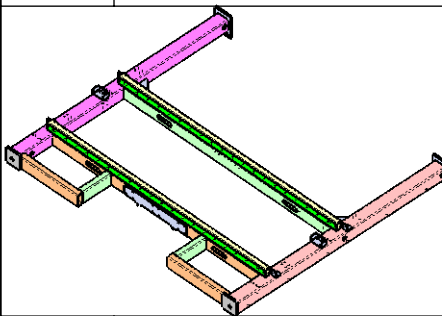
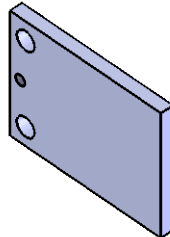
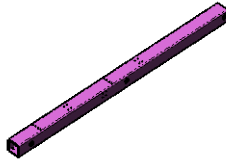
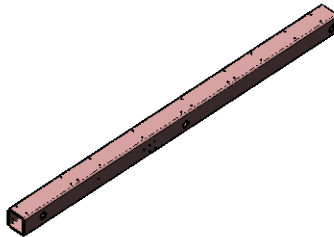
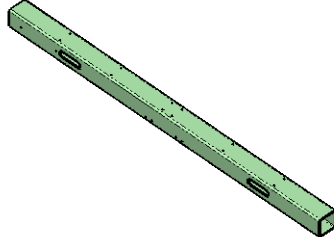
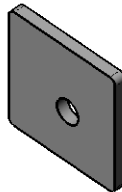
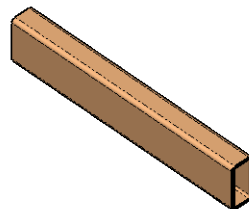
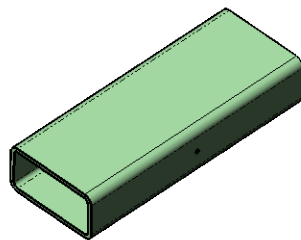

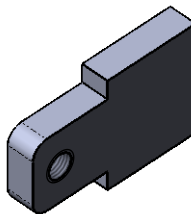

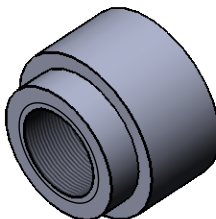
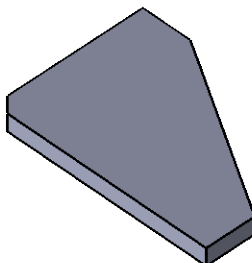
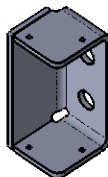
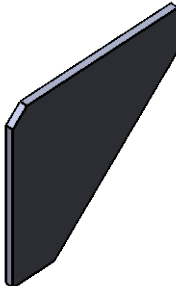
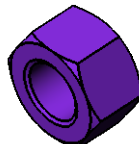


Metal Fabrication				Machine Model				Process Inst Name				Process Inst NO.				REV.		DATE		PREPARED BY: Leon Jiang				PAGE			
Process Instruction				AMS4020CL				MAIN FRAME RHS				HW-Y201962--B				OI		08/01/19		APPROVED BY: Caesar M				1/12			
MACH BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM							
Main Part Sub Part	MAIN FRAME WELDMENT			Main Part Sub Part	FOOT PLATE			Main Part Sub Part	FRONT TUBE 3			Main Part Sub Part	FRONT TUBE 4			Main Part Sub Part	SIDE TUBE 1			Main Part Sub Part	SIDE TUBE 2			Main Part Sub Part	RAIL TUBE		
DWG NO	Y201962--B	QTY	1 /M	DWG NO	Y20160008C	QTY	2 /M	DWG NO	Y20196203B	QTY	1 /M	DWG NO	Y20196204B	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 BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM			
Main Part Sub Part	RAIL SUPPORT ANGLE			Main Part Sub Part	LIFTING PLATE			Main Part Sub Part	TOP LONG TUBE			Main Part Sub Part	SHORT TOP TUBE			Main Part Sub Part	FORK TRAVERSER MOUNT PLATE			Main Part Sub Part	PUSH BLOCK			Main Part Sub Part	BOX MOUNT BRACKET		
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 BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM				MACH BOM			
Main Part Sub Part	EYE BOLT ROUND			Main Part Sub Part	SUPPORT GUSSET			Main Part Sub Part	JACK BOLT PLATE CENTER			Main Part Sub Part	CORNER GUSSET			Main Part Sub Part	M20 HEX NUT			Main Part Sub Part				Main 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			
																											

Metal Fabrication

Machine Model

Process Inst Name

Process Inst NO.

REV.

