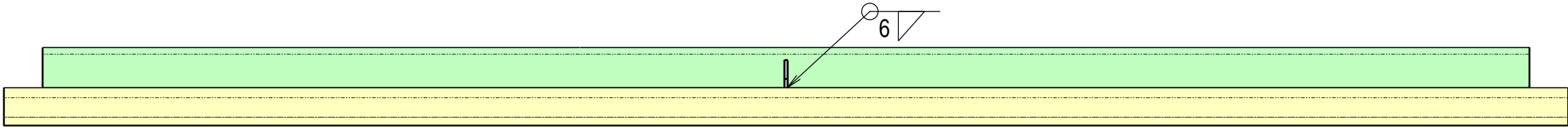
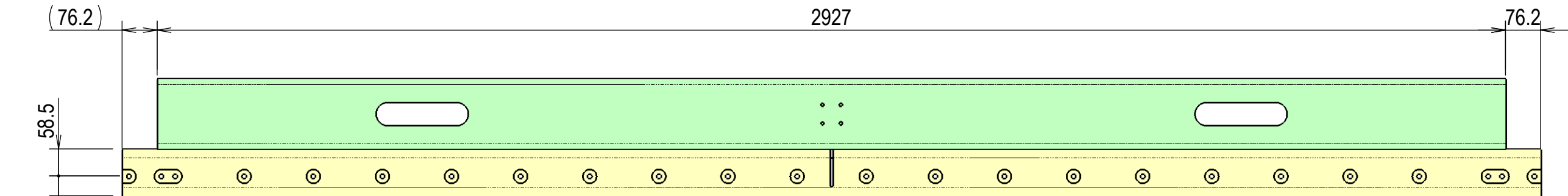
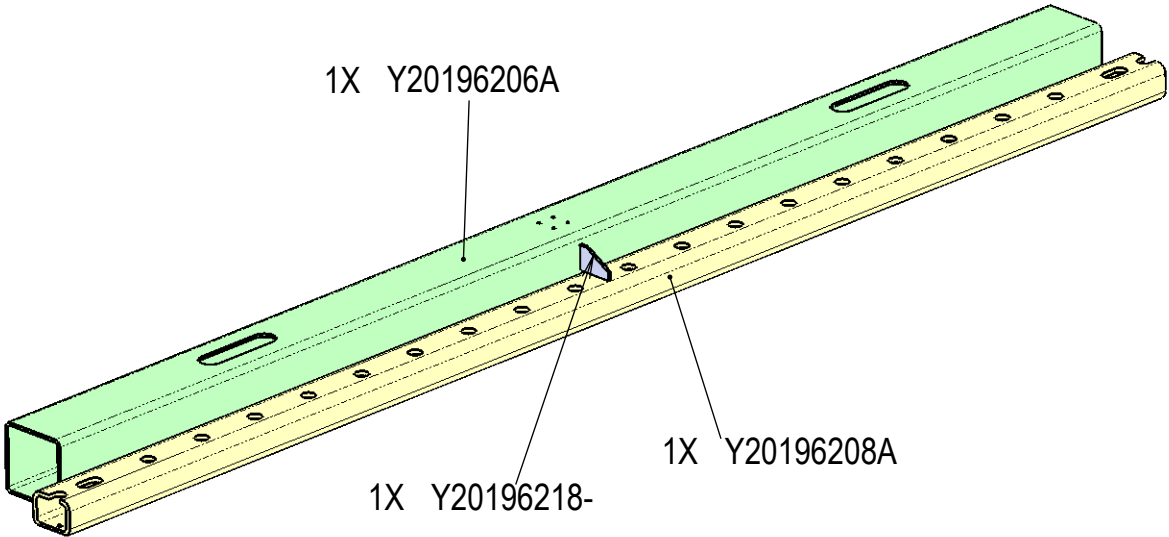


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Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
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SUB WELDMENT 2

