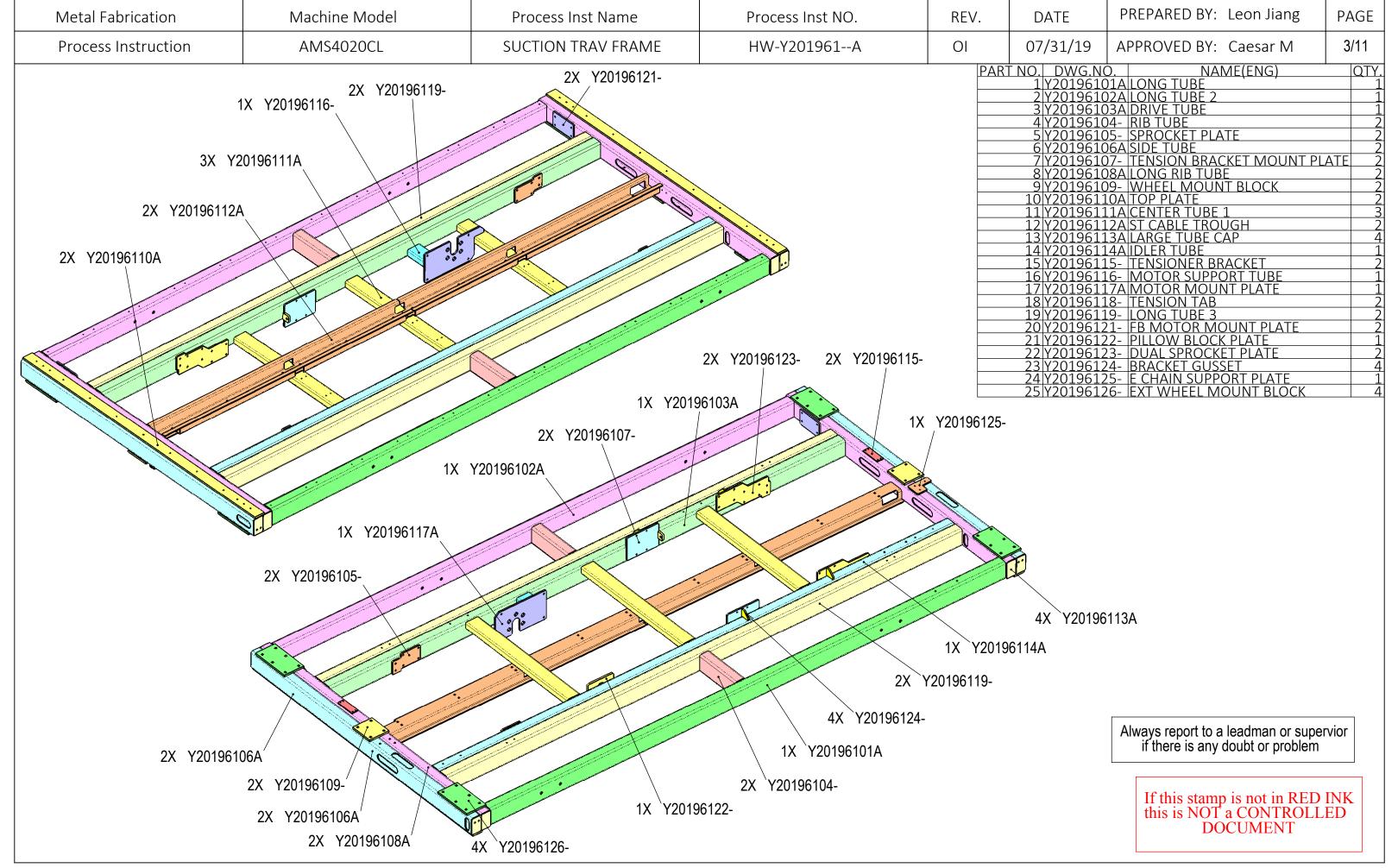
Metal Fabrication		Machine	- Model		Proc	cess Inst	Name		Process	Inst NO.	REV.	DATE	PREPARED BY:	Leon Jiana	PAGE
Process Instruction	AMS4020CL SUCTION TRAV FRAME			IE I	HW-Y201961A OI			07/31/19	APPROVED BY:		1/11				
		AIVIJ4U2											1/11		
	ЛАСН			MACH			MACH			MACH		MACH	MA		
Main Part ST FRAME WELDMENT Mai	BOM ain Part <b>L</b> ub Part	ONG TUBE		BOM  Main Part L  Sub Part	ONG TUBE 2	2	BOM Main Part Sub Part	DRIVE TUBE		BOM Main Part RIB TUB Sub Part	E	BOM Main Part SPROCK Sub Part	ET PLATE Mair Sub	Part SIDE TUBE	
DWG NO Y201961A QTY 1 /MDW	NG NO Y	′20196101A	QTY <b>1</b> /M	DWG NO Y	/20196102A	QTY 1/N	DWG NO	Y20196103A	QTY <b>1</b> /M	DWG NO Y201961	04- QTY 2 /N	DWG NO Y201961	<b>)5-</b> QTY <b>2</b> /MDW(	NO Y20196106A	QTY <b>2</b> /M
E SAFE	lat Size		INIT/ DATE	Mat Size		INIT/ DATE	Mat Size		INIT/ DATE	Mat Size	INIT/ DATE	Mat Size		Size	INIT/ DATE
Lengui	ength Paint		DATE	Length Paint		DATE	Length Paint			Length Paint	DATE	Length Paint	Lei	igth int	
	Time			Time			Time		_	Time		Time	Tir		