DATE

PREPARED BY: Leon Jiang

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Process Instruction

AMS4020CL

MAIN FRAME RHS

HW-Y201962--B

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08/01/19

APPROVED BY: Caesar M

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RHS SUB WELDMENT

1X Y20196203B

2X Y20196414-

1X Y20196206A

2X Y20196208A

2X Y20160008C

1X Y20196204B

4X Y20196209A

2X Y20196221-

4X P332000010

2X Y20196211A

2X Y20196217-

2X Y20196212A

2X Y20196213-

2X Y20196215A

1X Y20196214A

1X Y20196207A

PART NO.	DWG.NO.	NAME(ENG)	QTY.
1	Y20160008C	FOOT PLATE	2
2	Y20196203B	FRONT TUBE 3	1
3	Y20196204B	FRONT TUBE 4	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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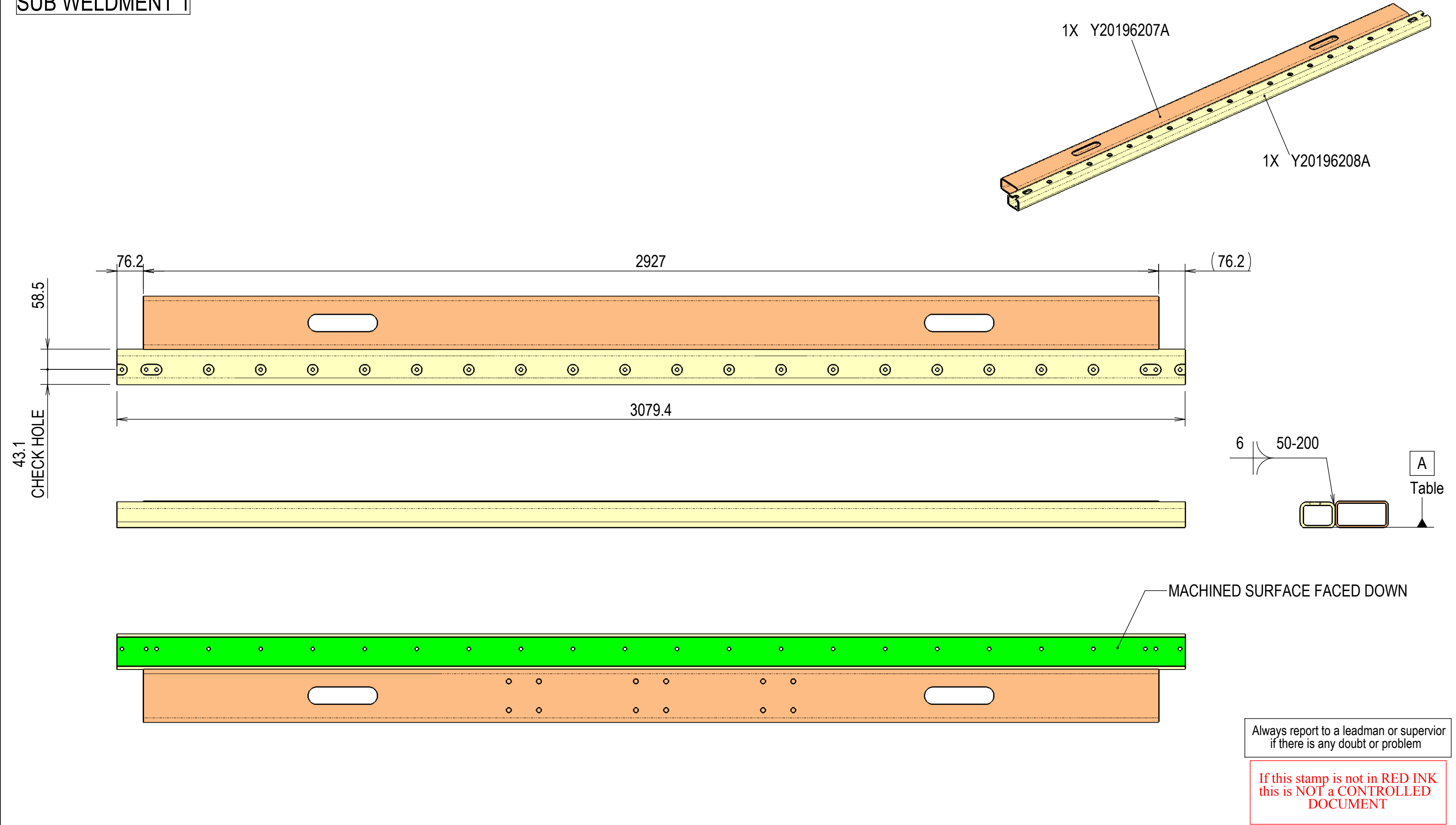
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DOCUMENT

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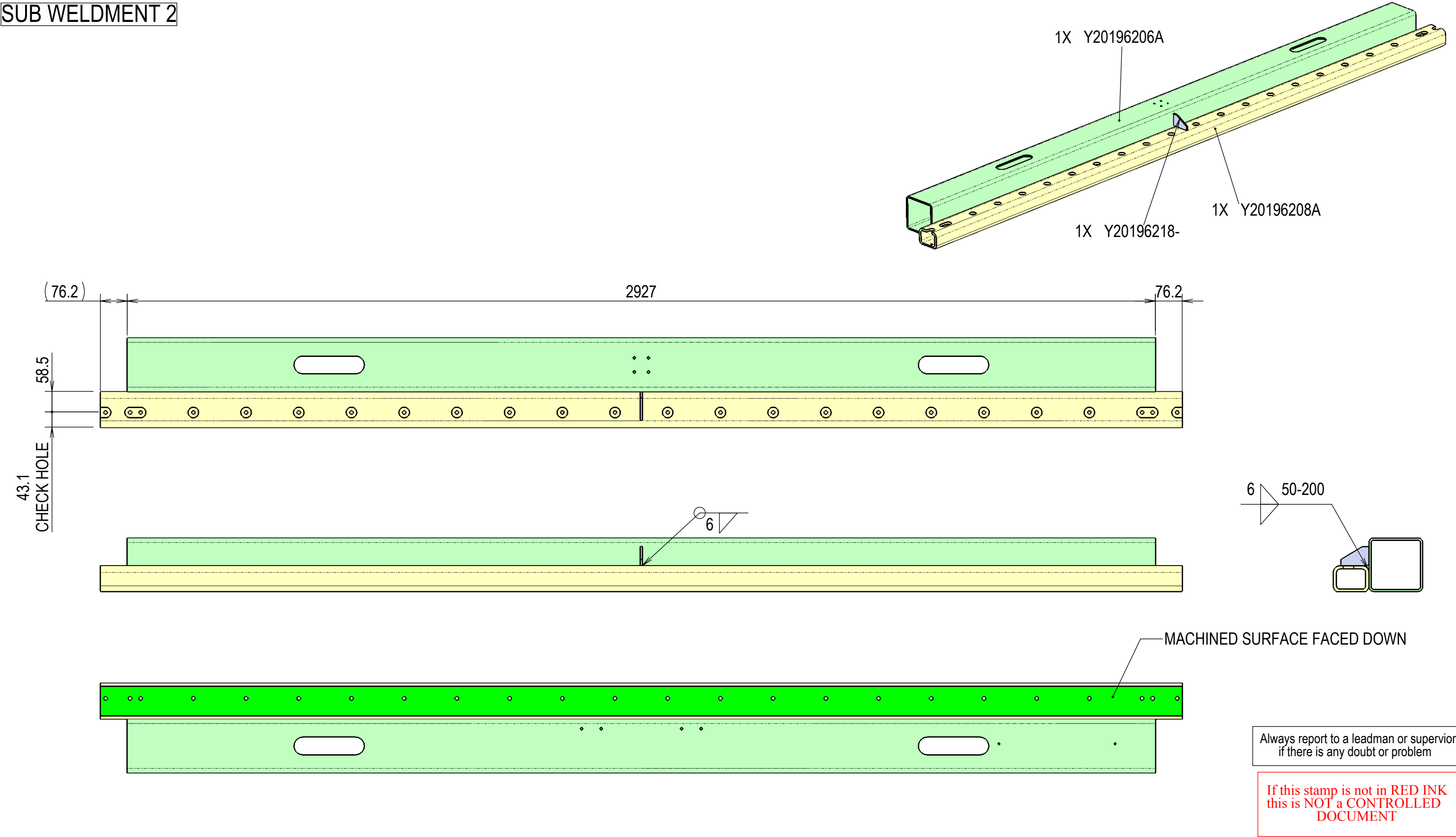
Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	MAIN FRAME RHS	HW-Y201962--B	OI	08/01/19	APPROVED BY: Caesar M	3/12