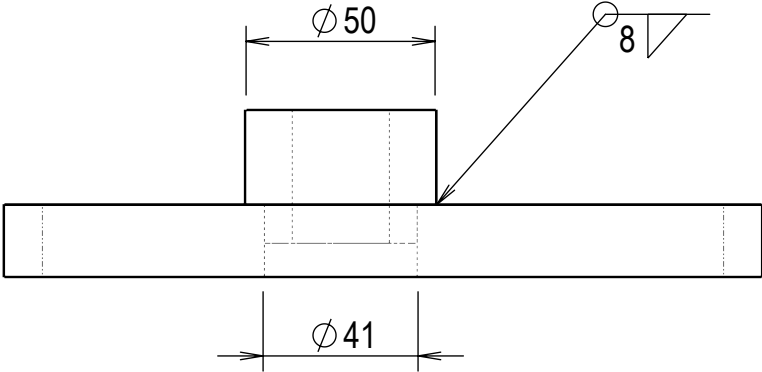
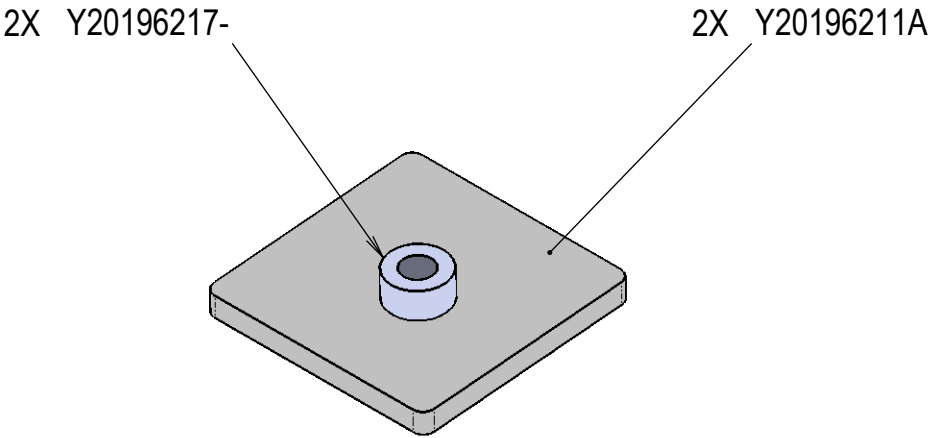
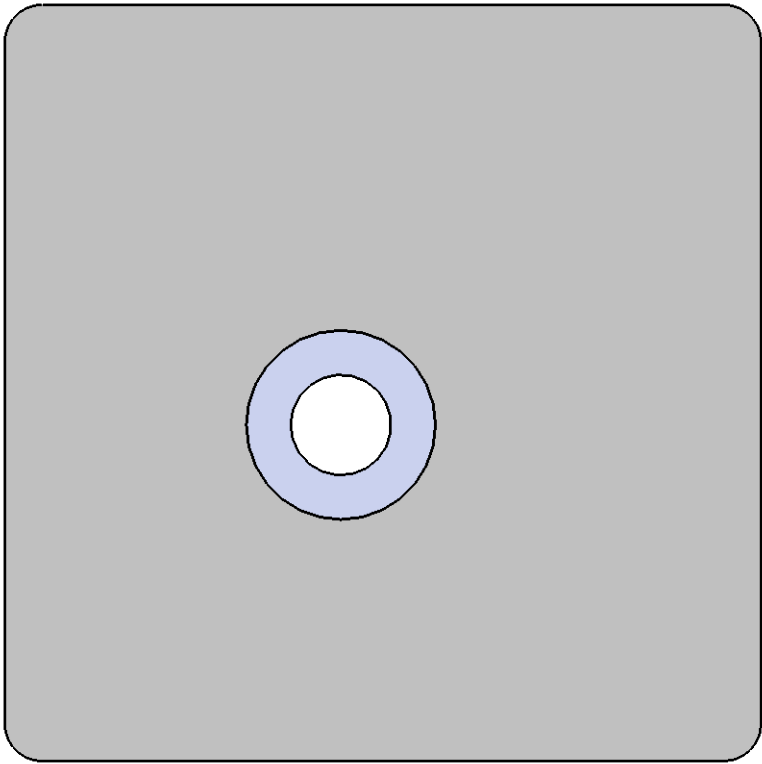


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Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	