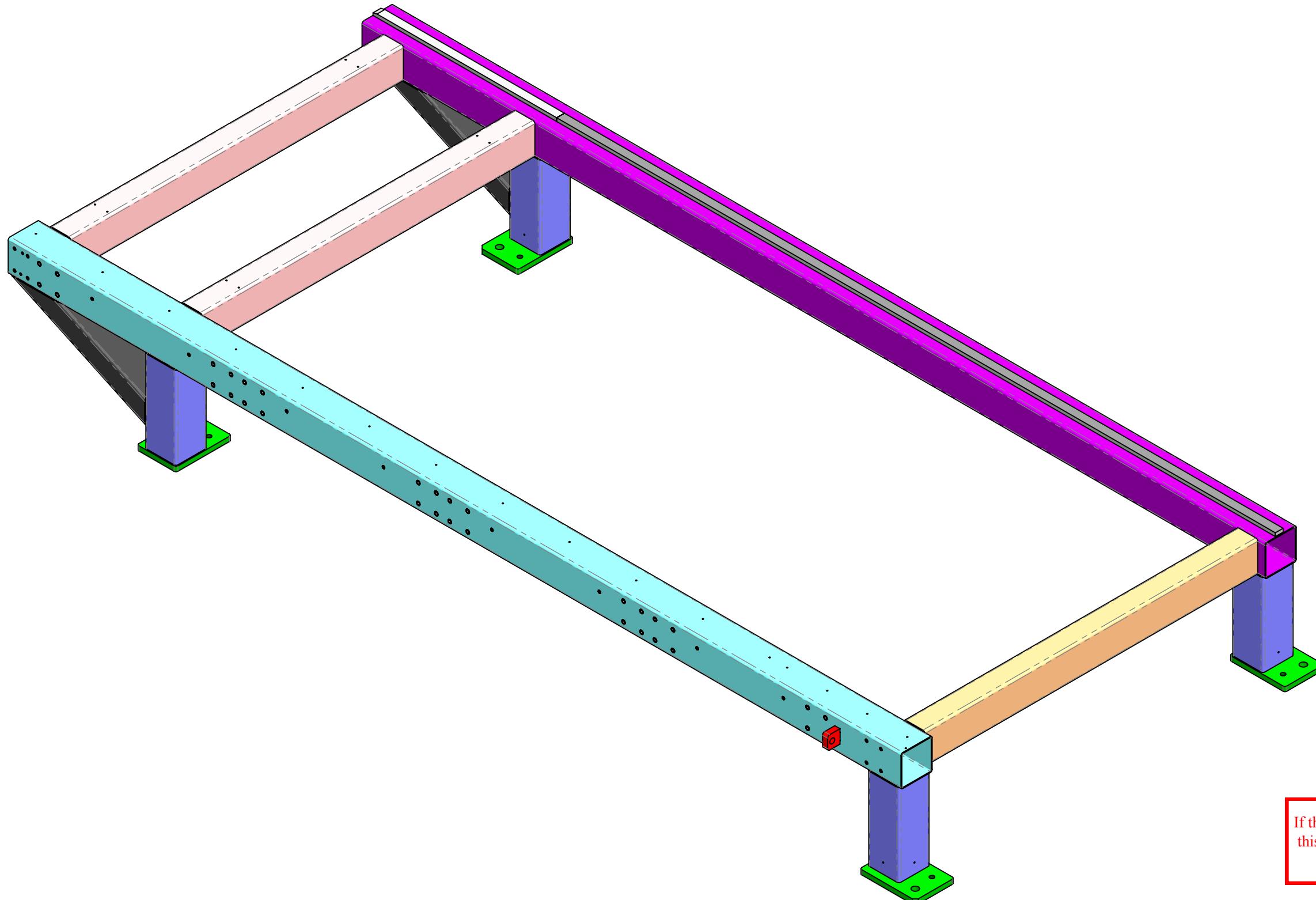
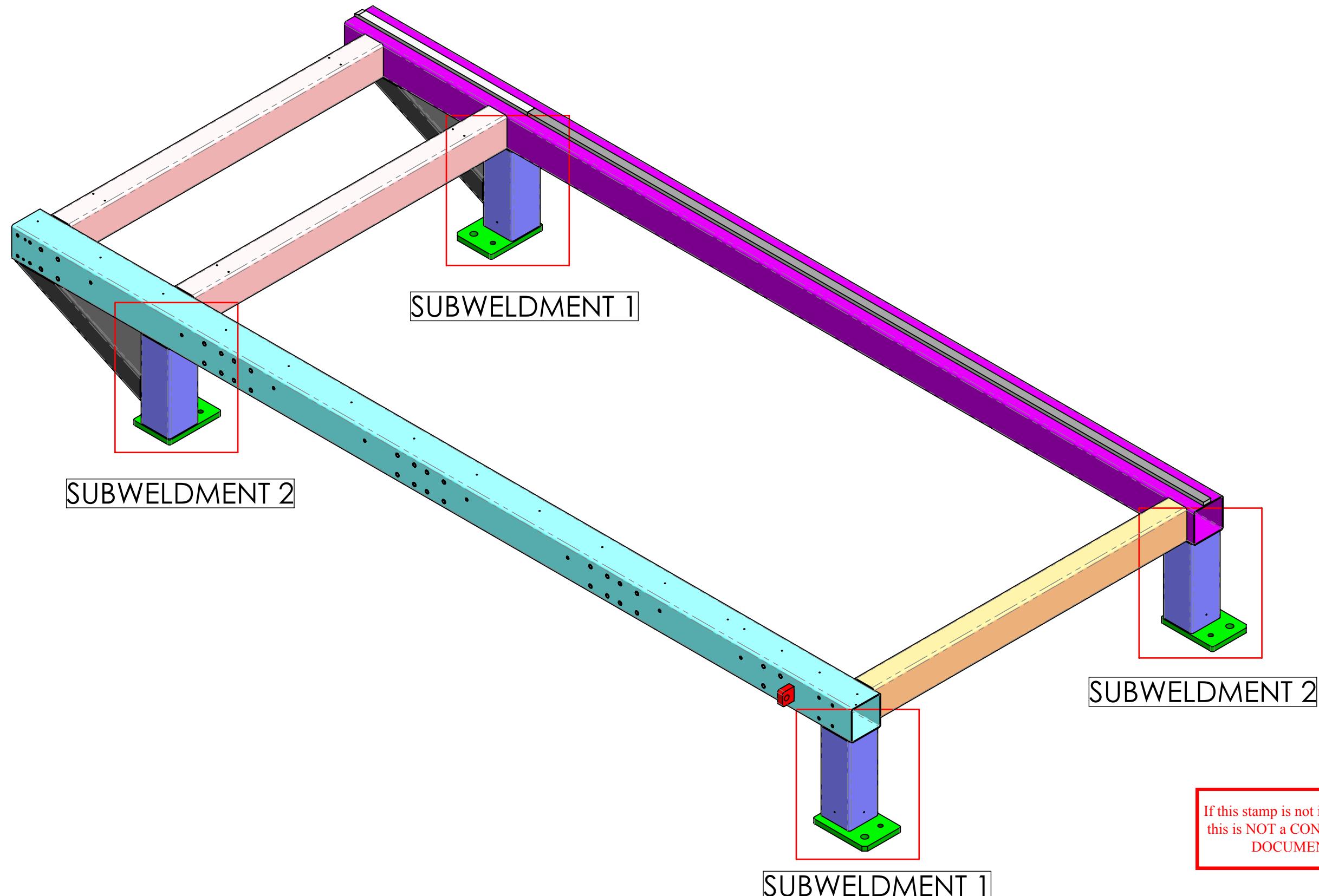


METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY JD	PAGE
PROCESS INSTRUCTIONS	AMS3015 LOS	LOS FRAME WELDMENT ASSY	Y202126---	OI	3/9/2019	APPROVED BY CRM	COVER

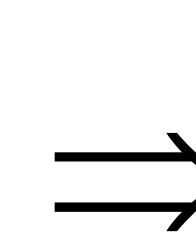
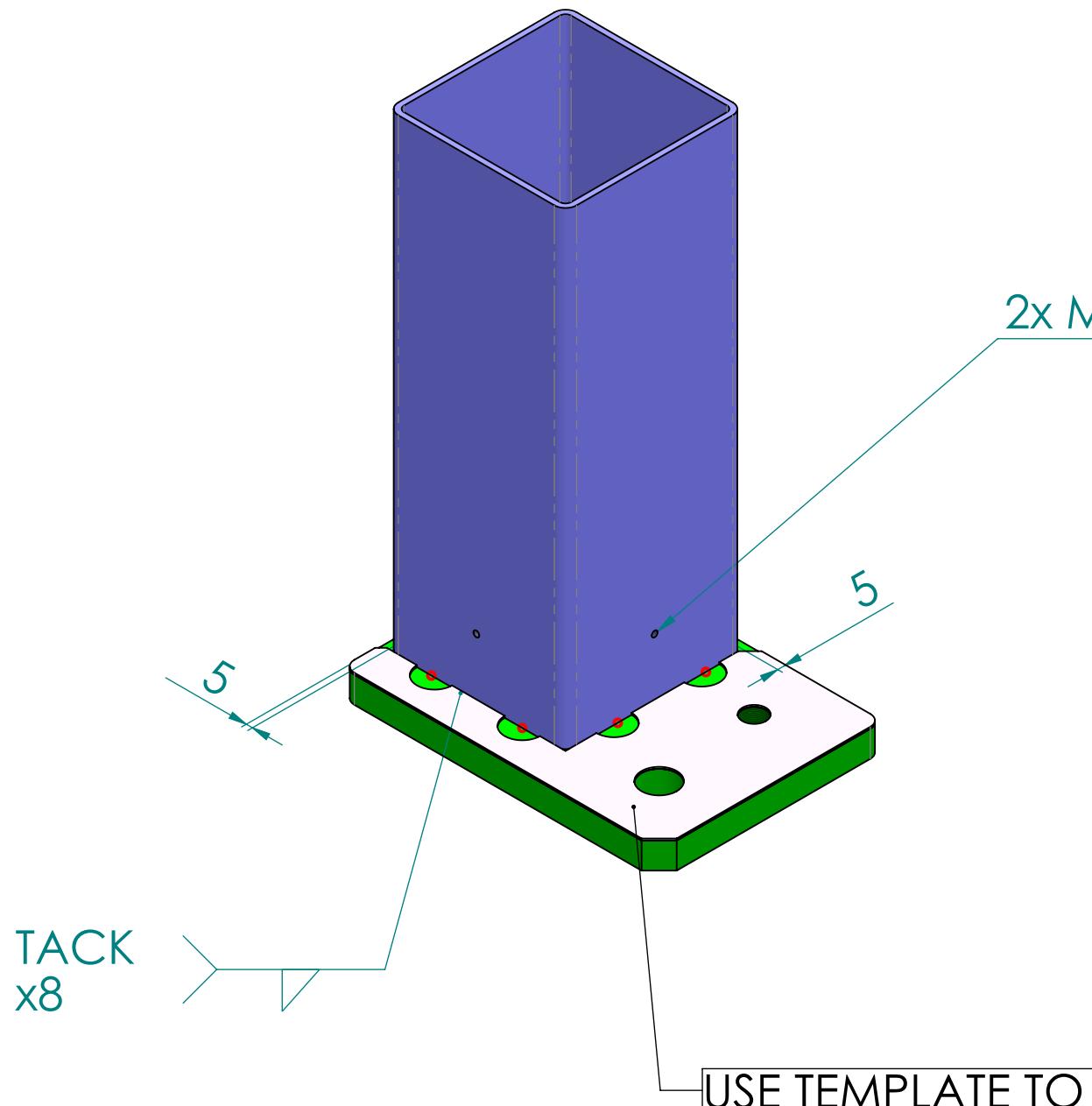


METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY JD	APPROVED BY CRM	PAGE 1/6
PROCESS INSTRUCTIONS	AMS3015 LOS	LOS FRAME WELDMENT ASSY	Y202126---	OI	3/9/2019			