SUB WELDMENT 1



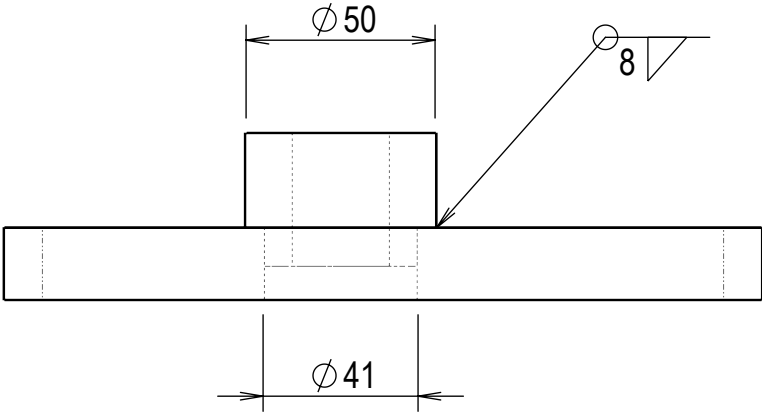
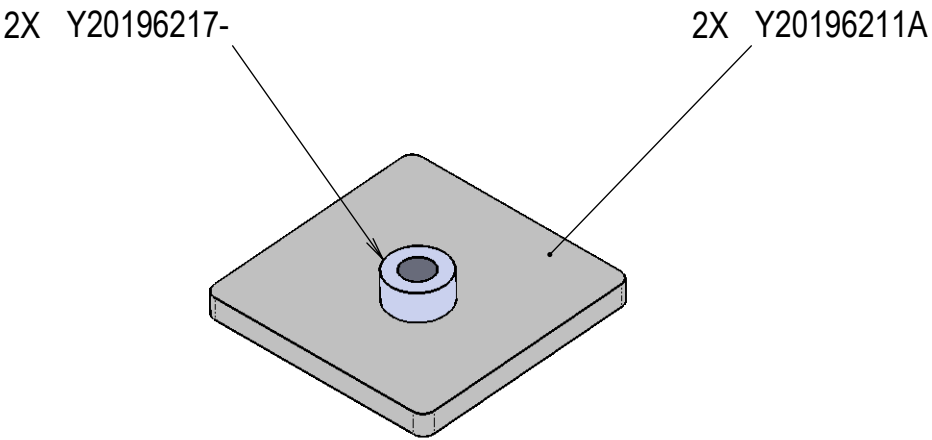
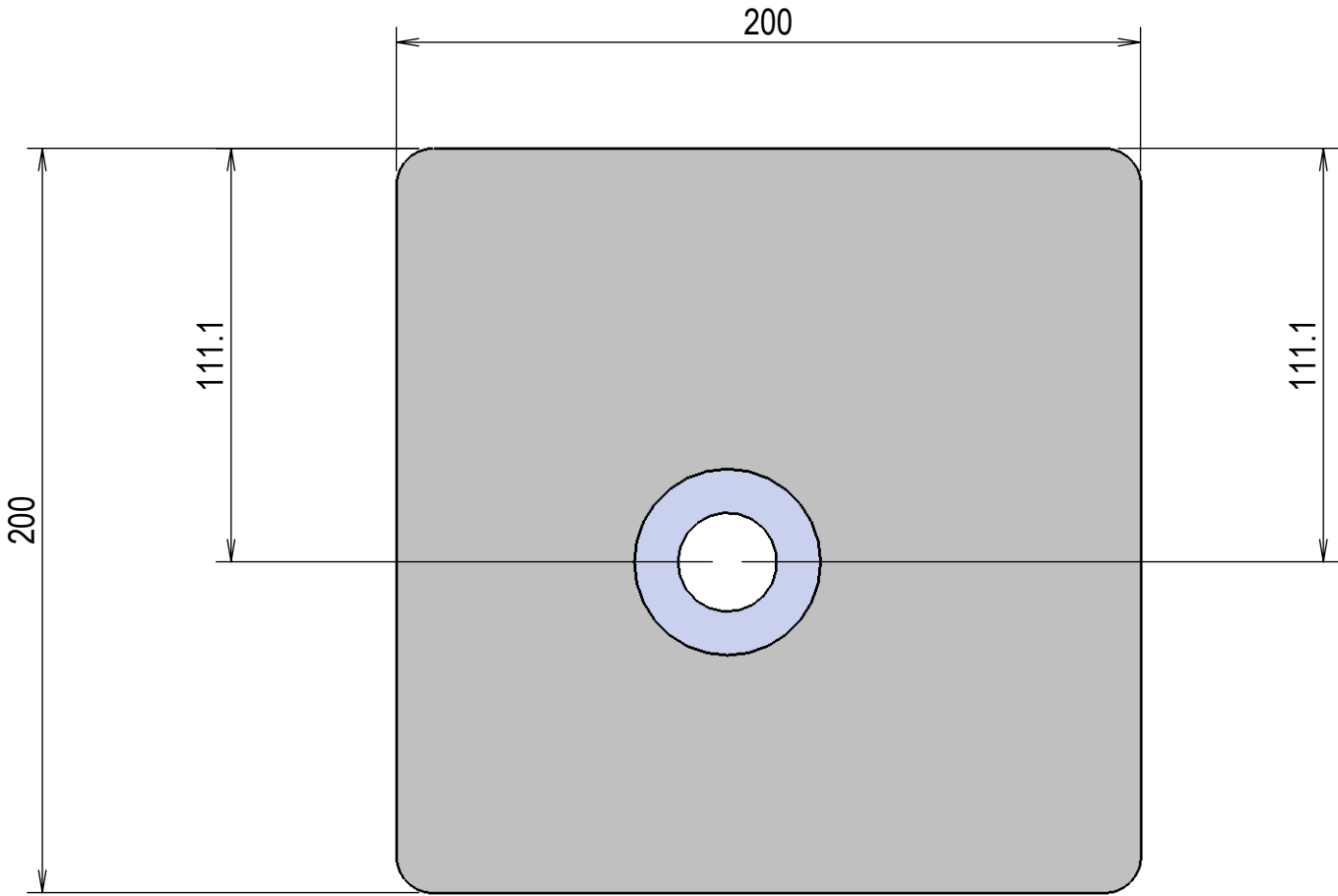
Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	MAIN FRAME RHS	HW-Y201962--B	OI	08/01/19	APPROVED BY: Caesar M	4/12