MAIN FRAME LHS	HW-Y201962--B	OI	08/01/19	APPROVED BY: Caesar M	5/12

SUB WELDMENT 3

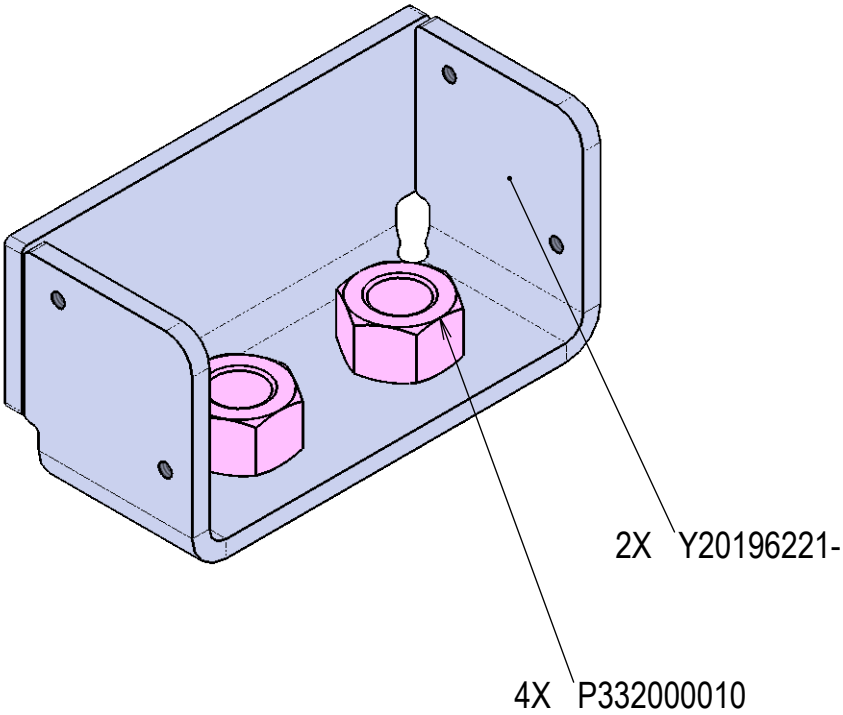
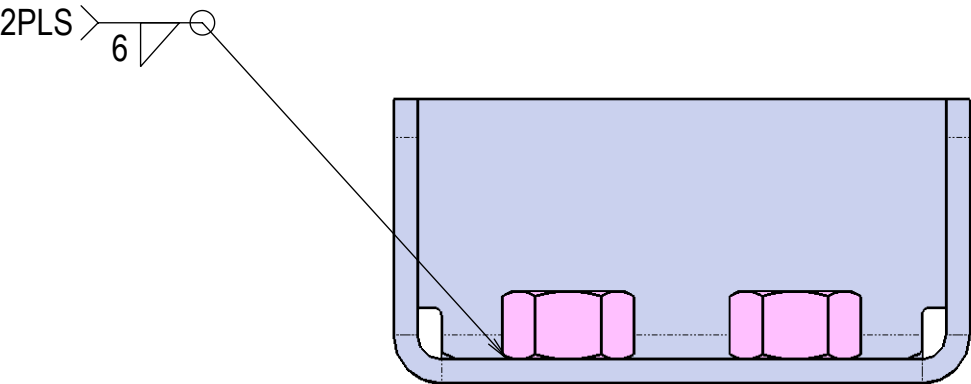
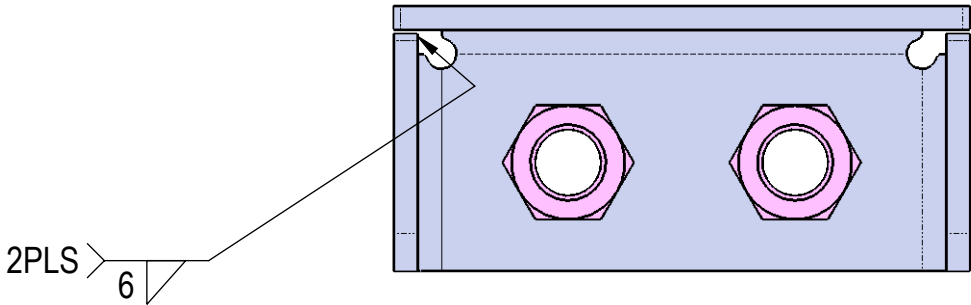


