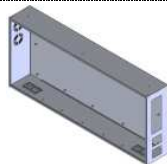

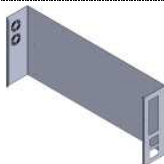
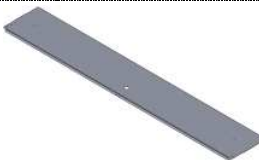
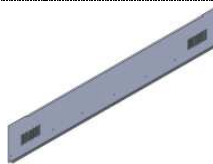
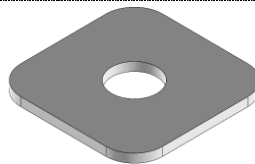

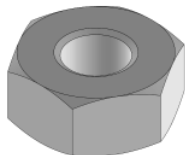
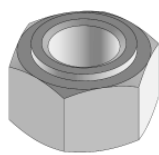
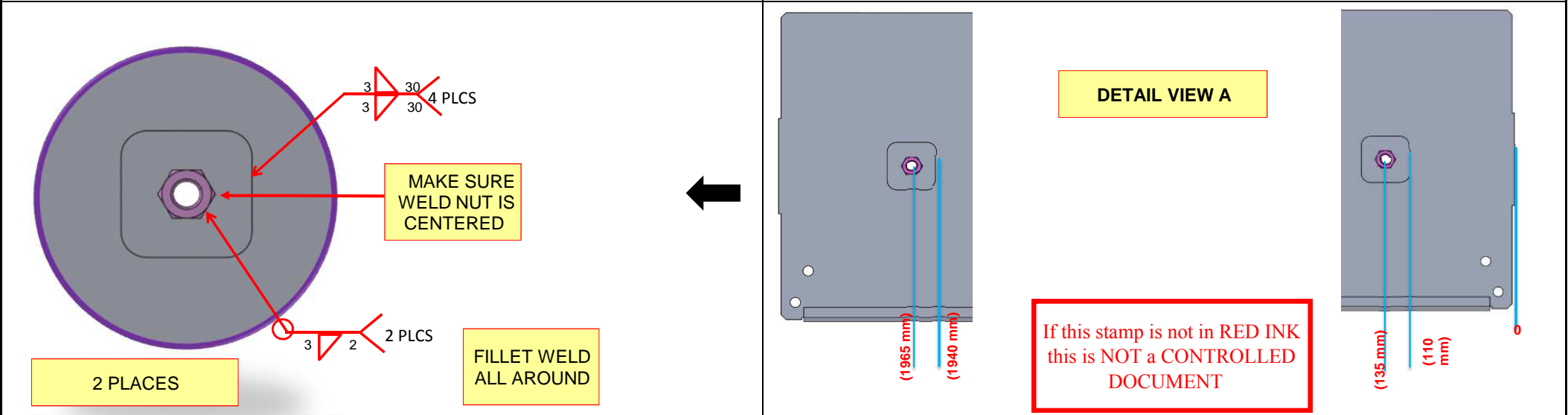
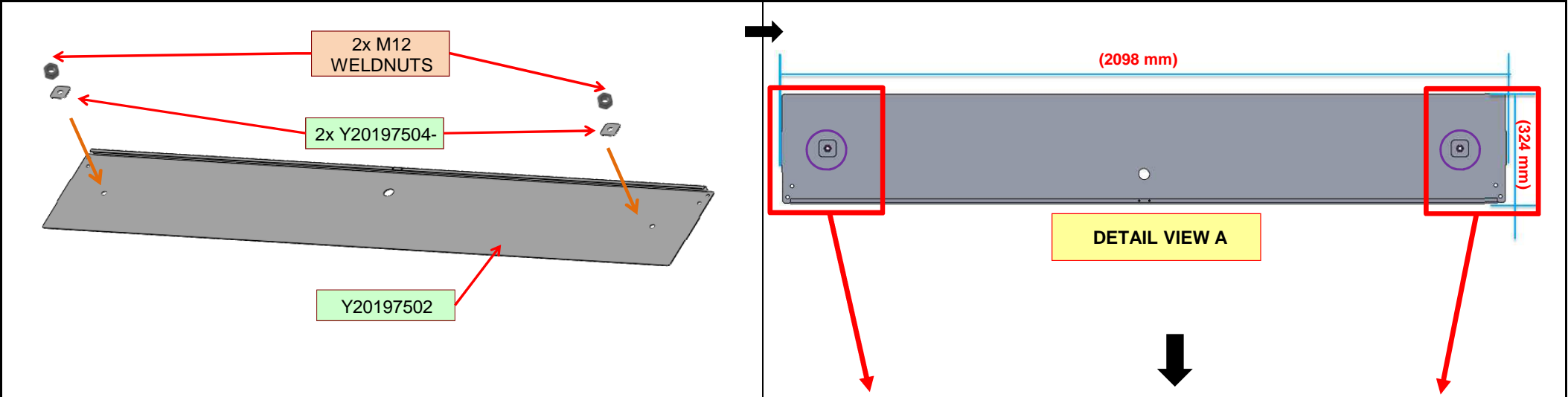