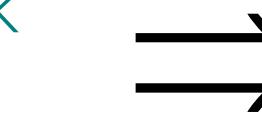
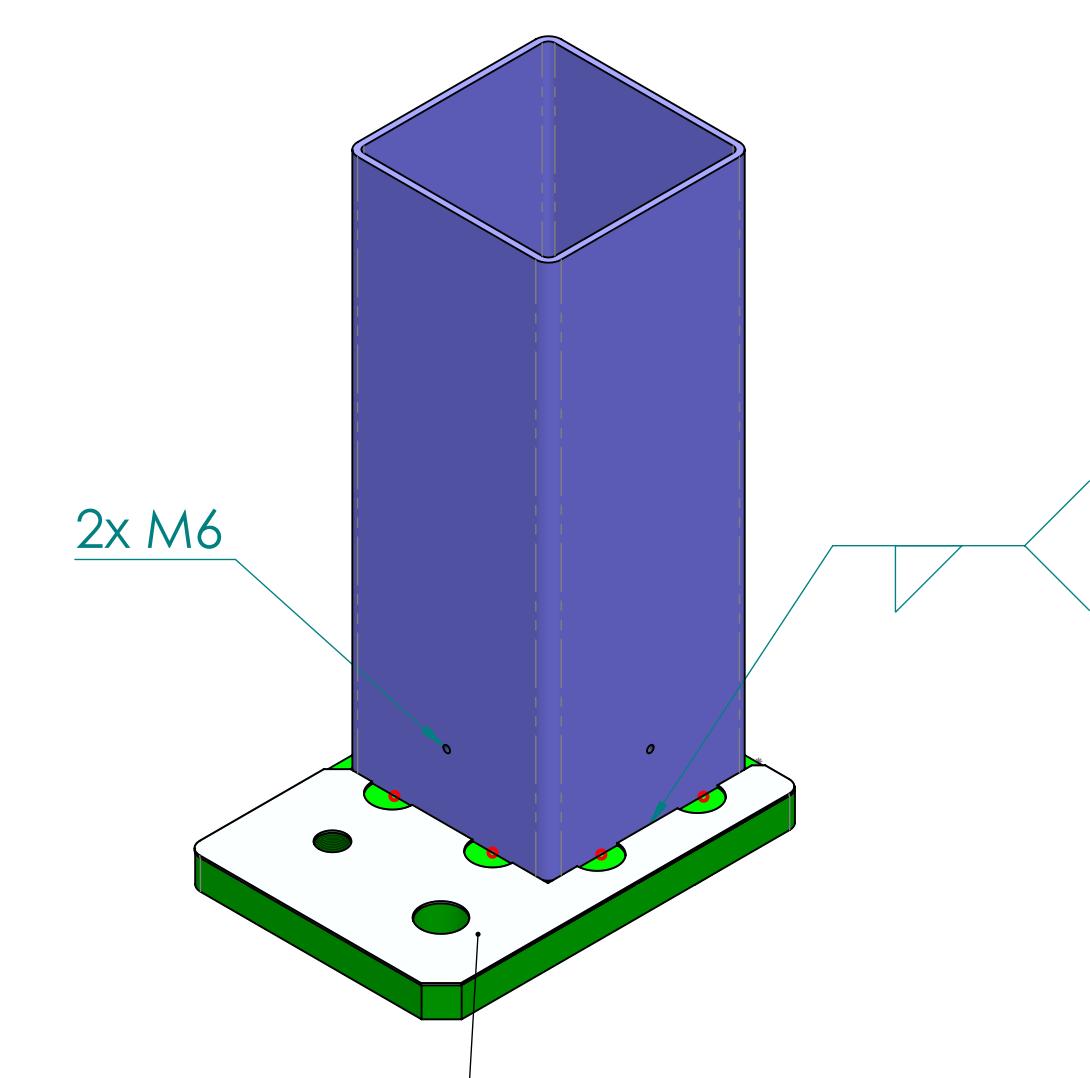
METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY <i>J.D.</i>	PAGE 2/6
PROCESS INSTRUCTIONS	AMS3015 LOS	LOS FRAME WELDMENT ASSY	Y202126---	O1	3/8/2019	APPROVED BY <i>CRM</i>	