SUB WELDMENT 2



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

SUB WELDMENT 3

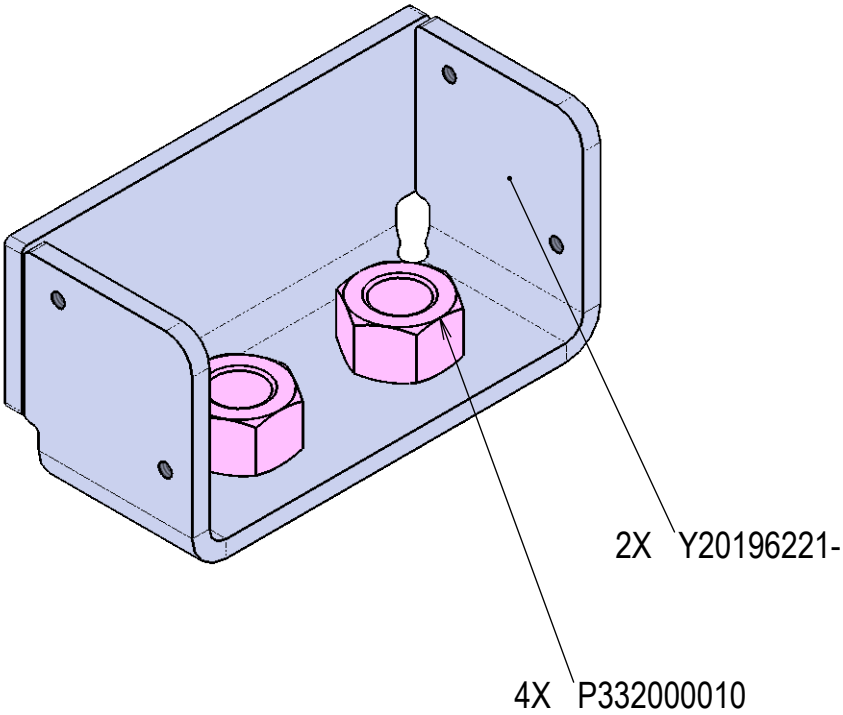
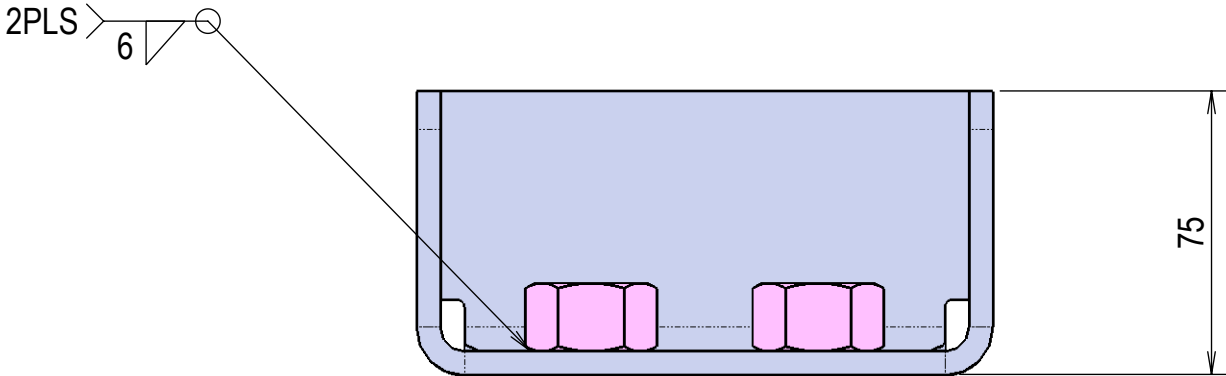
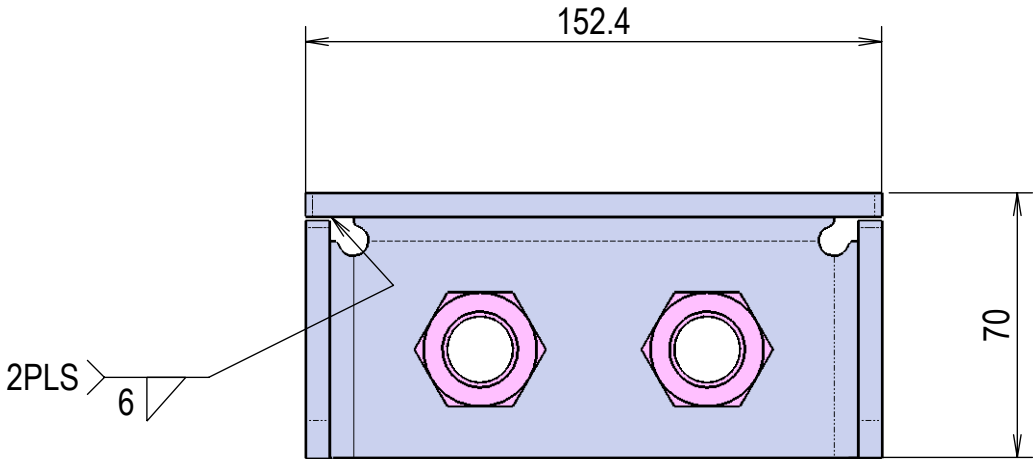


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Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
Process Instruction	AMS4020CL	MAIN FRAME RHS	HW-Y201962--B	OI	08/01/19	APPROVED BY: Caesar M	6/12