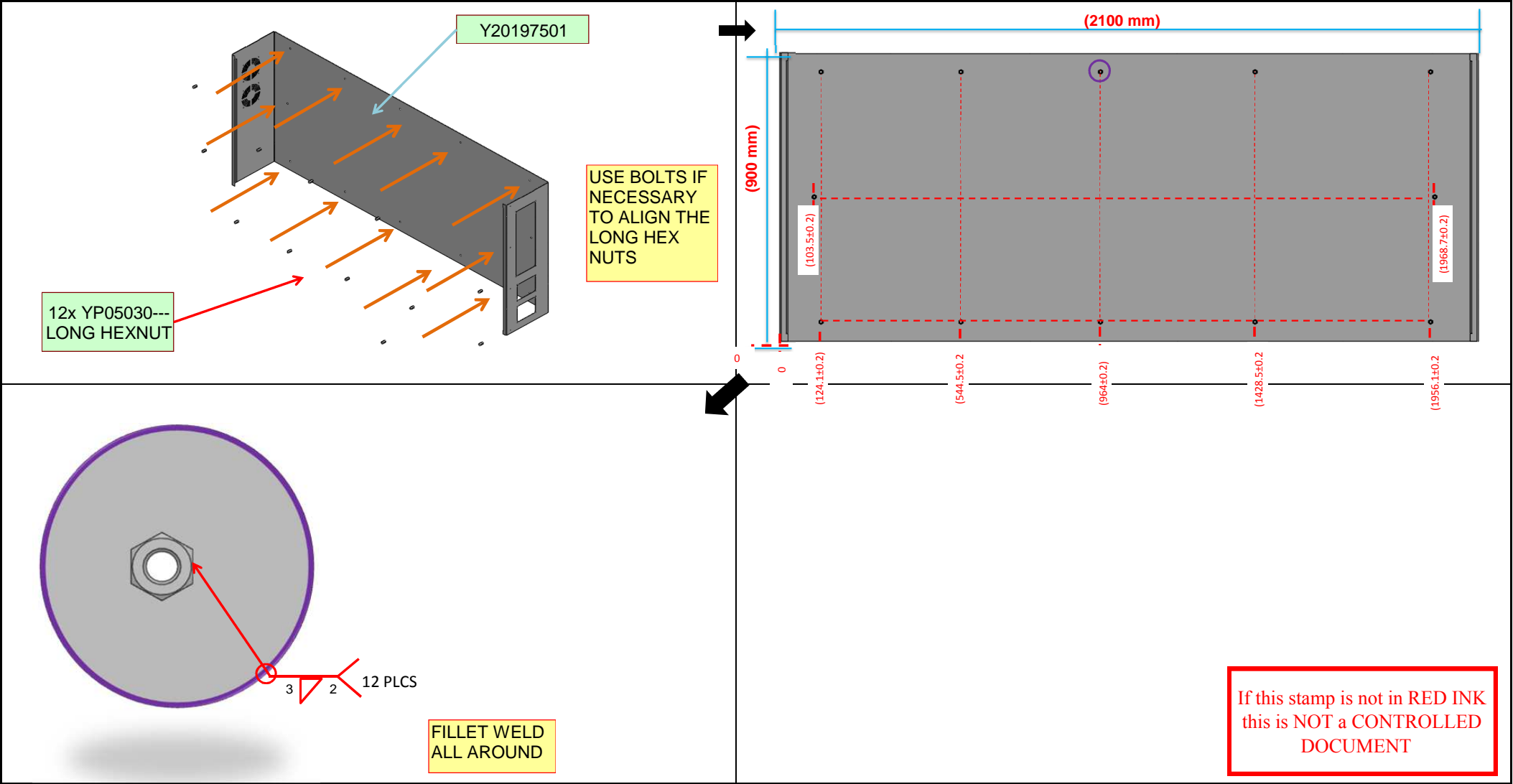
METAL FABRICATION				MACHINE MODEL				WELDMENT NAME				DRAWING NO.		REV	DATE		PREPARED BY F.R (7/09/2019)				Page 1/7						
PROCESS INSTRUCTIONS				AMS4020CL				CONTROL BOX WELDMENT				LW-Y201975--A		AOI	7/9/2019		APPROVED BY C.R.M(7/09/2019)										
Mach	AMS4020CL			Mach	AMS4020CL			Mach	AMS4020CL			Mach	AMS4020CL			Mach	AMS4020CL			Mach	AMS4020CL						
Bom	Y201975--A Control Box Weldment			Bom	Y20176802- FILTER BRACKET			Bom	Y20197501A Back Box			Bom	Y20197502A Box Top			Bom	Y20197503A Bottom Box			Bom	Y20197504- Nut Plate			Bom	YP05030--- NTFL8-25 HEX NUT		
Main Part	CONTROL BOX WELDMENT			Main Part	CONTROL BOX WELDMENT			Main Part	CONTROL BOX WELDMENT			Main Part	CONTROL BOX WELDMENT			Main Part	CONTROL BOX WELDMENT			Main Part	CONTROL BOX WELDMENT			Main Part	NTFL8-25 HEX NUT		
Sub Part				Sub Part	FILTER BRACKET			Sub Part	BACK BOX			Sub Part	BOX TOP			Sub Part	BOTTOM BOX			Sub Part	NUT PLATE			Sub Part	NTFL8-25 HEX NUT		
Dwg No.	Y201975--A			Dwg No.	Y20176802-			Dwg No.	Y20197501A			Dwg No.	Y20197502A			Dwg No.	Y20197503A			Dwg No.	Y20197504-			Dwg No.	YP05030---		
Mat size				Mat size	12.3			Mat size	13GA			Mat size	13GA			Mat size	13GA			Mat size	11GA			Mat size			
Length				Length	205 mm			Length	2100 mm			Length	2097.5 mm			Length	2095			Length	50 mm			Length			
Paint	Black Texture			Paint				Paint				Paint				Paint				Paint				Paint			
Time				Time				Time				Time				Time				Time				Time			
Part-Flow	LW-P-A			Part-Flow	SM/BL-LC-LW			Part-Flow	SM-LW			Part-Flow	SM-LW			Part-Flow	SM-LW			Part-Flow	SM/BL-LC-LW			Part-Flow	OUT-LW		
																											