POSITION PARTS AS SHOWN, TAKING NOTE OF TAPPED HOLES AND PLATE CHAMFER LOCATION  
TACK WITH TEMPLATE THEN FILLET WELD ALL AROUND

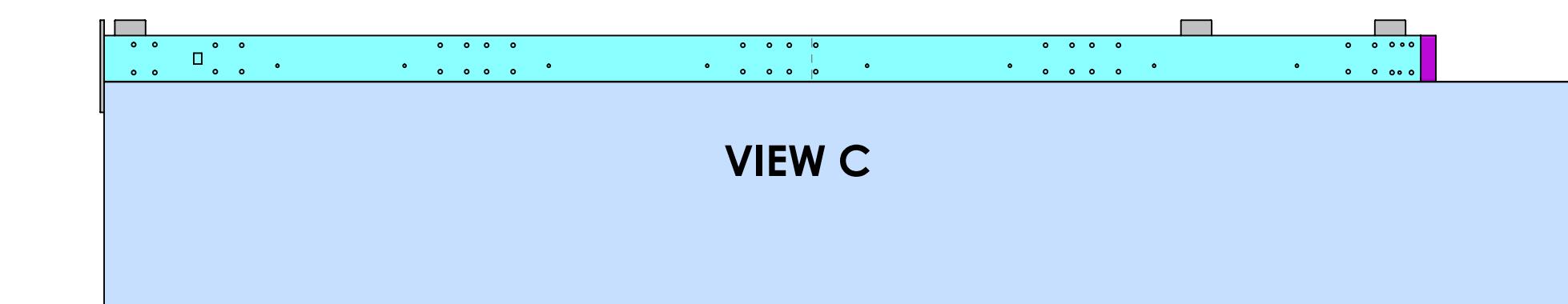
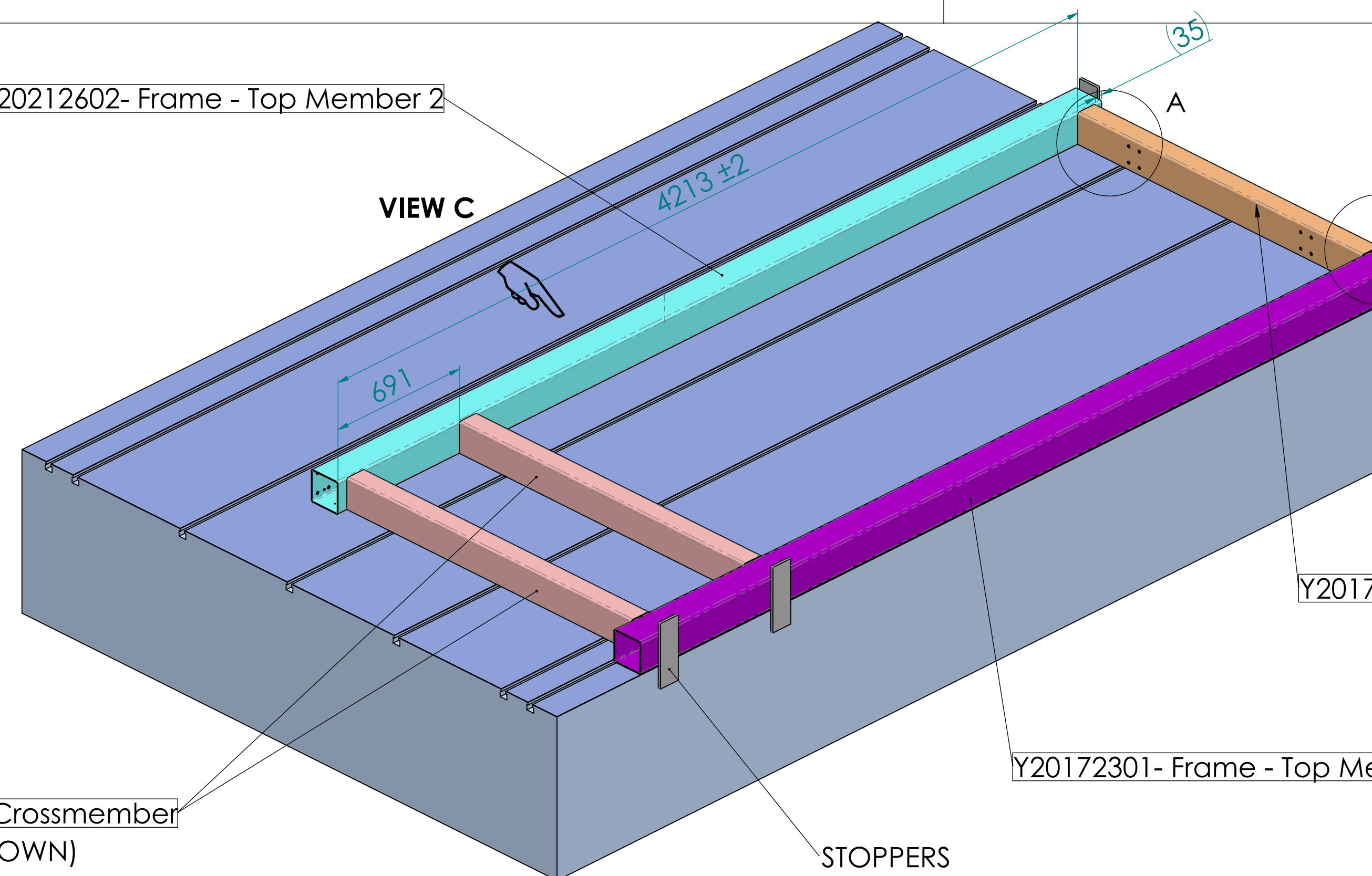
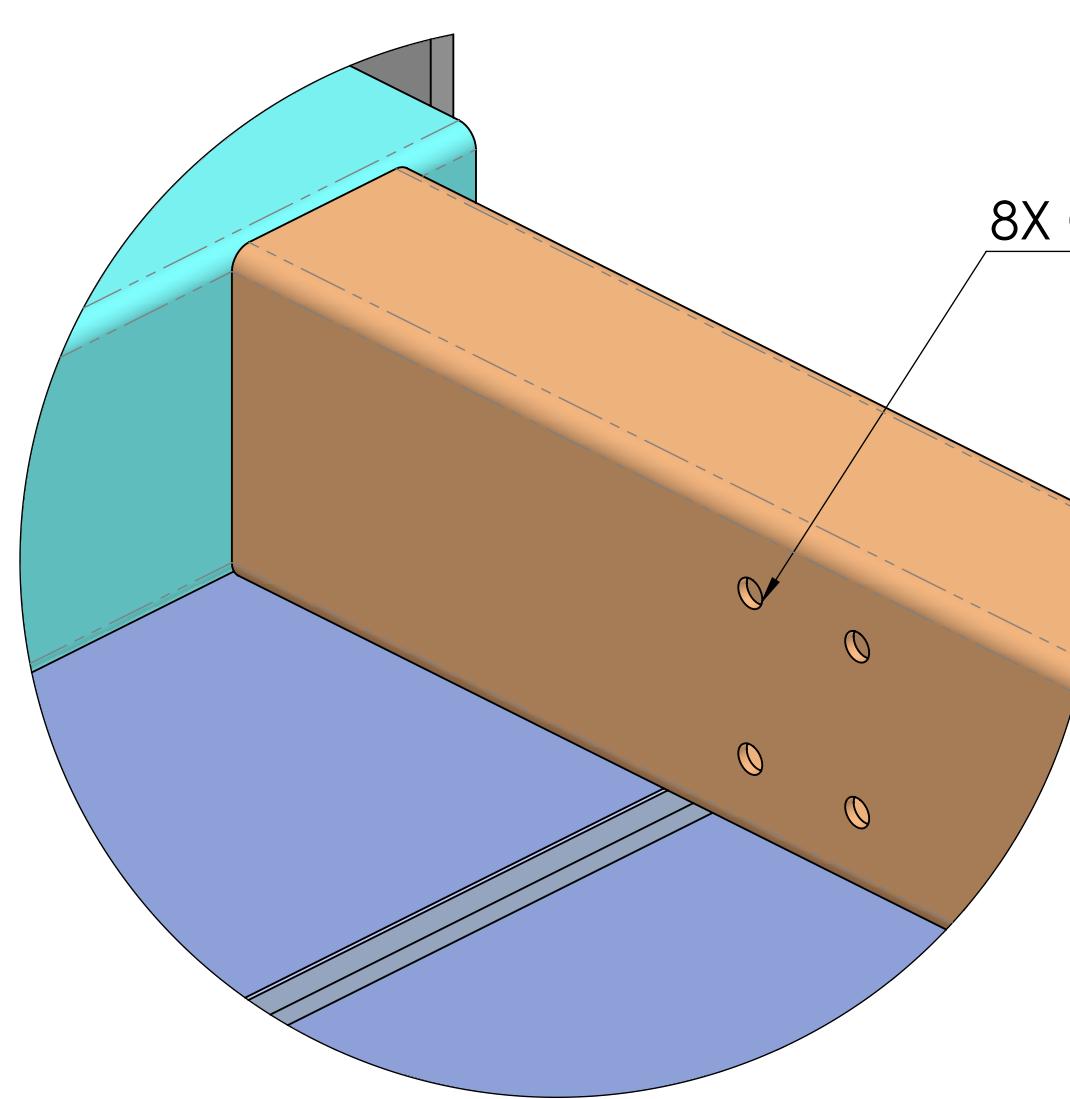