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Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	MAIN FRAME LHS	HW-Y201962--B	OI	08/01/19	APPROVED BY: Caesar M	6/12

SUB WELDMENT 4

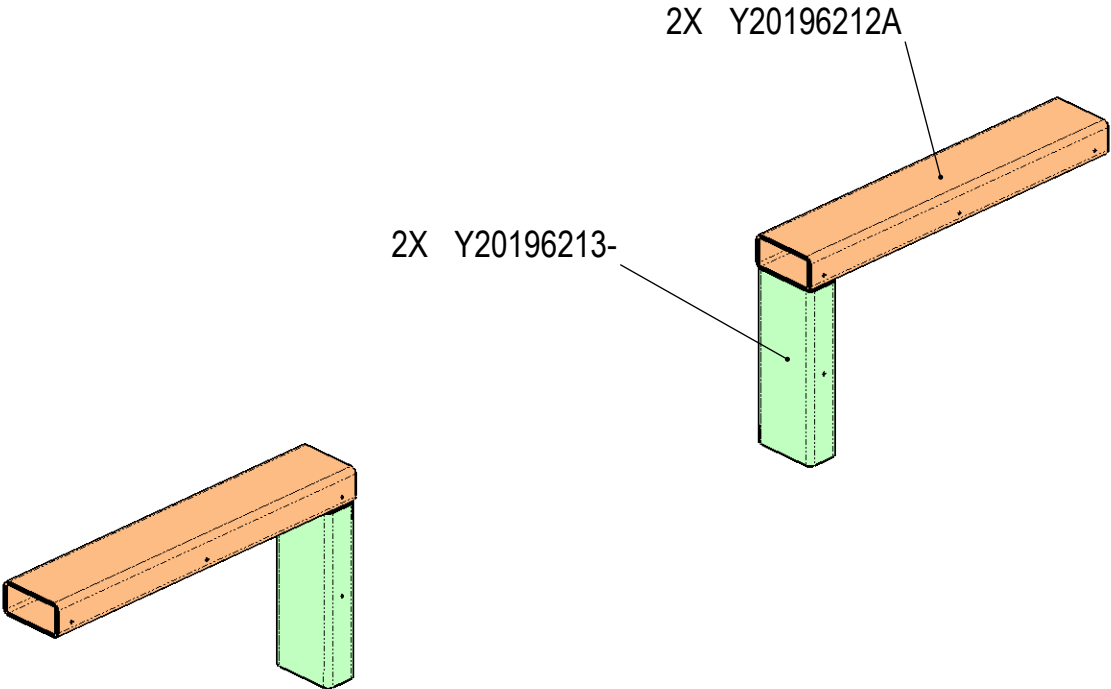


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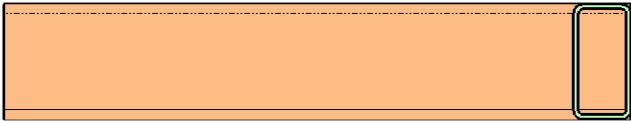
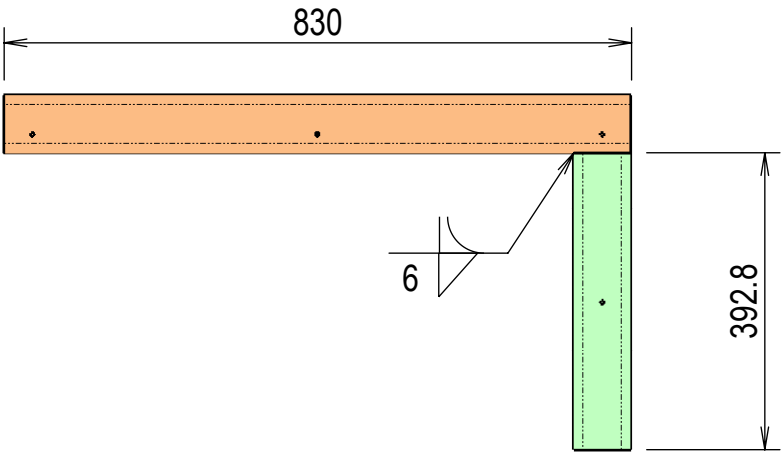
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Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	MAIN FRAME LHS	HW-Y201962--B	OI	08/01/19	APPROVED BY: Caesar M	7/12

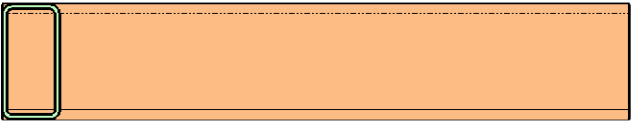
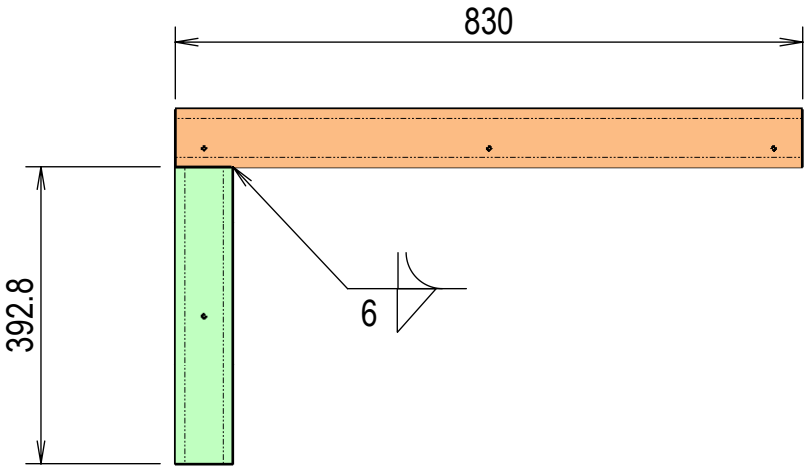
SUB WELDMENT 5