Mach	AMS4020CL			Mach	AMS4020CL																						
Bom	Hex-1A-M8 Weld_Nut			Bom	Hex-1A-M12 Weld_Nut																						
Main Part	CONTROL BOX WELDMENT			Main Part	CONTROL BOX WELDMENT																						
Sub Part	WELD NUT			Sub Part	WELD NUT																						
Dwg No.	P332050002			Dwg No.	P332050003																						
Mat size	M8			Mat size	M12																						
Length				Length																							
Paint				Paint																							
Time				Time																							
Part-Flow	OUT-LW			Part-Flow	OUT-LW																						
																											

METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO	REV	DATE	PREPARED BY F.R. (7/09/2019)	Page 2/7
PROCESS INSTRUCTIONS	AMS4020CL	CONTROL BOX WELDMENT	LW-Y201975--A	AOI	7/9/2019	APPROVED BY C.R.M(7/09/2019)	



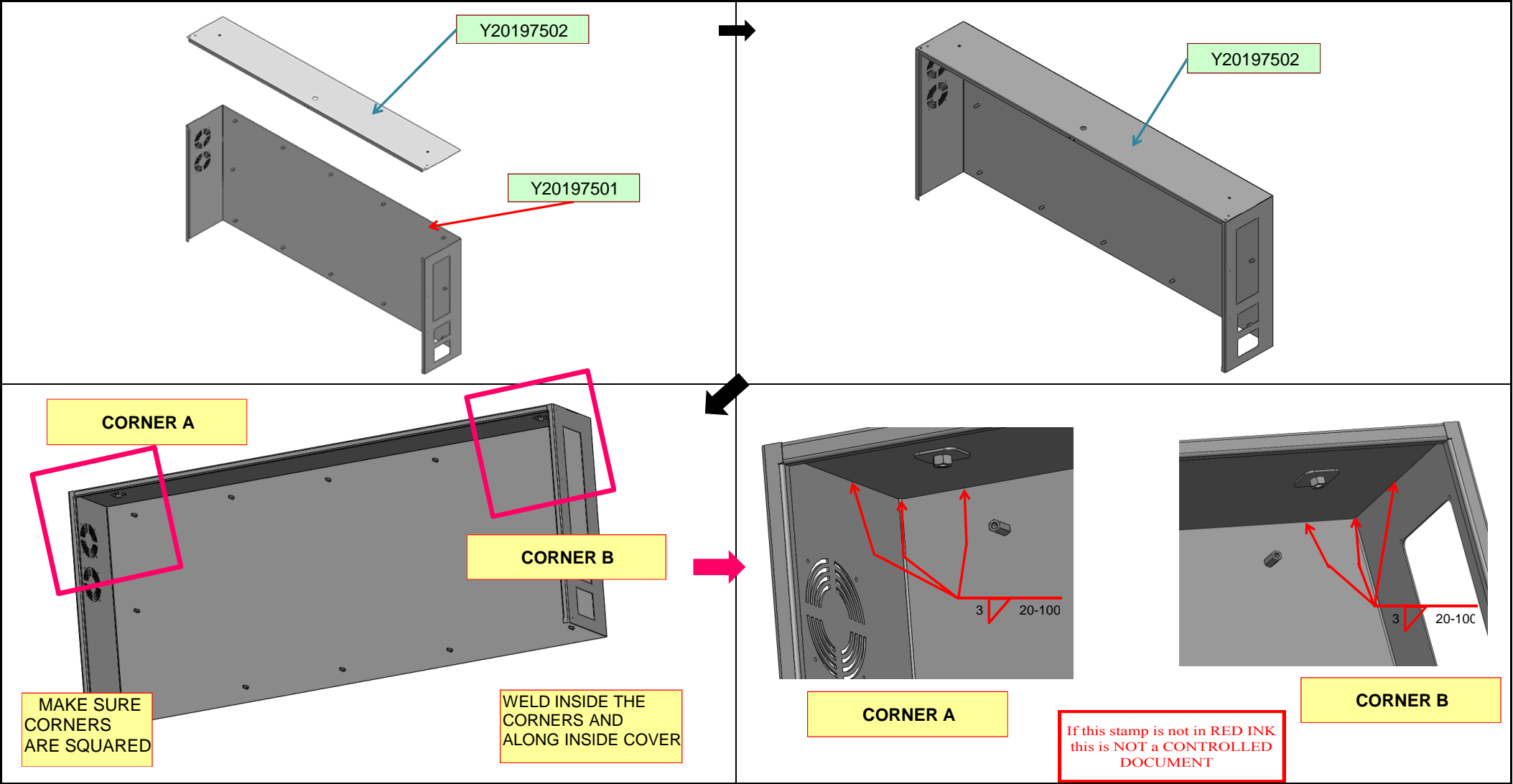
Always report to a leadman or supervisor if there is any doubt or problem.

METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO	REV	DATE	PREPARED BY F.R. (7/09/2019)	Page 4/7
PROCESS INSTRUCTIONS	AMS4020CL	CONTROL BOX WELDMENT	LW-Y201975--A	AOI	7/9/2019	APPROVED BY C.R.M(7/09/2019)	



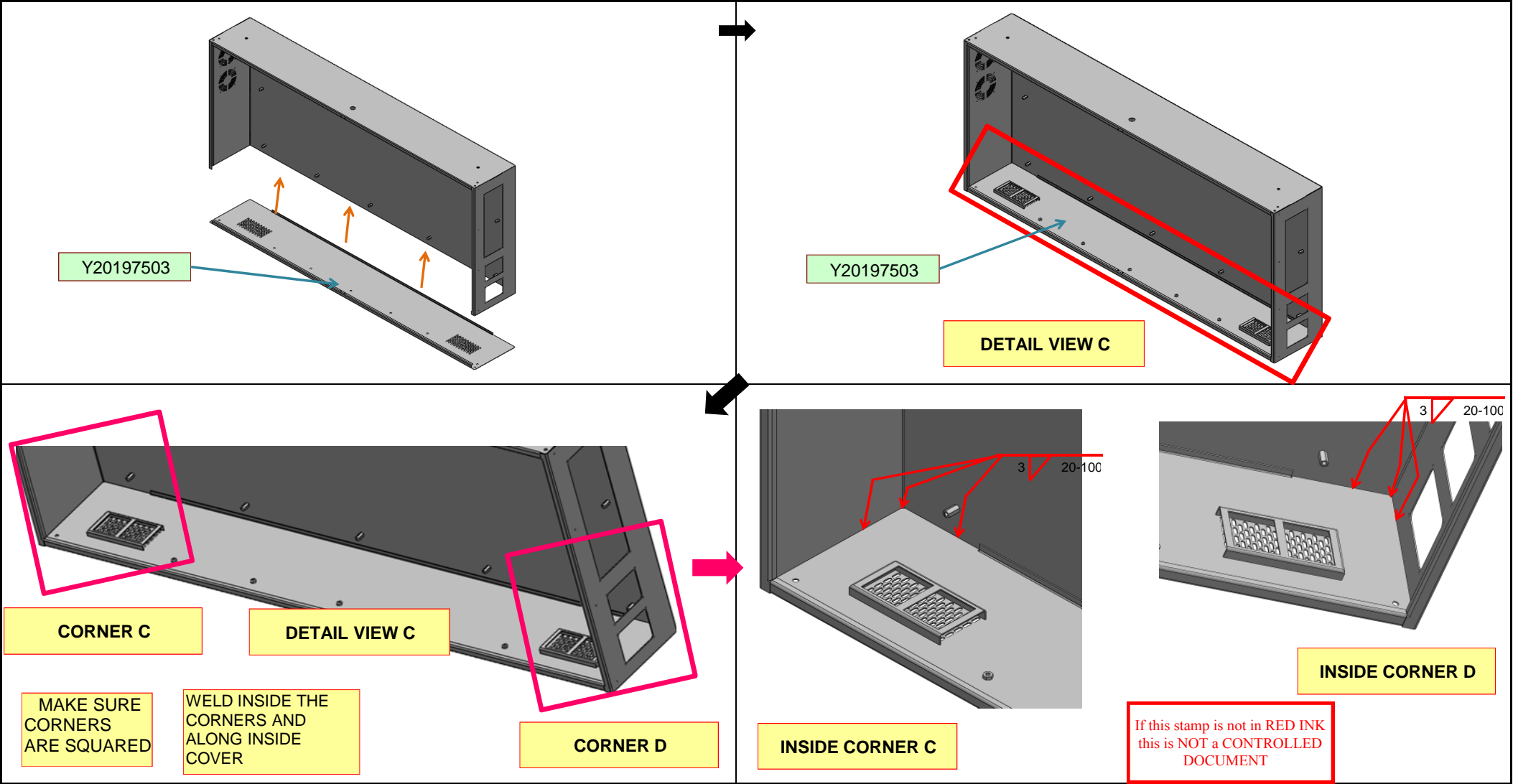
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METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO	REV	DATE	PREPARED BY F.R. (7/09/2019)	Page 5/7
PROCESS INSTRUCTIONS	AMS4020CL	CONTROL BOX WELDMENT	LW-Y201975--A	AOI	7/9/2019	APPROVED BY C.R.M(7/09/2019)	