SUB WELDMENT 4

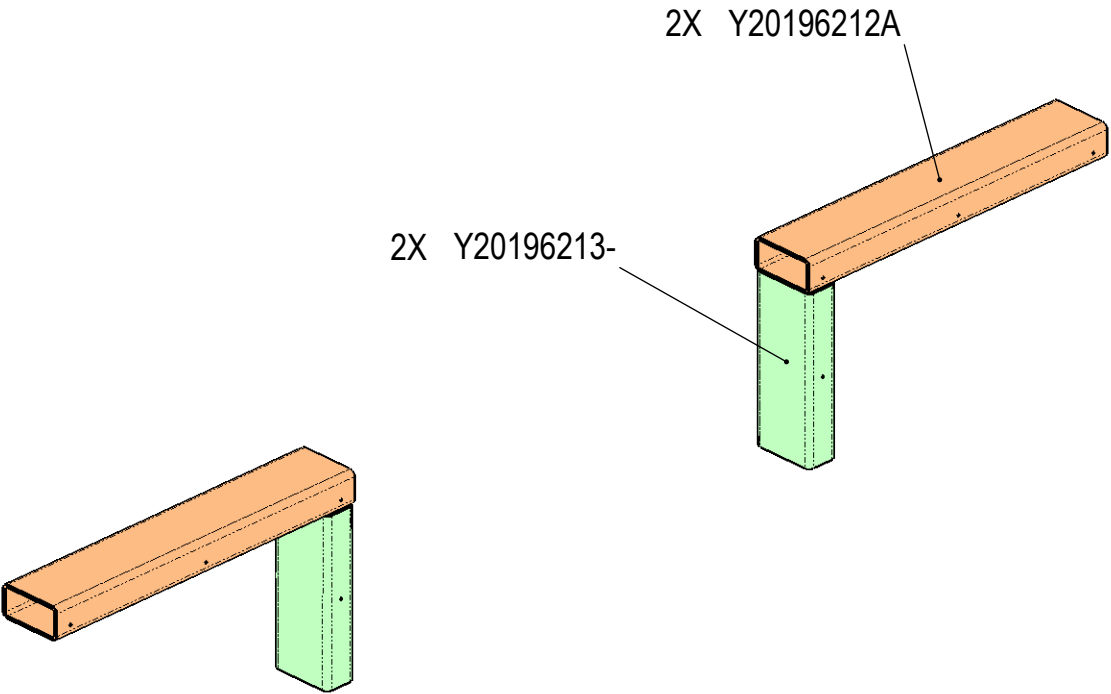


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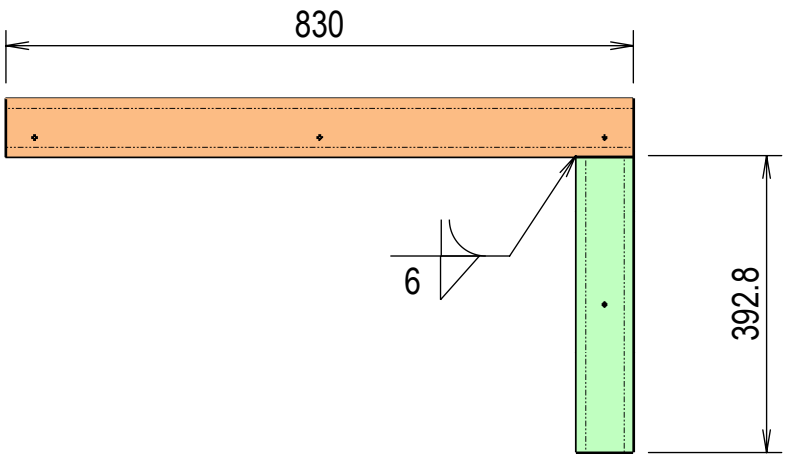
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Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
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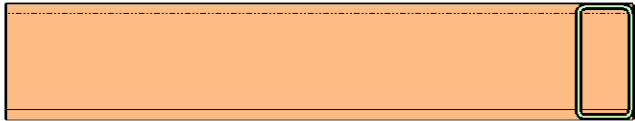
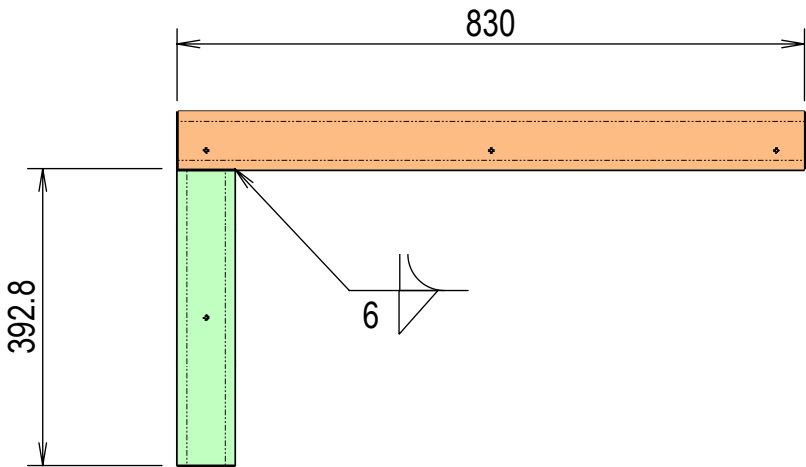
SUB WELDMENT 5