Part Flow Par	rt Flow <b>F</b>	RI=>T		Part Flow <b>F</b>	RI=>T		Part Flow	RI=>T		Part Flow OUT		Part Flow BL-LC=>		Flow BL-LC=>T	
MACH M	ЛАСН			MACH			MACH			MACH		MACH	MA	CII	
	BOM			BOM			BOM			BOM		BOM	BC	M	
Main Part TENSION BRACKET MOUNT PLATE Mai	ain Part <b>L</b>	ONG RIB TU		Main Part W	VHEEL MOUNT	BLOCK	Main Part	TOP PLATE		Main Part CENTER TUBE		Main Part ST CABLE TRO	JGH Mair	Part LARGE TUBE	E CAP
	ub Part	(00400400A		Sub Part	(00400400	0.77	Sub Part	V/00400440A	107/10/11	Sub Part	444 07/ 0 /	Sub Part	Sub	Part   V20106112A	07/1/04
	NG NO Y lat Size	′20196108A	QIY   2 /M	DWG NO Y Mat Size	/20196109-	QIY   <b>2</b> /N	MDWG NO Mat Size	Y20196110A	QIY   <b>2</b> /M	DWG NO   <b>Y 201961</b>   Mat Size	11A QTY 3 /N	MDWG NO   <b>Y201961</b>	2A QTY 2 /MDWG		QIY   4 /M
	ength		DATE	Length		DATE	Length		DATE	Length	DATE	Length		igth	DATE
	Paint		-	Paint			Paint		7	Paint		Paint		int	-
	Time			Time			Time		•	Time	•	Time	Tir		•
Part Flow BL-LC=>T Par	rt Flow <b>F</b>	RI=>T		Part Flow <b>E</b>	BL-LC		Part Flow	OUT		Part Flow RI=>T		Part Flow BL-LC=>	T=>B Part	Flow BL-LC	
	ЛАСН			MACH			MACH			MACH		MACH	MA		