x2

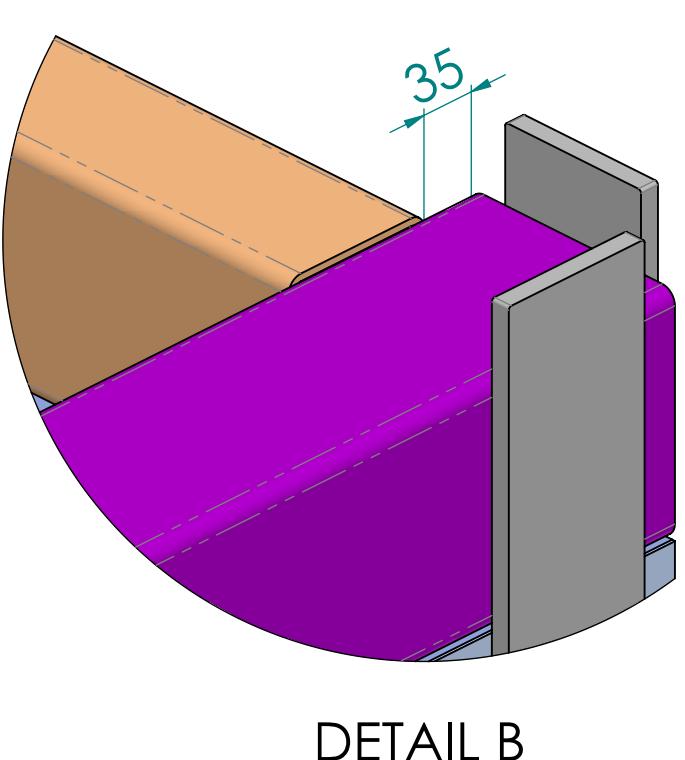
CREATE OPPSITE SIDE LEG BY POSITIONING SAME PARTS AS SHOWN



x2

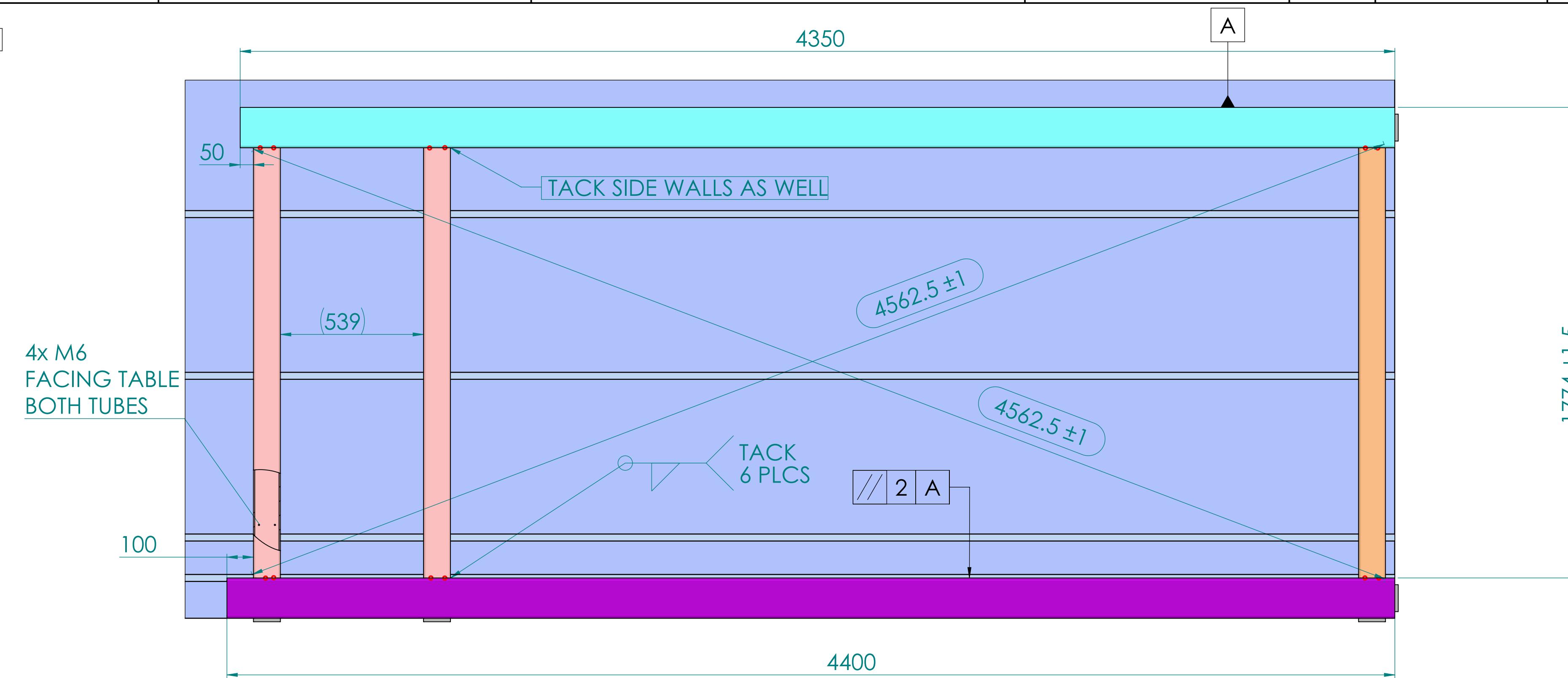


If this stamp is not in RED INK  
this is NOT a CONTROLLED  
DOCUMENT

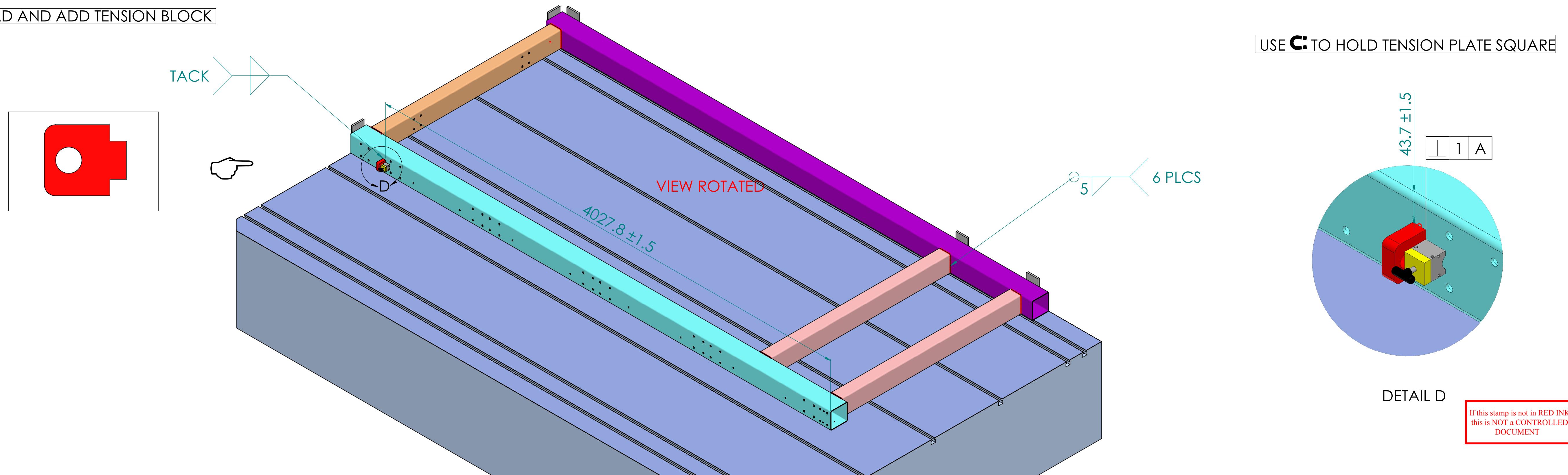


METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	APPROVED BY <i>JD</i>	PAGE 3/6
PROCESS INSTRUCTIONS	AMS3015 LOS	LOS FRAME WELDMENT ASSY	Y202126---	OI	3/8/2019	PREPARED BY <i>CRM</i>	

[CONFIRM SQUARENESS BEFORE FINAL WELD]

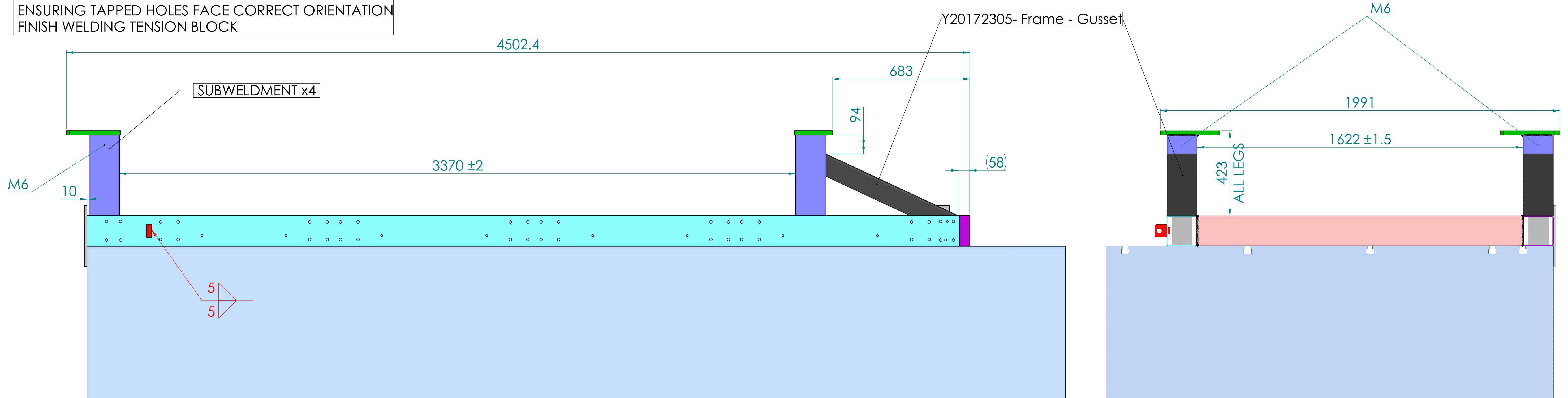


[PREFORM FINAL WELD AND ADD TENSION BLOCK]