SUB WELDMENT 5-1



SUB WELDMENT 5-2

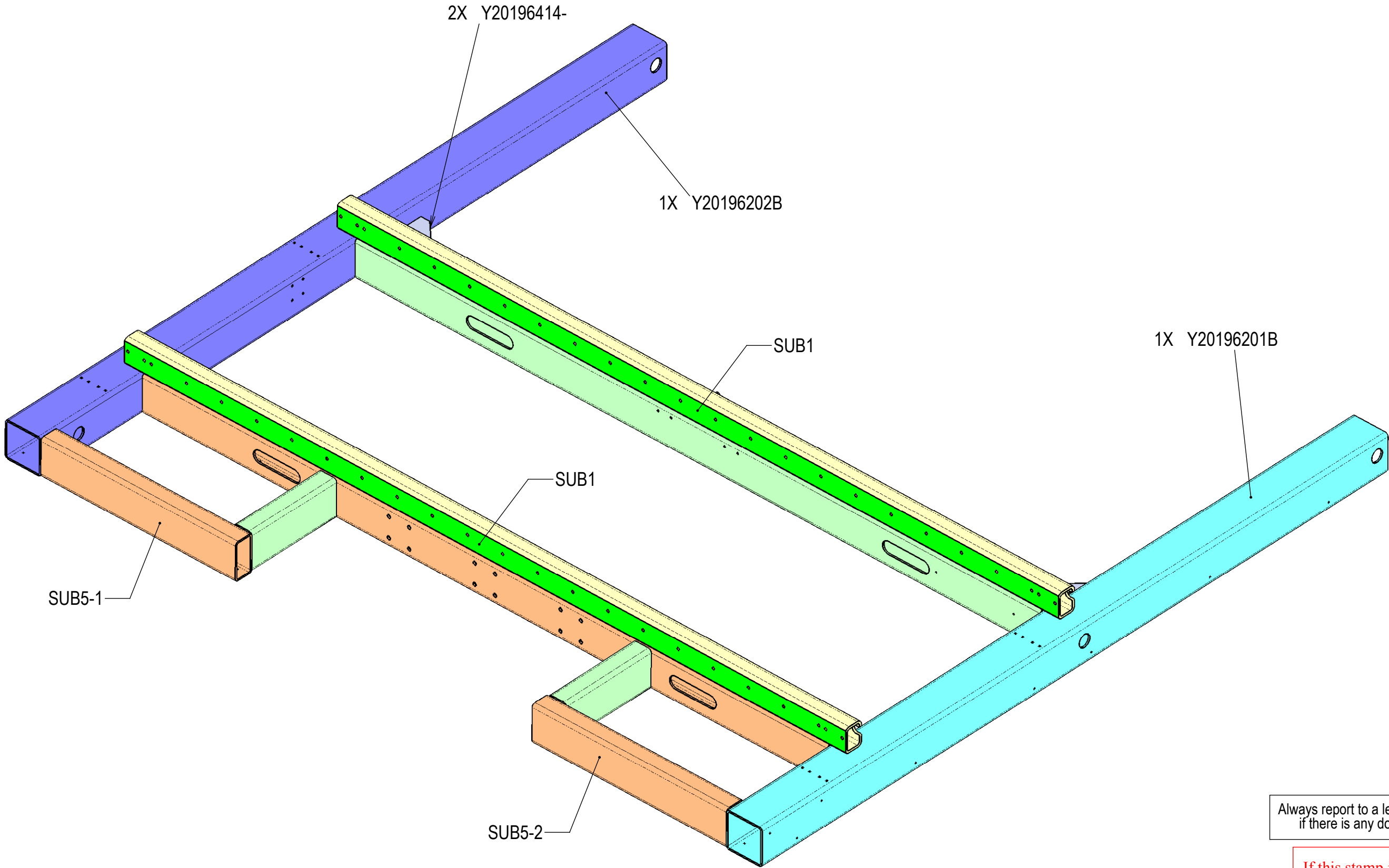


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Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
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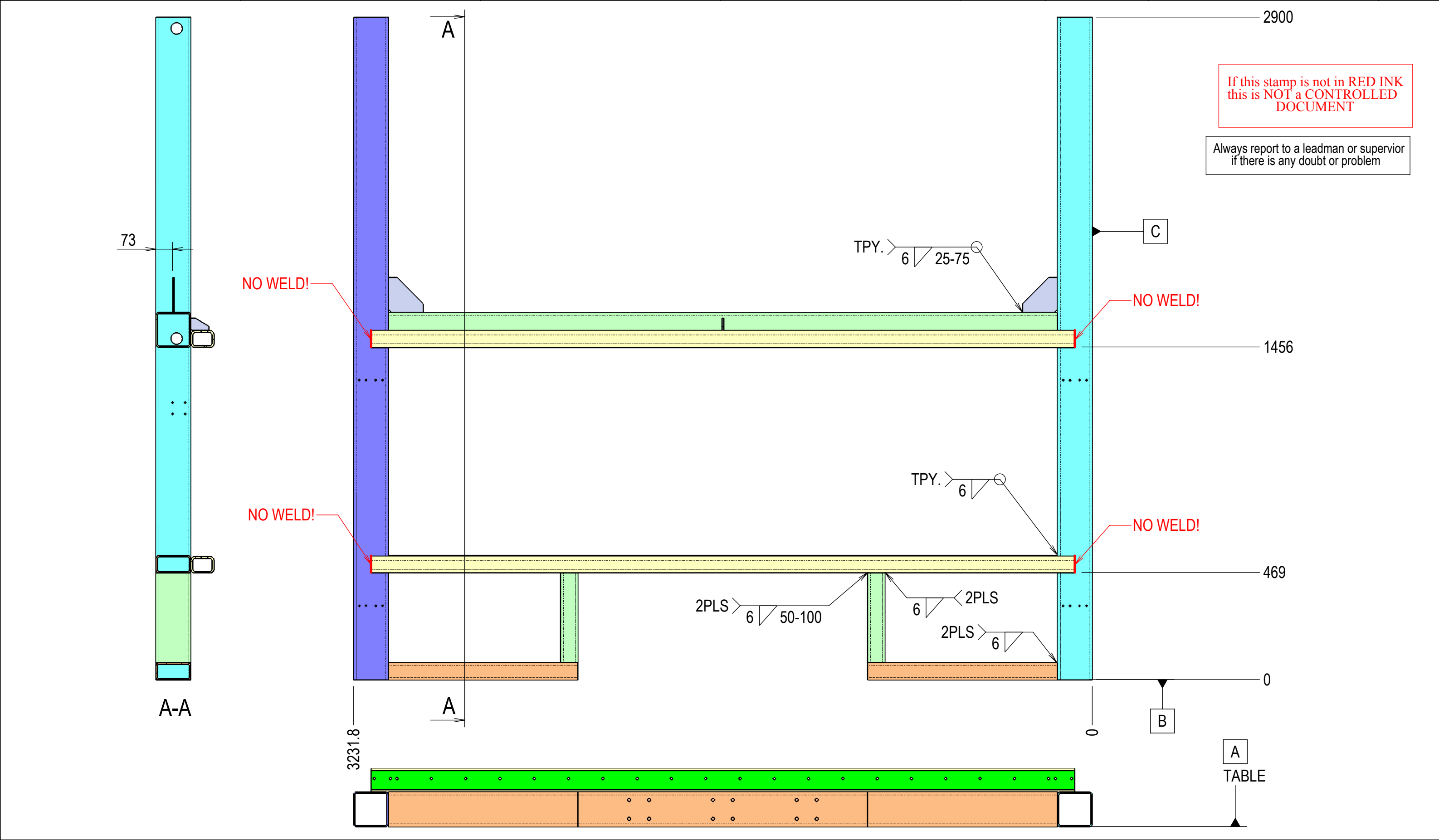