SUB WELDMENT 5-1



SUB WELDMENT 5-2

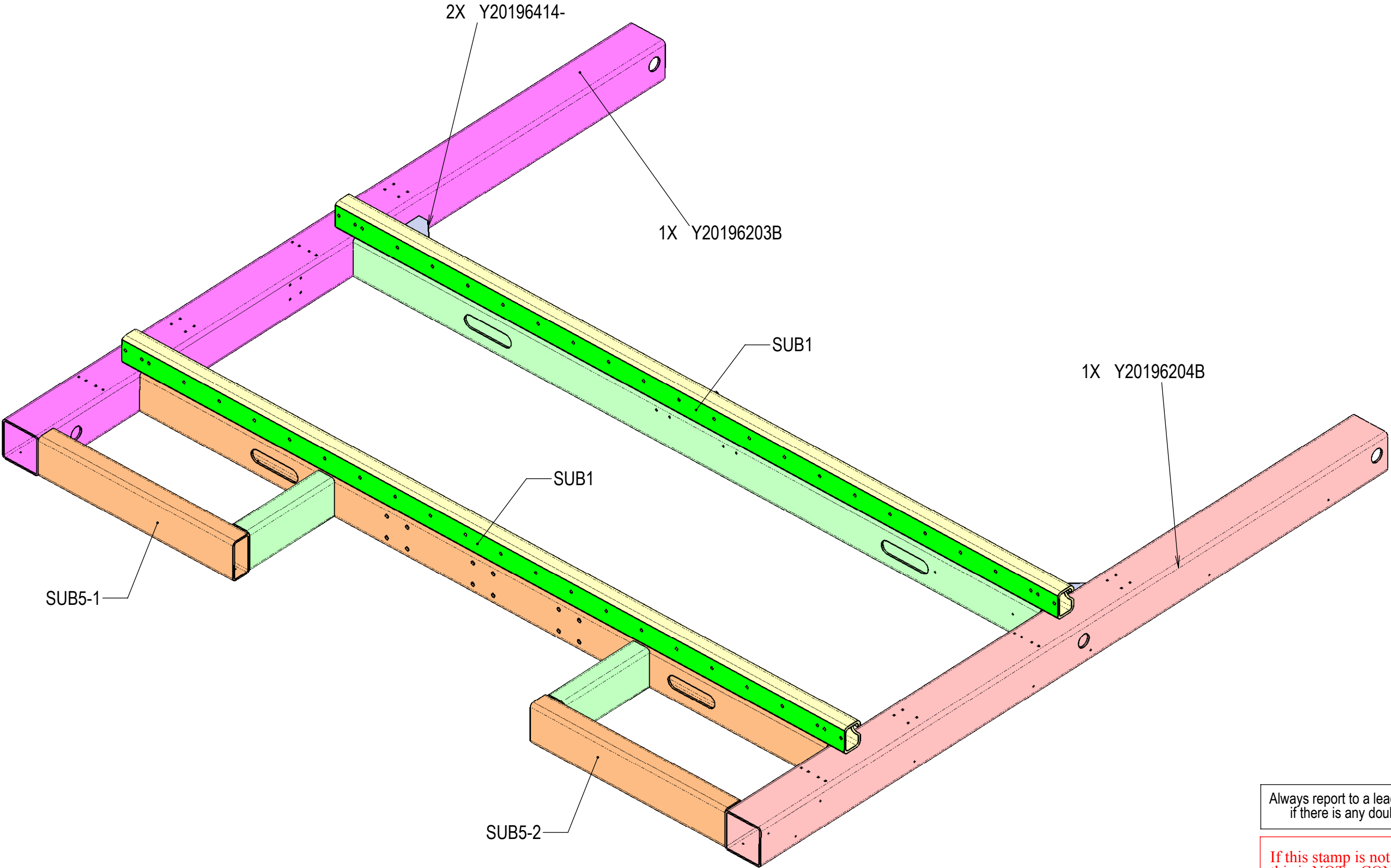


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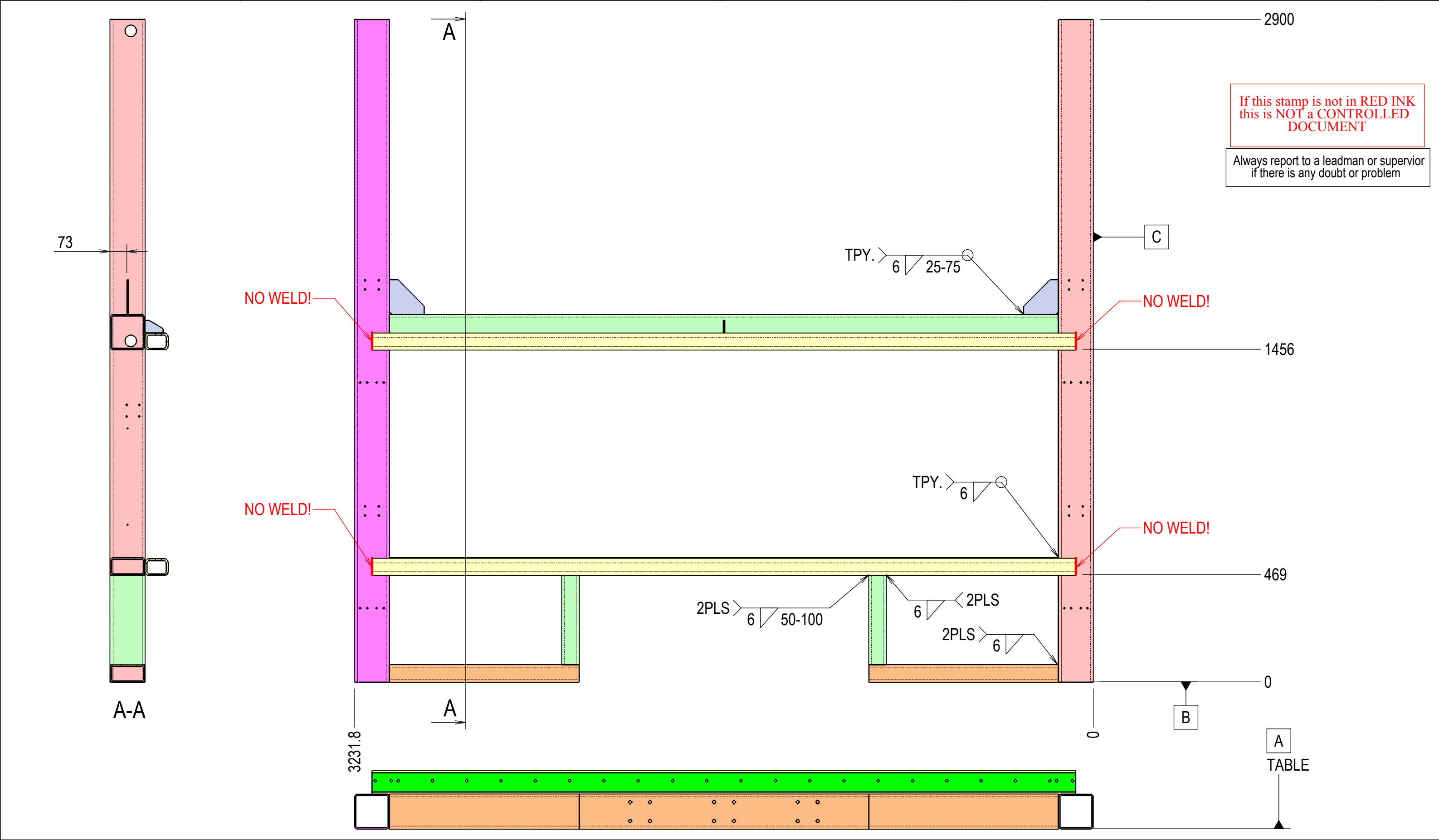
Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
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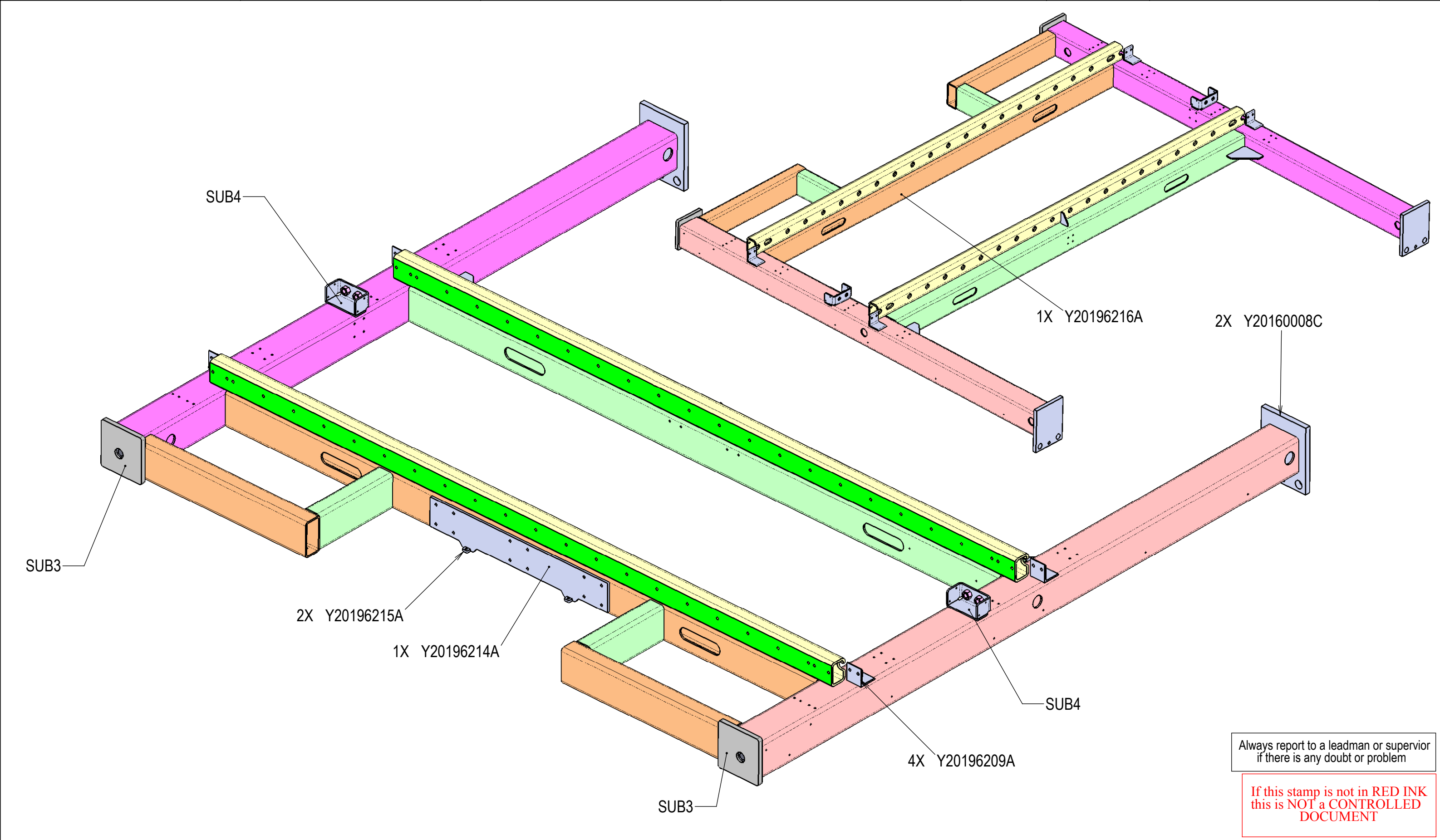