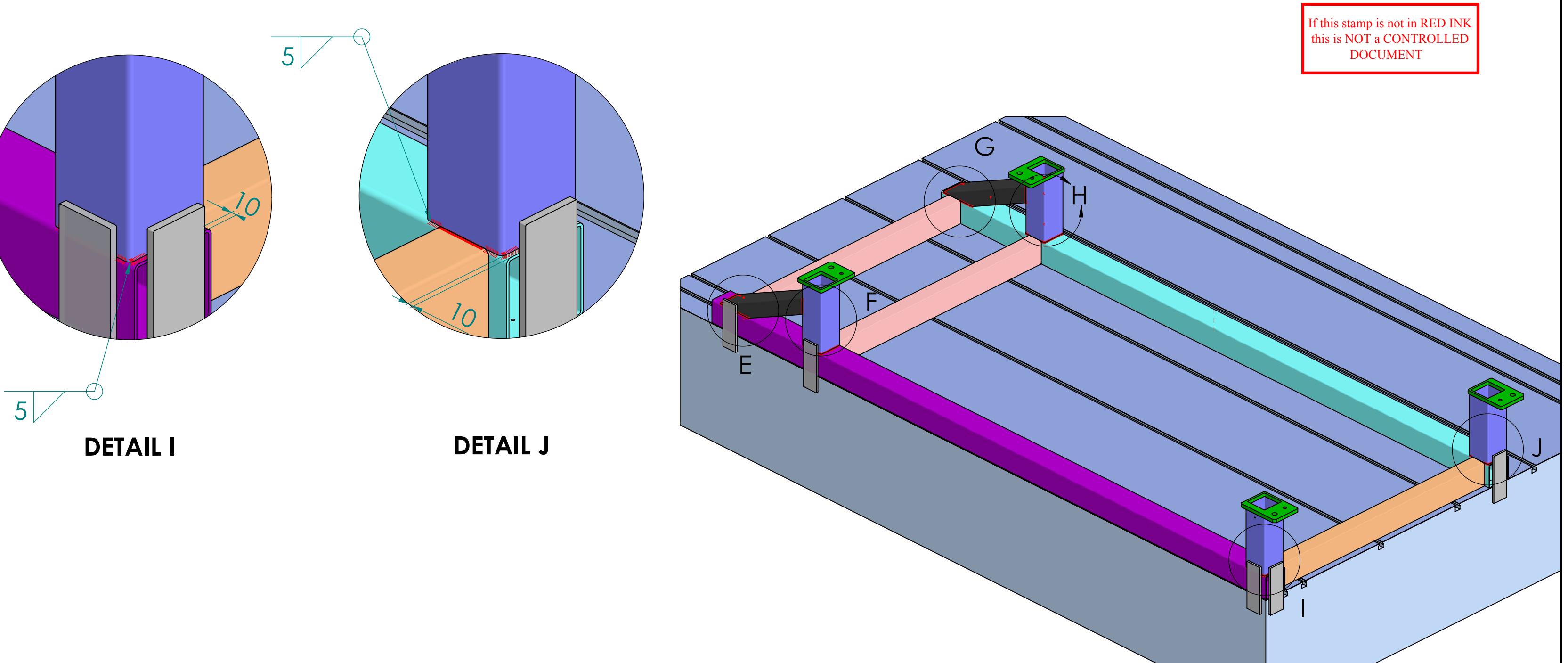
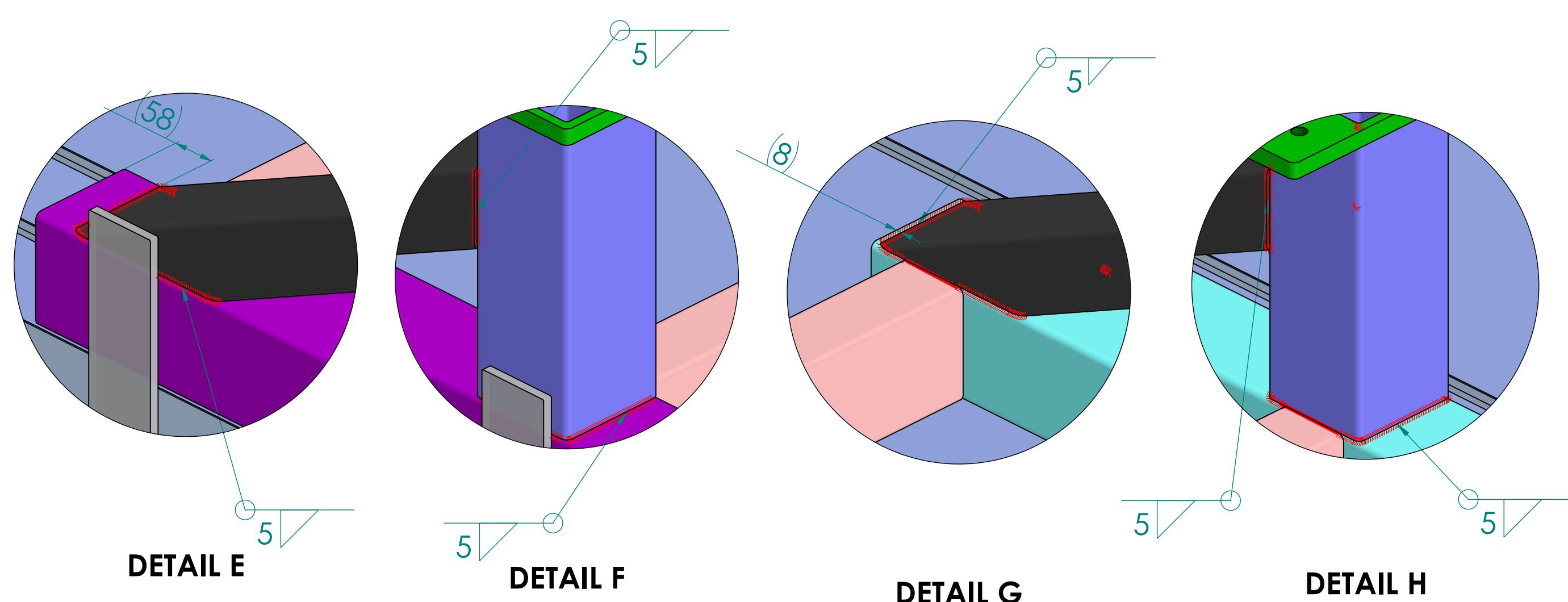


METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY <i>JD</i>	PAGE 4/6
PROCESS INSTRUCTIONS	AMS3015 LOS	LOS FRAME WELDMENT ASSY	Y202126---	OI	3/8/2019	APPROVED BY <i>CRM</i>	

POSITION EARLIER SUBWELDMENTS AS SHOWN  
ADDING THE GUSSET SUPPORTS. POSITION LEGS  
ENSURING TAPPED HOLES FACE CORRECT ORIENTATION  
FINISH WELDING TENSION BLOCK

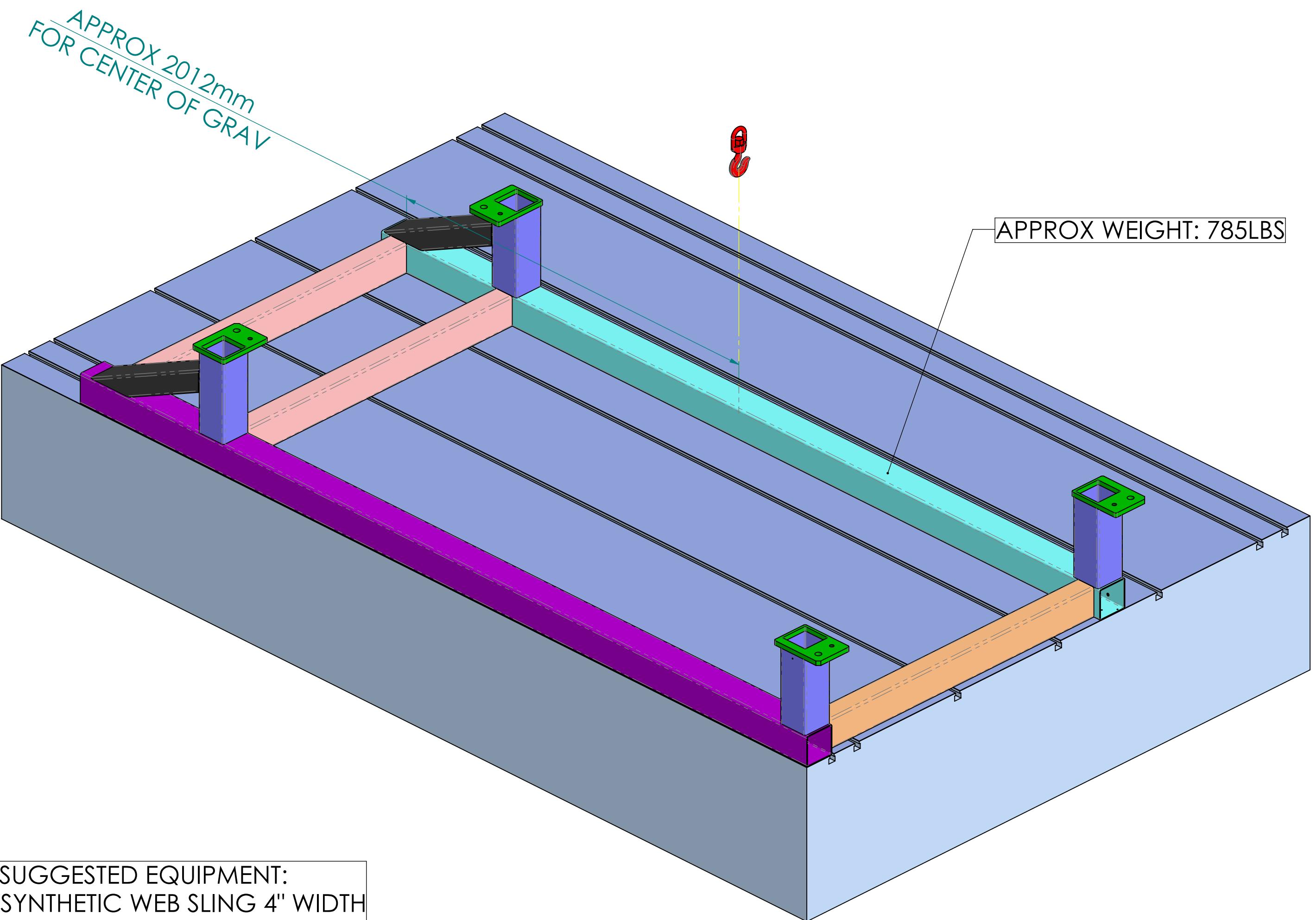


FLUSH LEGS WITH LONG TUBES (TEAL/PURPLE) UNLESS OTHERWISE NOTED.  
TACK. THEN WELD.

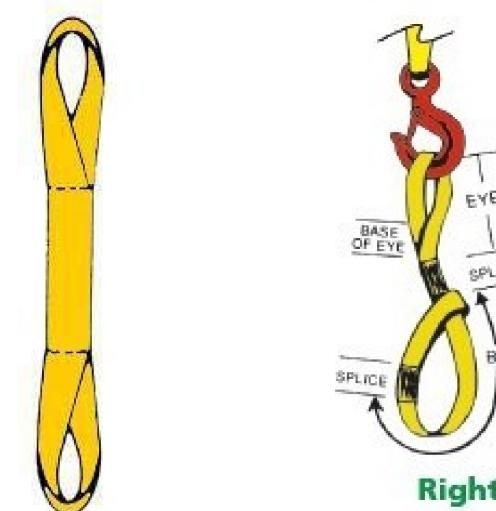


METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY <i>JD</i>	PAGE 5/6
PROCESS INSTRUCTIONS	AMS3015 LOS	LOS FRAME WELDMENT ASSY	Y202126---	OI	3/8/2019	APPROVED BY <i>CRM</i>	