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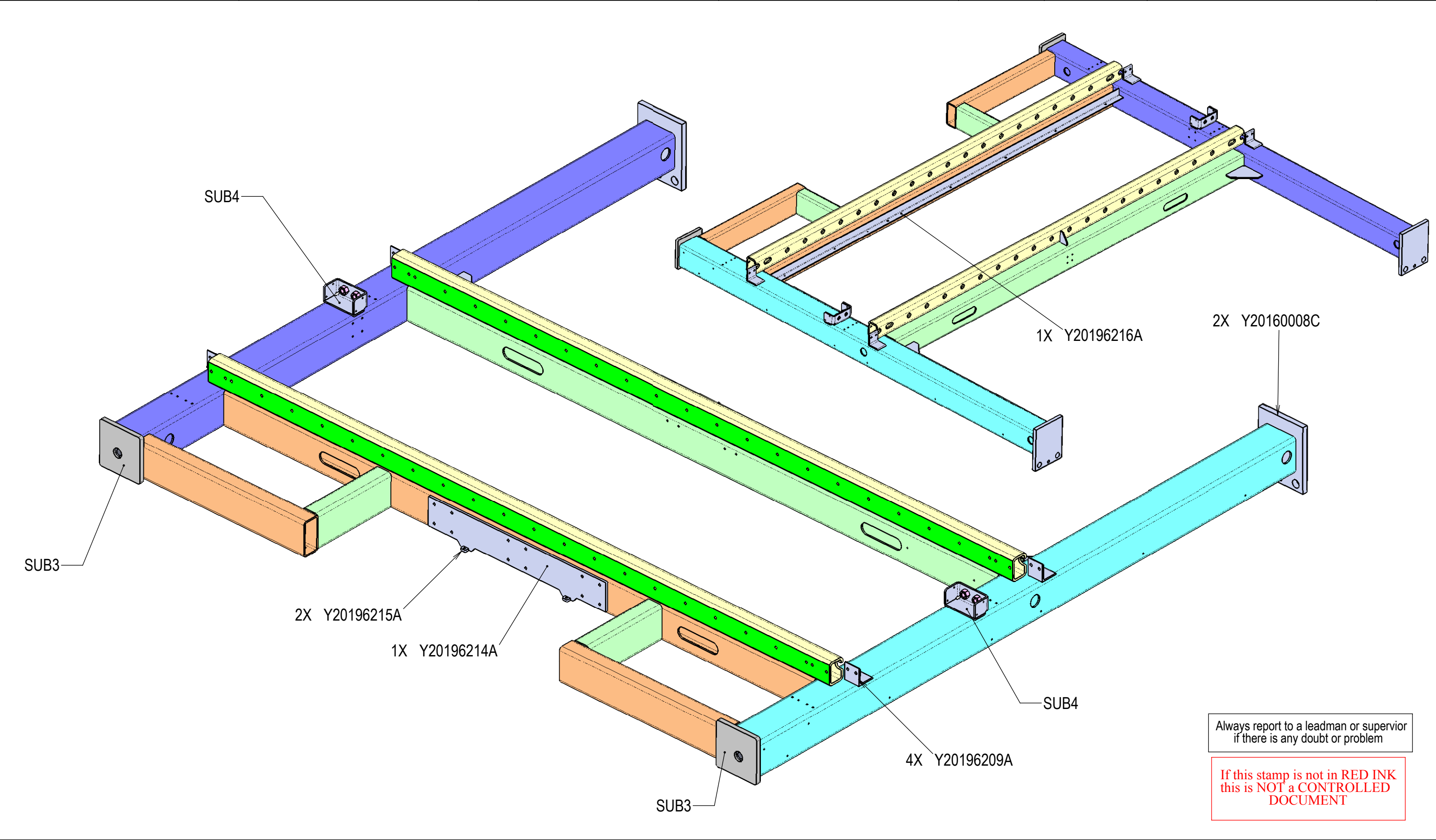
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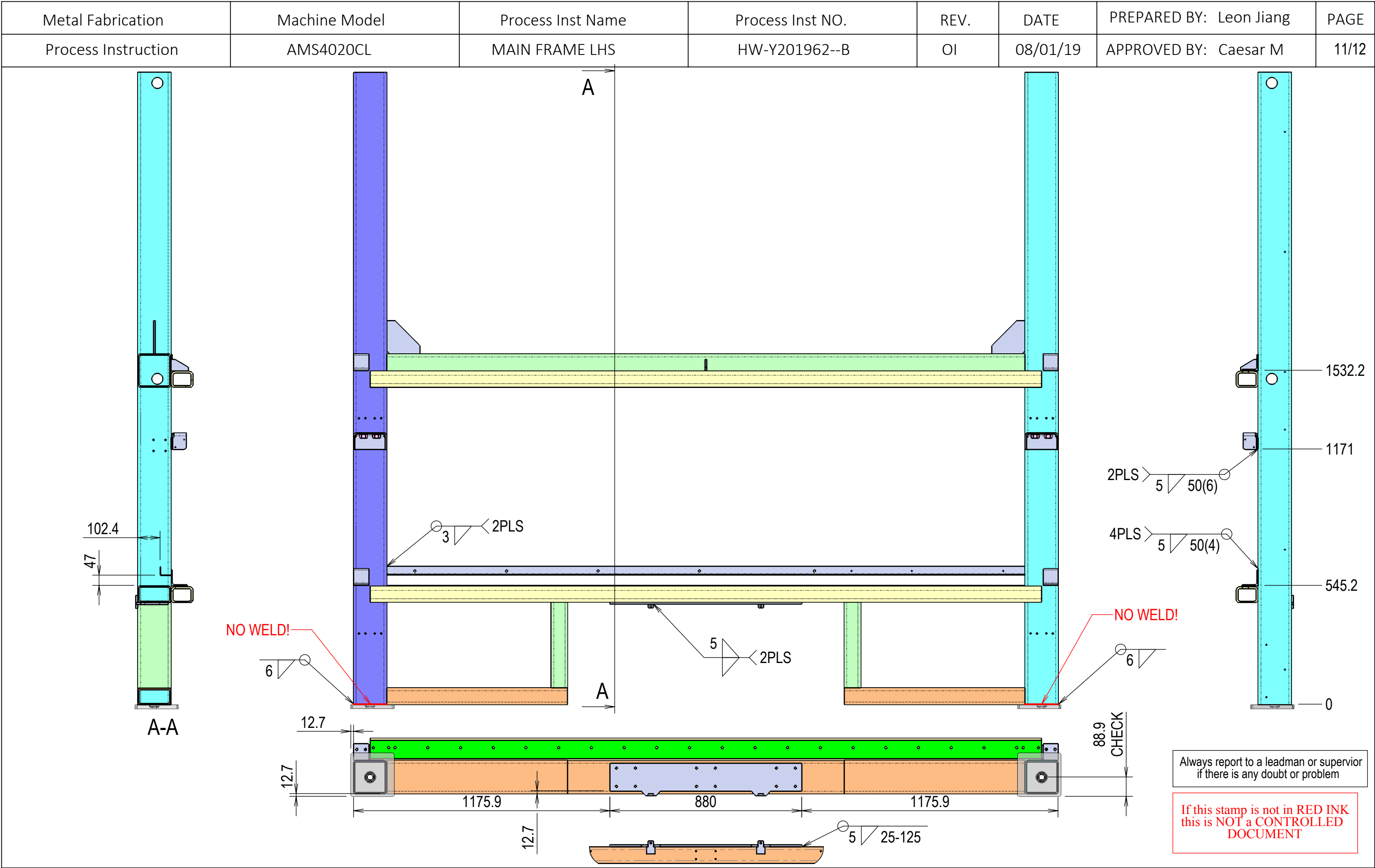


Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	MAIN FRAME LHS	HW-Y201962--B	OI	08/01/19	APPROVED BY: Caesar M	9/12

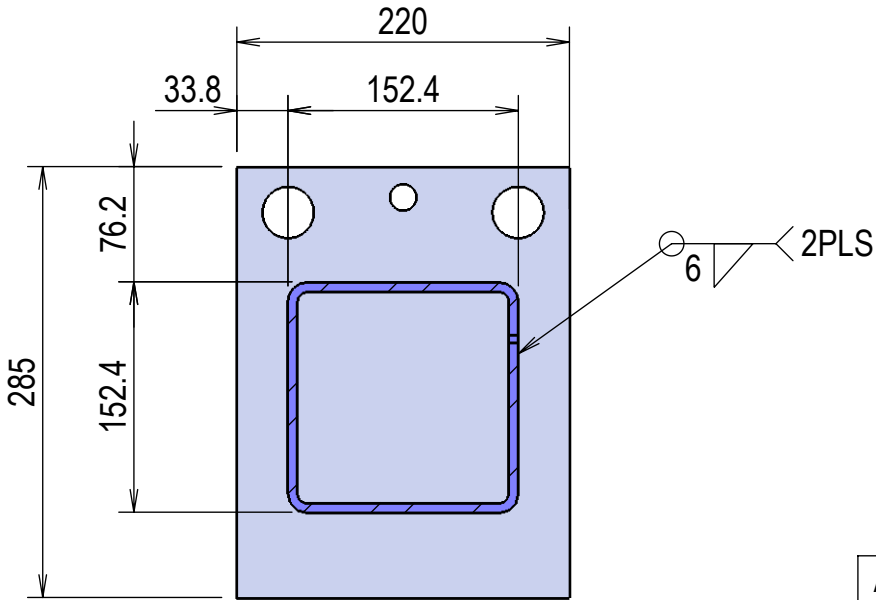