BOM BOM BAIN Part IDLER TUBE Main Part IDLER TUBE	BOM	ENGIONED	BDV-KET	BOM Main Part M	OTOR SUPF		BOM Main Part	MOTOR MOUNT PLAT	TE	BOM Main Part <b>TENSIO</b>	JTΔR	BOM Main Part LONG TU	BF 3	OM Part FB MOTOR MO	NINT DI ATE
Sub Part Sul	ub Part	LINSIONER		Sub Part			Sub Part			Sub Part		Sub Part	Sub	Part	
DWG NO Y20196114A QTY 1 /MDW	NG NO Y	/20196115-	QTY <b>2</b> /M	DWG NO Y	′20196116-		DWG NO	Y20196117A		DWG NO Y201961		MDWG NO Y201961	<b>19-</b> QTY <b>2</b> /MDWG	NO Y20196121-	
5.475	lat Size		INIT/ DATE	Mat Size		INIT/ DATE	Mat Size		INIT/ DATE	Mat Size	INIT/ DATE	Mat Size	INIT/ Mat		INIT/ DATE
Length	ength Paint			Length Paint		·· <del>-</del>	Length Paint			Length Paint		Length Paint	Lei	igth int	
	Time			Time			Time			Time		Time	Fa		
1		BL-LC=>T		Part Flow C	DUT			BL-LC=>PF		Part Flow BL-LC		Part Flow RI=>T		Flow BL-LC=>T	
														•	

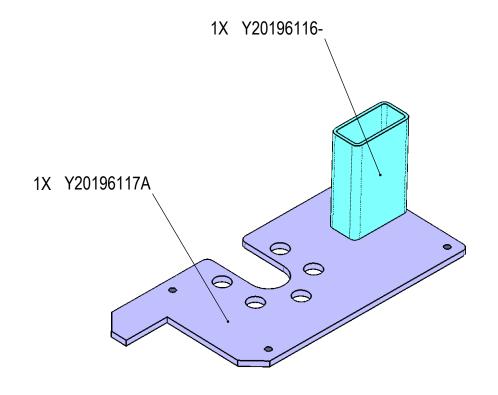
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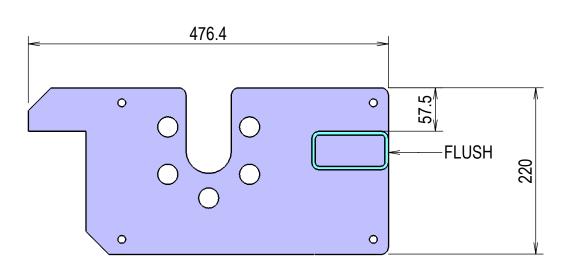
Metal Fabrication Machine Model Process Inst Nar		Name	Pro	ocess Inst No	0.	REV. DATE PREPAREI			BY: Leon Jiang	PAGE			