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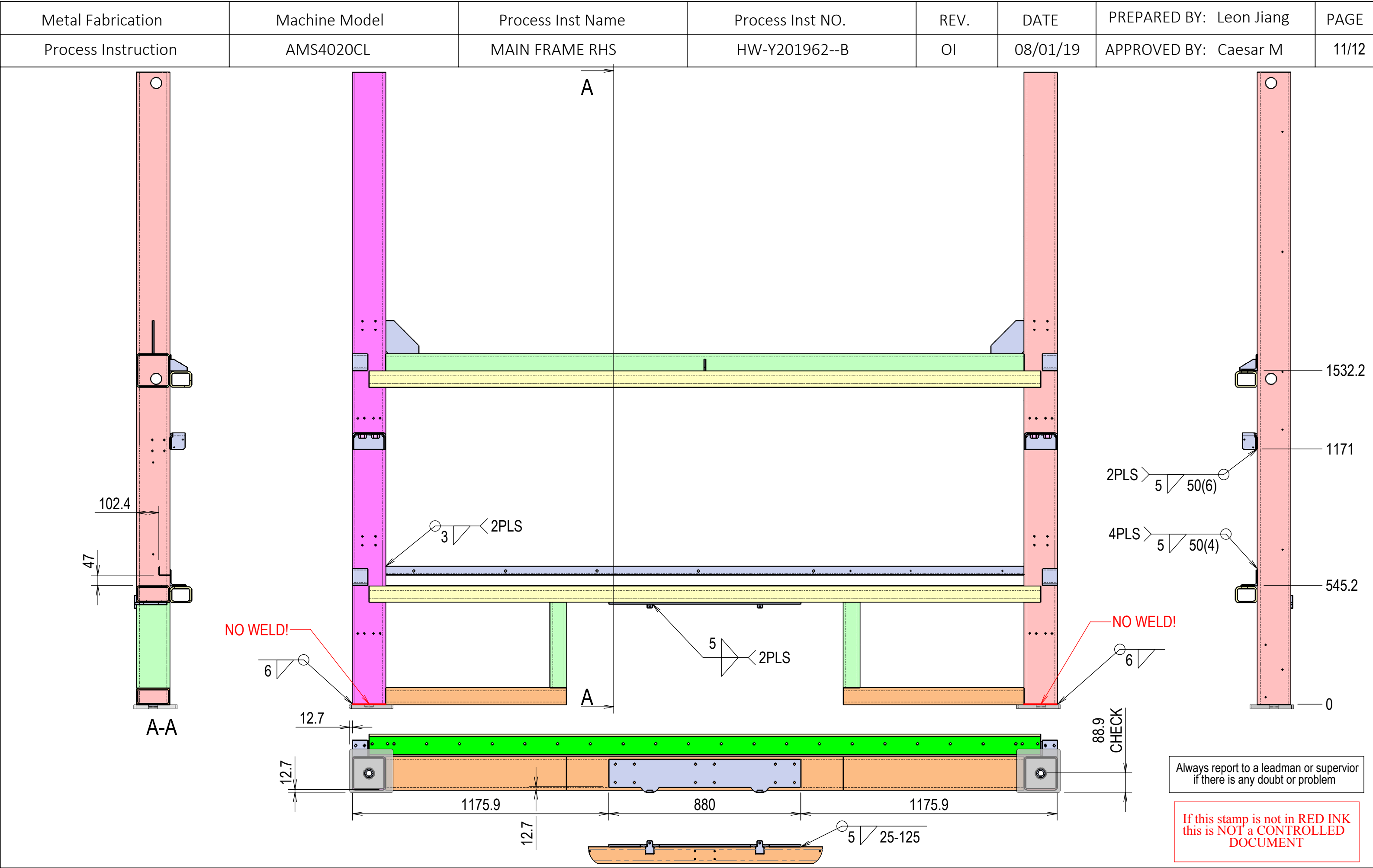
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Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
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