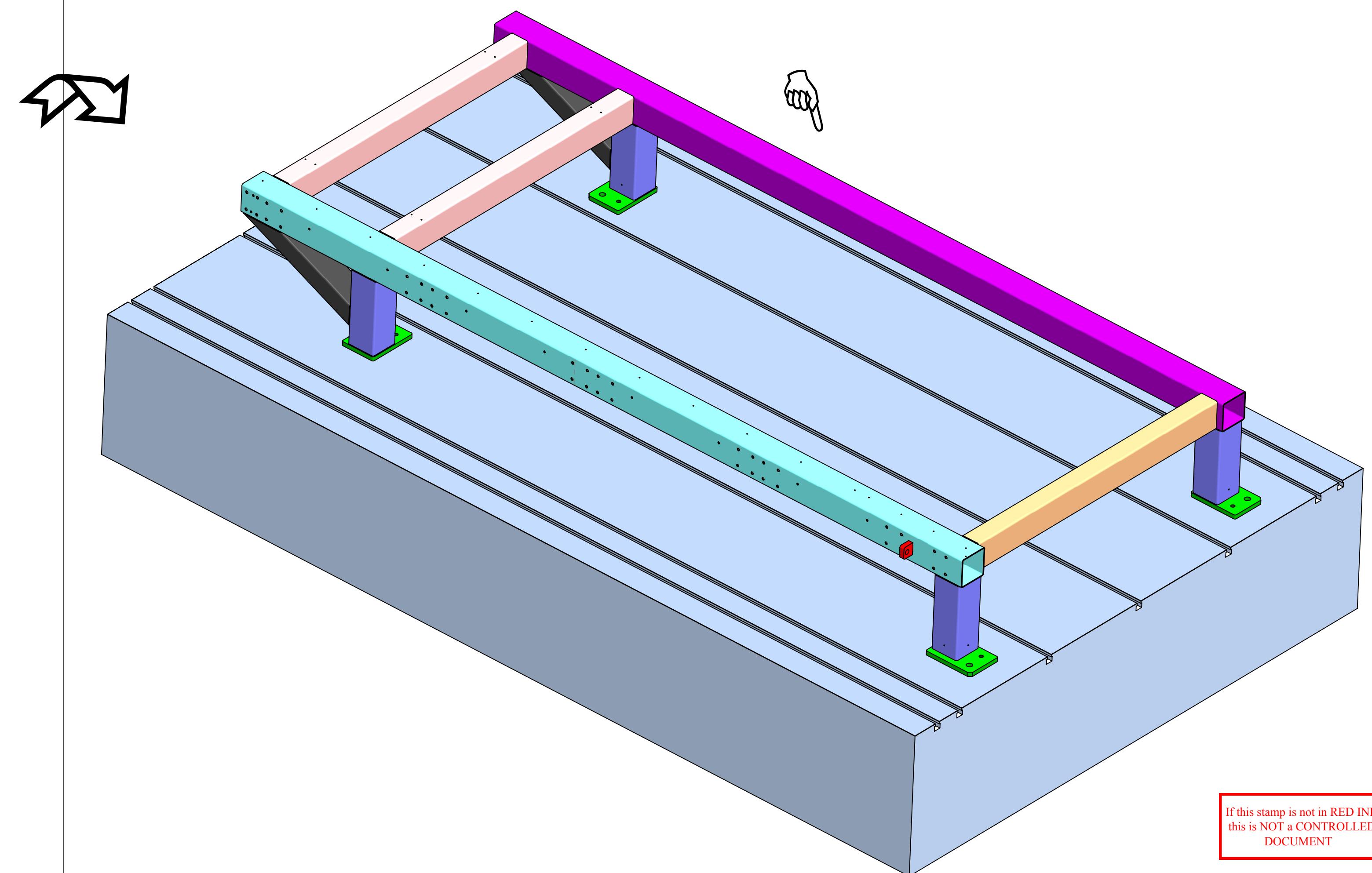
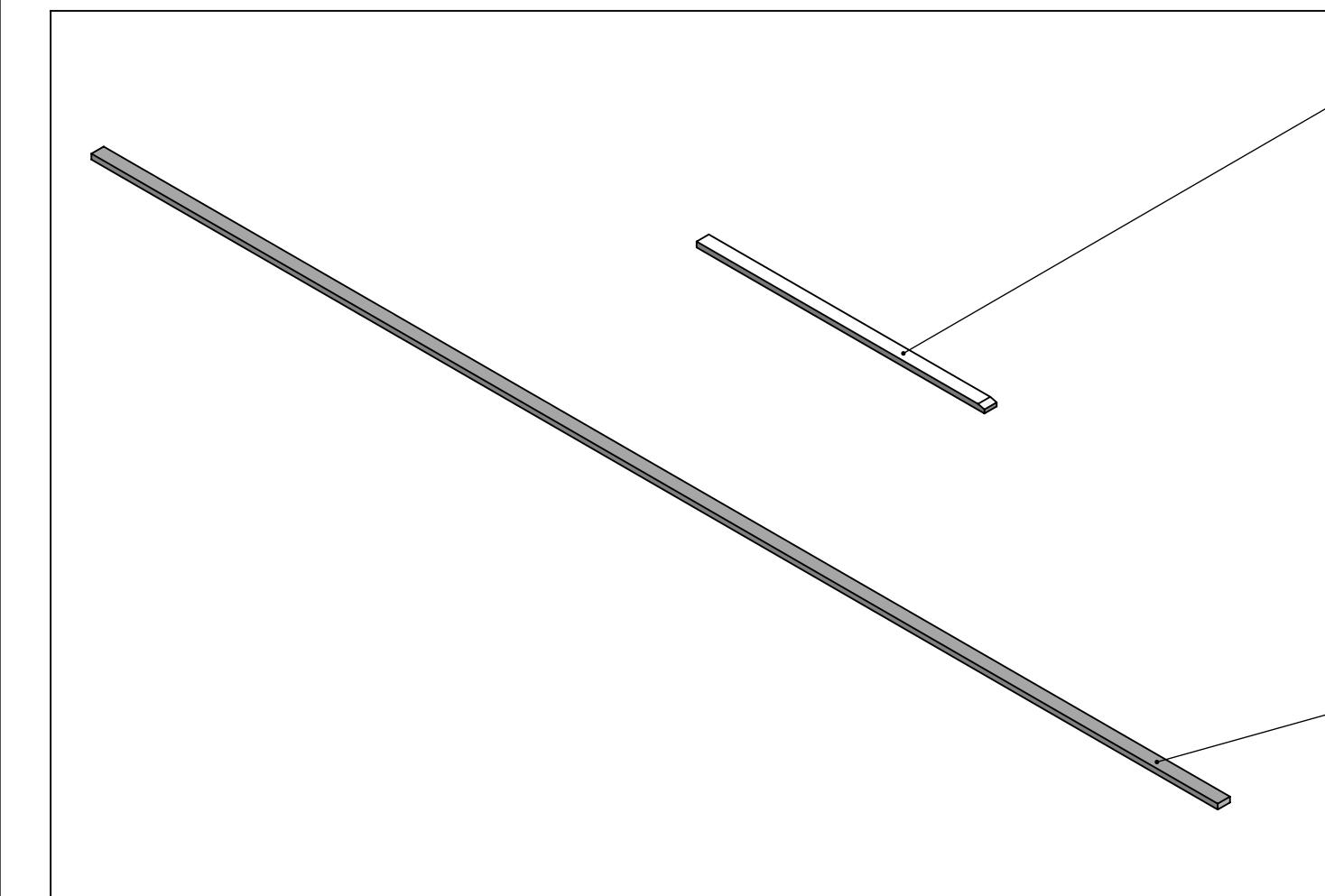
USE PROPER RIGGING EQUIPMENT TO LIFT AND FLIP FRAME.  
LIFT AT 2 POINTS AT THE LEGS OR AT CENTER



SUGGESTED EQUIPMENT:  
-SYNTHETIC WEB SLING 4" WIDTH  
-CHOKER METHOD



PREPARE BOTH FLAT BARS, SHORT AND LONG.



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

METAL FABRICATION	MACHINE MODEL	WELDMENT NAME	DRAWING NO.	REV	DATE	PREPARED BY <i>J.D.</i>	PAGE 6/6
PROCESS INSTRUCTIONS	AMS3015 LOS	LOS FRAME WELDMENT ASSY	Y202126--	OI	3/8/2019	APPROVED BY <i>C.R.M.</i>	

POSITION BOTH FLAT BARS AS SHOWN WITH CHAMFER ON GUSSET SIDE.  
STITCH WELD ENTIRE LENGTH.