Proces	ss Instruction	AMS4020CL		SUCTION TRA	V FRAME	HW	-Y201961 <i>F</i>	4	OI	07/31/19	APPROVED	BY: Caesar M	2/11
MACH	MACH		MACH		MACH		MACH			MACH		MACH	•
BOM	BOM		BOM	A OLICET OLICOST	BOM		BOM			BOM		BOM	
Main Part PILLO	OW BLOCK PLATE Main Pa	art DUAL SPROCKET PLATE	Main Part BR	ACKET GUSSET	Main Part E (	CHAIN SUPPORT F		EXT WHEEL MO				Main Part	
Sub Part	Sub Pa	o V2010C122	Sub Part	0406404   071/   4 /h	Sub Part	0040640E   OTV	Sub Part	V20406426	OTV 1 / 1	Sub Part	OTV /A	Sub Part	OTV /NA
Mat Size	NIT/ Mat Siz	O Y20196123- QTY 2 /N	Mat Size	<u>.0190124-   QTY   4 /N</u>   INIT/	Mat Size	20190125- QTY INIT/	Mat Size	120190120-	INIT/	Mat Size	QTY /N	DWG NO Mat Size	QTY /M
Length	DATE		Length	DATE	Length	DATE	Length		DATE	Length	DATE	Length	DATE
Paint	Paint		Paint		Paint		Paint		1	Paint		Paint	_
Time	Time		Time	I	Time		Time			Time		Time	
Part Flow BL-LC	C=>PF Part Flo	w BL-LC=>PF	Part Flow BL	LC	Part Flow BI	LC=>T		BL-LC=>PF		Part Flow		Part Flow	
MACH	MACH		MACH		MACH		MACH			MACH		MACH	
BOM	BOM		BOM		BOM		BOM			BOM		BOM	