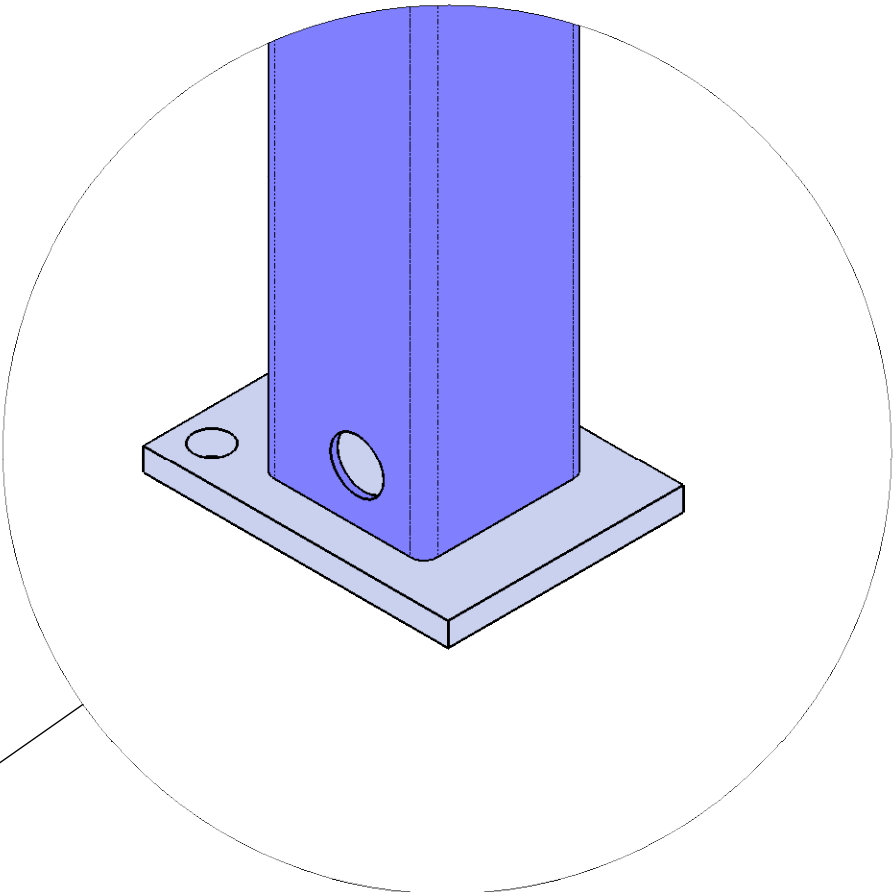
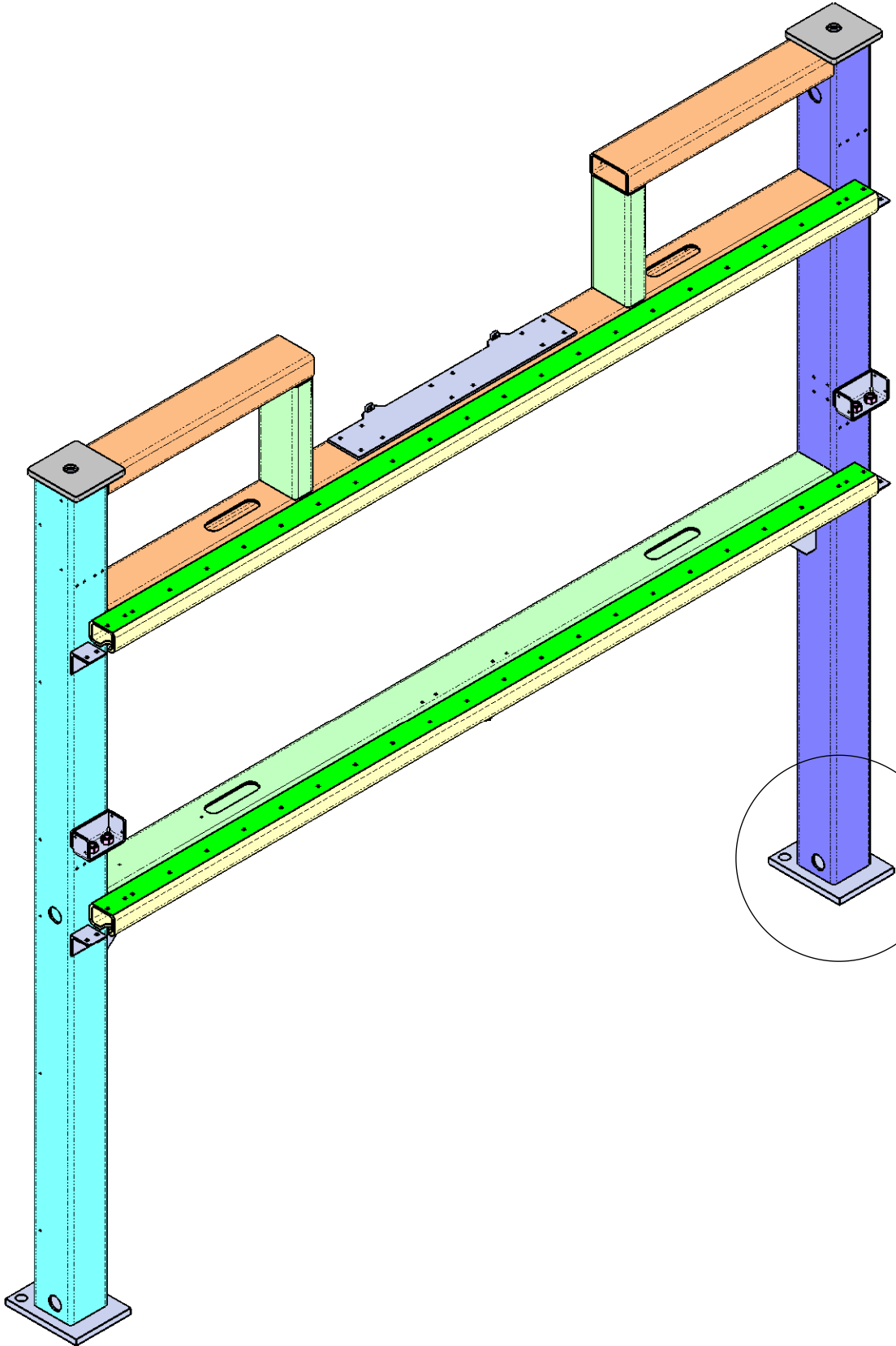


Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
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