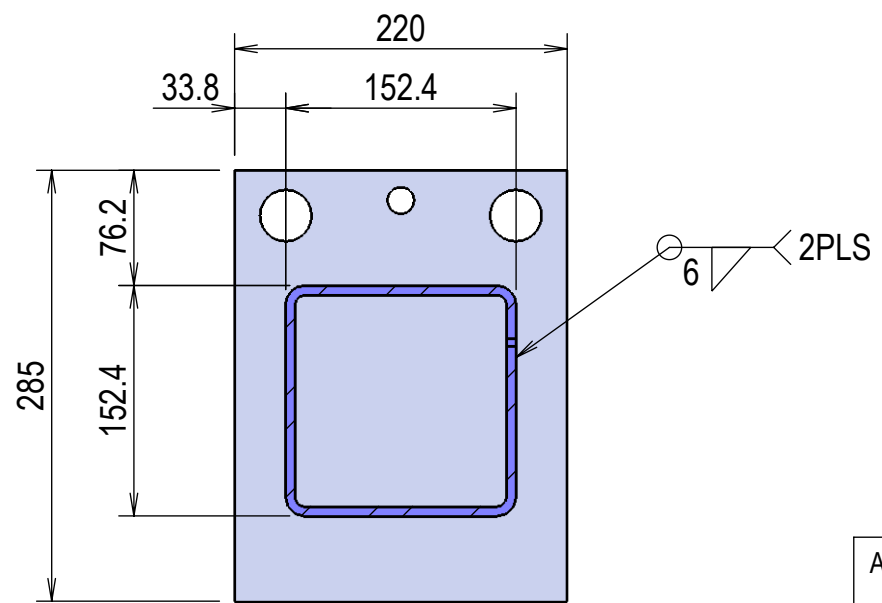
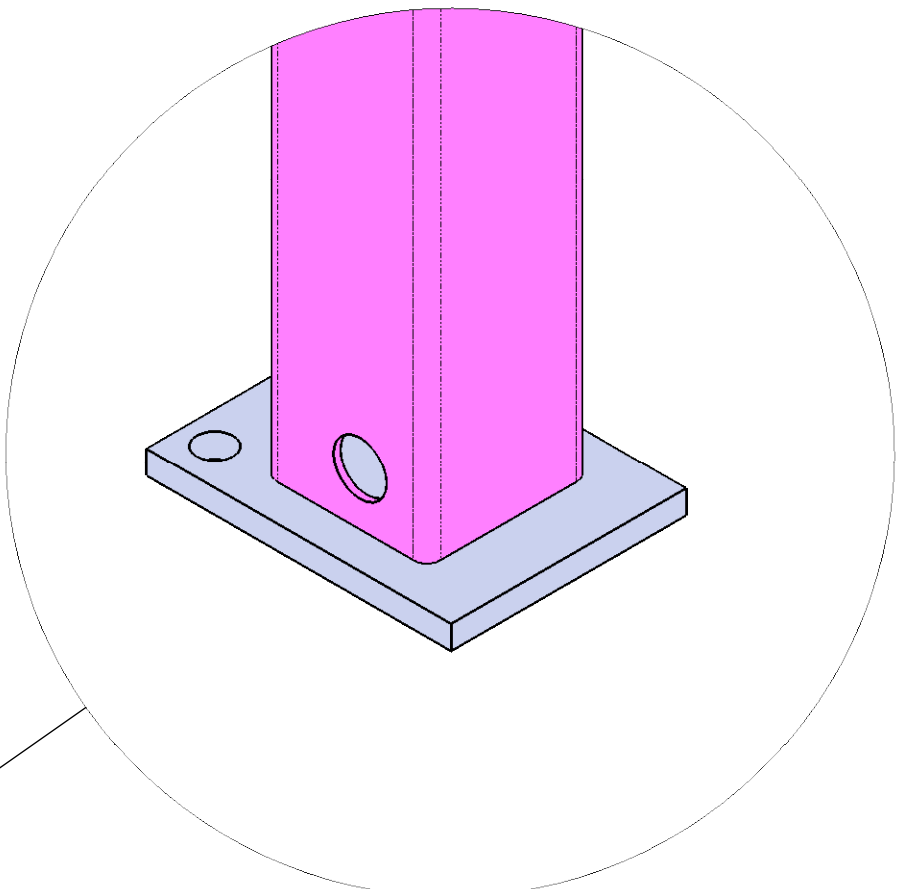
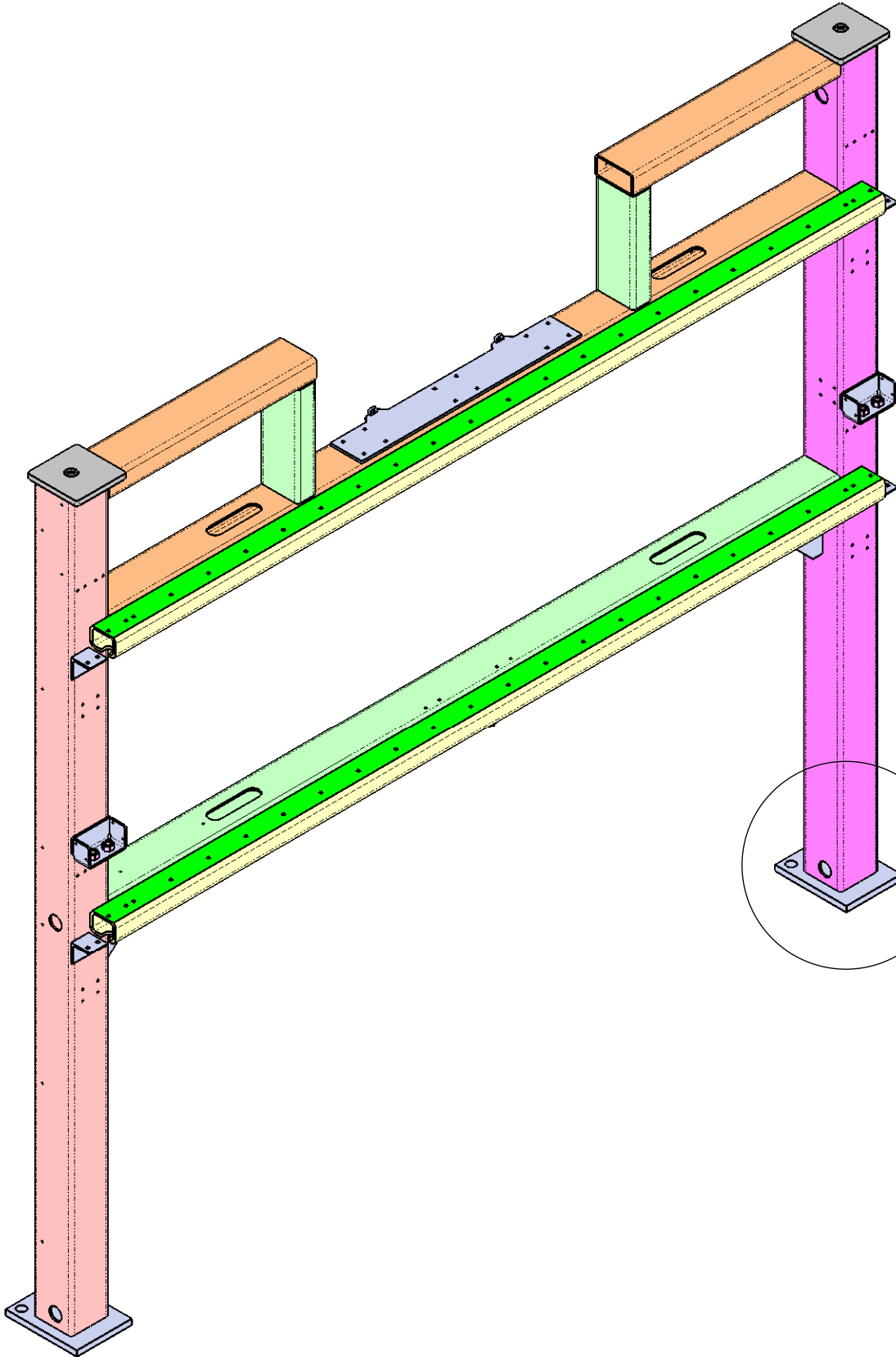


Metal Fabrication	Machine Model	Process Inst Name	Process Inst NO.	REV.	DATE	PREPARED BY: Leon Jiang	PAGE
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