Main Part	Main Pa		Main Part		Main Part		Main Part			Main Part		Main Part	
Sub Part	Sub Pa		Sub Part		Sub Part		Sub Part			Sub Part		Sub Part	
DWG NO	QTY /M DWG N		DWG NO		DWG NO	QTY	/M DWG NO			DWG NO		DWG NO	QTY /M
Mat Size	INIT/ Mat Siz	B + FF	Mat Size	INIT/ DATE	Mat Size	INIT/	Mat Size		INIT/	Mat Size	INIT/ DATE	Mat Size	INIT/
Length	DATE		Length	DATE	Length	DATE	Length		DATE	Length	DATE	Length	DATE
Paint	Paint		Paint		Paint		Paint			Paint		Paint	
Time	Time		Time		Time		Time			Time		Time	
Part Flow	Part Flo	ow	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 Sub Part	Main Pa Sub Pa		Main Part Sub Part		Main Part Sub Part		Main Part Sub Part			Main Part Sub Part		Main Part Sub Part	
DWG NO	QTY /M DWG N		DWG NO	QTY /M	1DWG NO	QTY	/MDWG NO			DWG NO	QTY /N	DWG NO	QTY /M
Mat Size	INIT/ Mat Siz		Mat Size	INIT/	Mat Size	INIT/	Mat Size			Mat Size	INIT/	Mat Size	INIT/
Length	DATE Lengtl	5.475	Length	DATE	Length	DATE	Length		DATE	Length	DATE	Length	DATE
Paint	Paint		Paint		Paint		Paint			Paint		Paint	
Time	Time	-	Time		Time		Time			Time	·	Time	
Part Flow	Part Flo	ow	Part Flow		Part Flow		Part Flow			Part Flow		Part Flow	