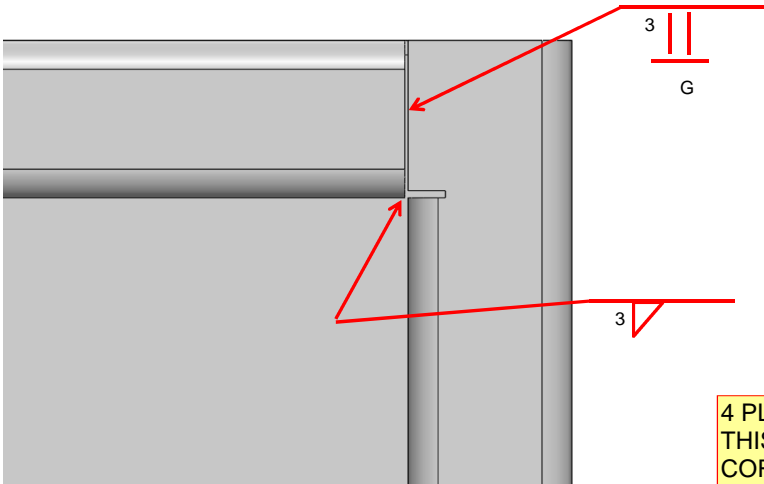
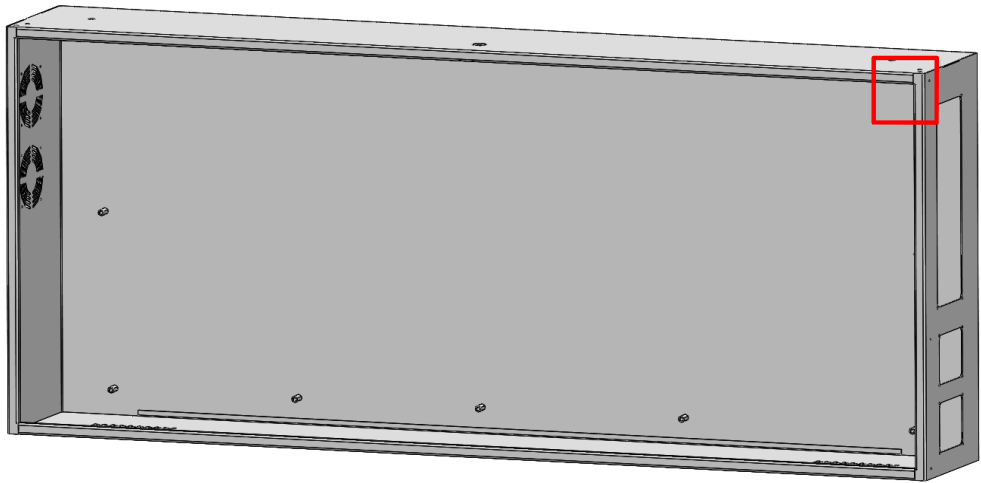
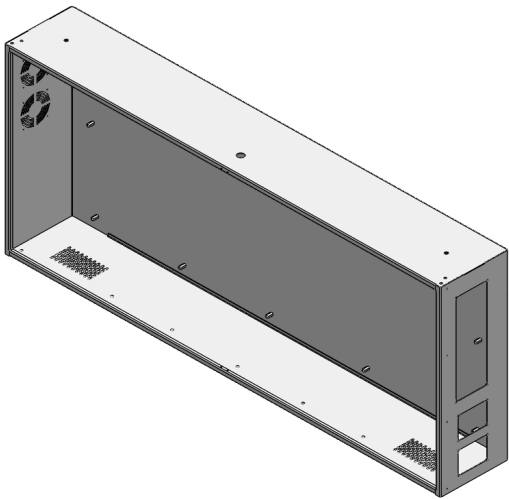
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METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO	REV	DATE	PREPARED BY F.R. (7/09/2019)	Page 6/7
PROCESS INSTRUCTIONS	AMS4020CL	CONTROL BOX WELDMENT	LW-Y201975--A	AOI	7/9/2019	APPROVED BY C.R.M(7/09/2019)	



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if there is any doubt or problem.

METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO	REV	DATE	PREPARED BY F.R. (7/09/2019)	Page 7/7
PROCESS INSTRUCTIONS	AMS4020CL	CONTROL BOX WELDMENT	LW-Y201975--A	AOI	7/9/2019	APPROVED BY C.R.M(7/09/2019)	



BUTT WELD
AND FINISH
GRIND

4 PLACES; DO
THIS FOR ALL 4
CORNERS

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