											If thi this i	s stamp is not in RI s NOT a CONTRO DOCUMENT	ED INK DLLED
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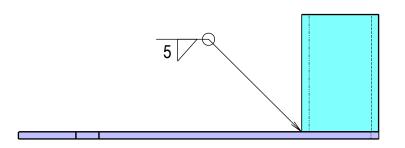


Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE	
Process Instruction	AMS4020CL	SUCTION TRAV FRAME	HW-Y201961A	OI	07/31/19	APPROVED BY: Caesar M	4/11	

## SUB WELDMENT 1







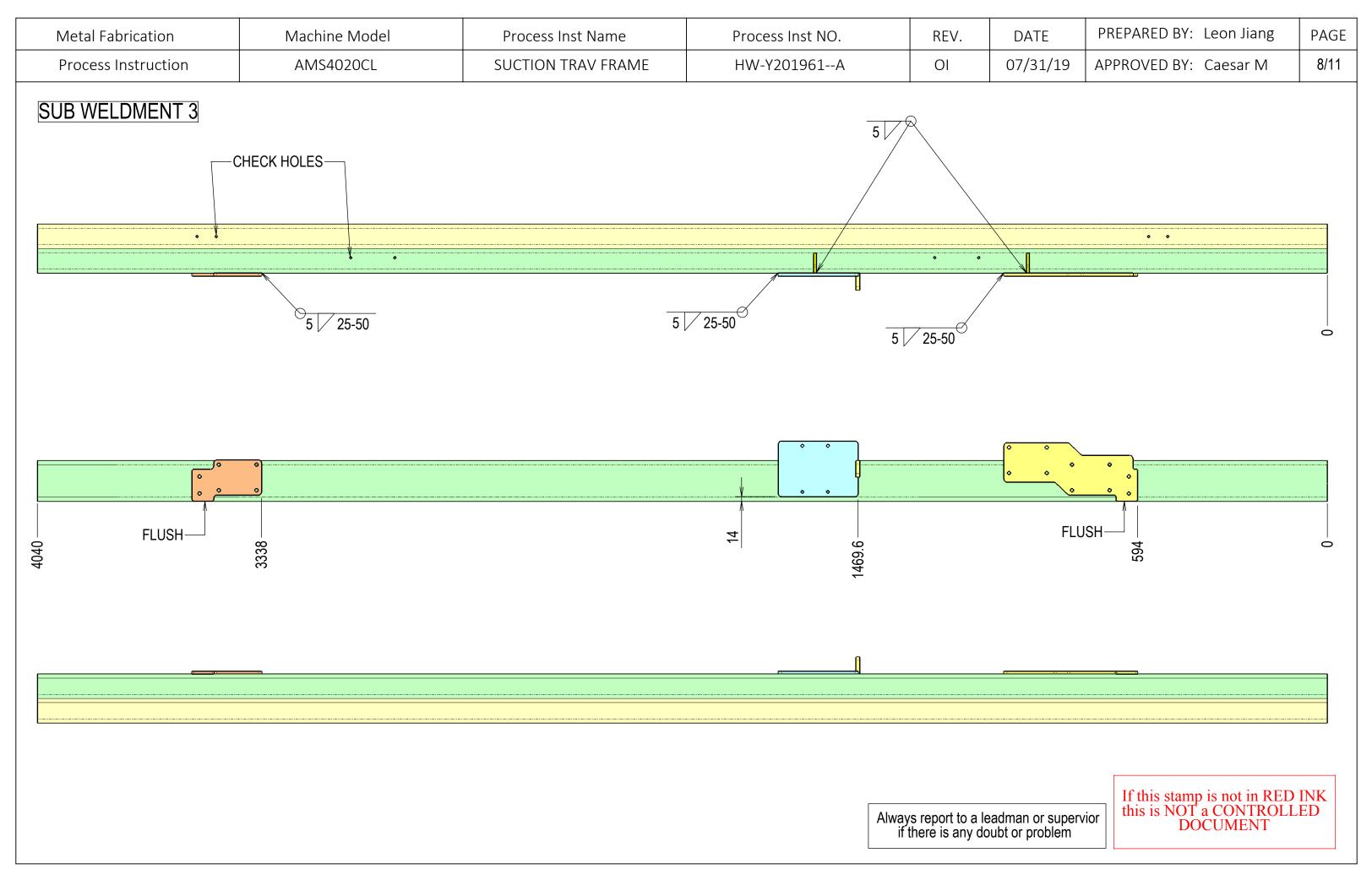
Always report to a leadman or supervior if there is any doubt or problem

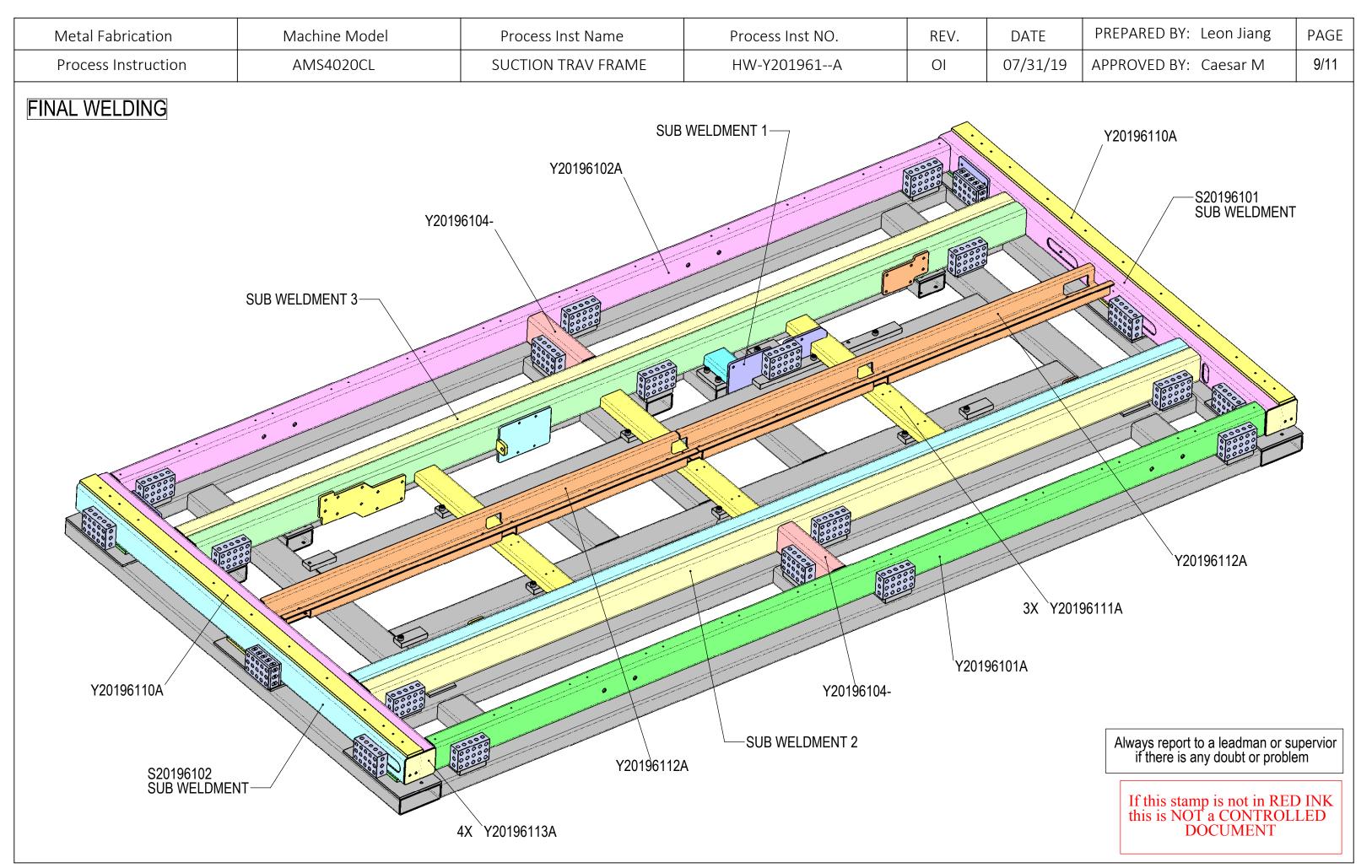
If this stamp is not in RED INK this is NOT a CONTROLLED DOCUMENT

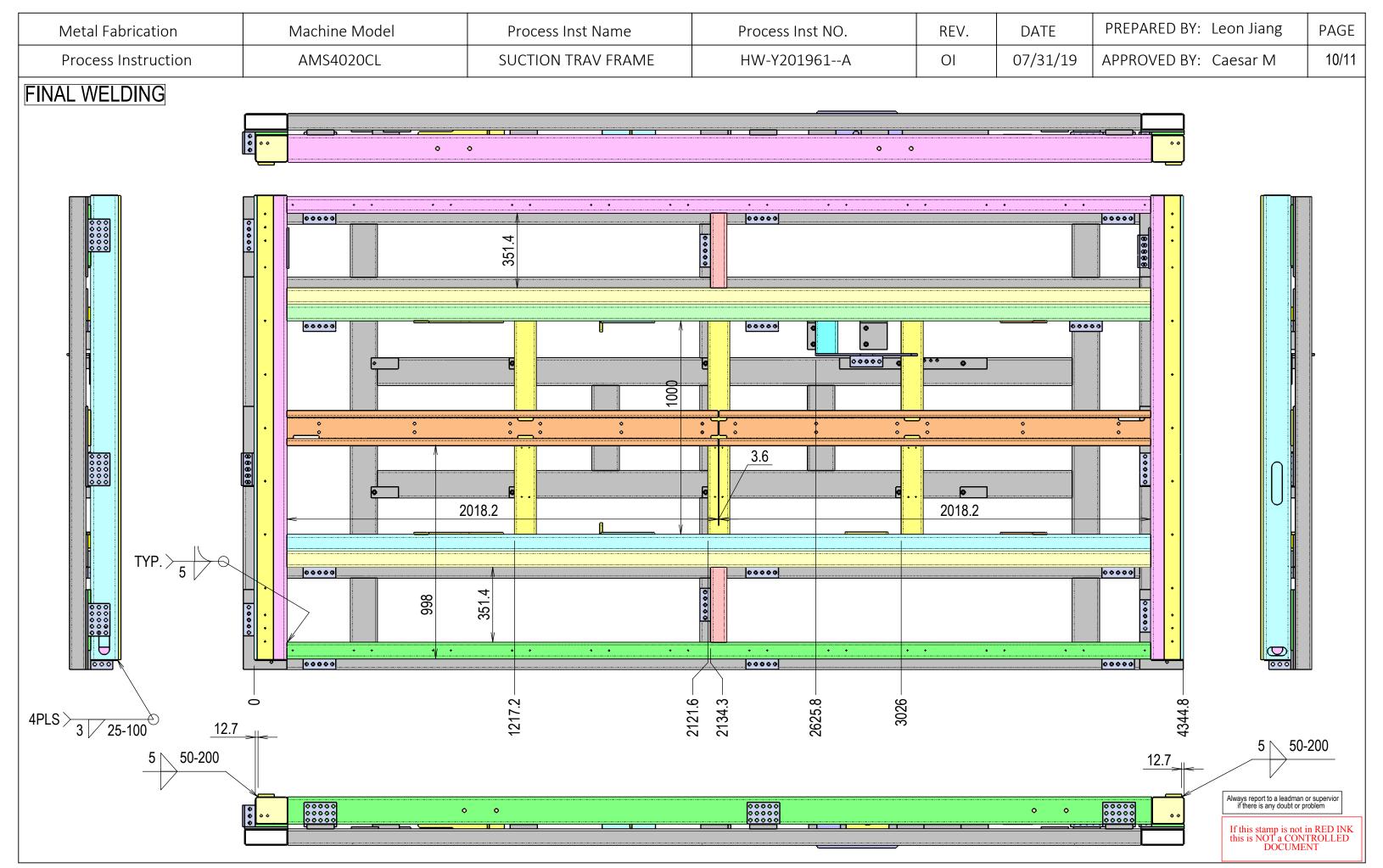
Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon	Jiang PAGE
Process Instruction	AMS4020CL	SUCTION TRAV FRAME	HW-Y201961A	OI	07/31/19	APPROVED BY: Caes	ar M 5/11
SUB WELDMENT 2							'
OOD WEEDINEIT E	Y2 <sup>-</sup>	0196123-					
Always report to a leadman or sur if there is any doubt or probler		Y20196118-	96107- Y20196119- 2X Y20196124		Y20196105-		
If this stamp is not in RED I this is NOT a CONTROLLE DOCUMENT	∃ <b>D</b>						

Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	SUCTION TRAV FRAME	HW-Y201961A	OI	07/31/19	APPROVED BY: Caesar M	6/11
SUB WELDMENT 2							
		$\widehat{\mathbb{A}}$					
CUECK HOLES	5						
CHECK HOLES	933.2	1599.6					4040
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	FLUCIA	4	^			FLUSH	
- 0	FLUSH	1469.6 -	41			3338	
		<del>4</del>	56				
			· ·	П			
			Alwa	ve report to a loc	dman or supervier	If this stamp is not in RED I this is NOT a CONTROLLE DOCUMENT	NK ED
			if	there is any dou	dman or supervior bt or problem	DOCUMENT	

Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY:	Leon Jiang	PAGE
Process Instruction	AMS4020CL	SUCTION TRAV FRAME	HW-Y201961A	OI	07/31/19	APPROVED BY:	Caesar M	7/11
Y20196119-	Y20196105-	Y20196107- 2X Y20196124-	Y20196118-	0196123-	Y20196103A			
						Always report to if there is any	a leadman or su y doubt or proble	pervior m
						If this stamp this is NOT DO	p is not in RED a CONTROL CUMENT	D INK LED







Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	SUCTION TRAV FRAME	HW-Y201961A	Ol	07/31/19	APPROVED BY: Caesar M	11/11

