

Engineering Report

M A24-4090

Masters with obsolete parts included

9/7/2023

8:43 AM

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Detail	Quantity	Engineer/Reference	Drawing ID	Rev
----A24-4351 PLUG-2, 1/8 NPT ALUM.	3.00			
Qty Per:	3.0000	Unit of Measure	EA	
Fixed Qty:	0.00	Qty Per Basis:	Starting Qty	
----A24-4352 PLUG-4, 1/4 NPT ALUM.	5.00			
Qty Per:	5.0000	Unit of Measure	EA	
Fixed Qty:	0.00	Qty Per Basis:	Starting Qty	
----A24-4354 PLUG-8, 1/2 NPT ALUM.	2.00			
Qty Per:	2.0000	Unit of Measure	EA	
Fixed Qty:	0.00	Qty Per Basis:	Starting Qty	
--30 EA-LEVEL-02 - ENGINE ASSEMBLY LEVEL 2	Type:	0.0 %	Scra	
End Qty:	1.00	Start Qty:	1.00	
Resource ID:	EA-LEVEL-02	Setup:	0.0 Hrs	Fixed Scrap: 0.00
		Run:	10.0000 MIN/P	Min Move:
Service ID:		Transit:	0.0 Days	Capacity Min:
PRESSURE TEST CYLINDER HEAD FOR LEAKS. 30 PSI				
--40 EA-LEVEL-02 - ENGINE ASSEMBLY LEVEL 2	Type:	0.0 %	Scra	
End Qty:	1.00	Start Qty:	1.00	
Resource ID:	EA-LEVEL-02	Setup:	0.0 Hrs	Fixed Scrap: 0.00
		Run:	30.0000 LOAD	Min Move:
Service ID:		Transit:	0.0 Days	Capacity Min:
TUMBLE CYLINDER HEAD IN LARGE TUMBLER. 20 MIN				
--50 EA-LEVEL-02 - ENGINE ASSEMBLY LEVEL 2	Type:	0.0 %	Scra	
End Qty:	1.00	Start Qty:	1.00	
Resource ID:	EA-LEVEL-02	Setup:	0.0 Hrs	Fixed Scrap: 0.00
		Run:	10.0000 LOAD	Min Move:
Service ID:		Transit:	0.0 Days	Capacity Min:
ULTRASONIC CLEAN CYLINDER HEAD USING HEAT AND AIR				
AGITATION. RINSE THOROUGHLY AND USE COMPRESSED AIR TO				
DRY.				
INSPECT CYLINDER HEAD.				
--60 EA-LEVEL-02 - ENGINE ASSEMBLY LEVEL 2	Type:	0.0 %	Scra	
End Qty:	1.00	Start Qty:	1.00	
Resource ID:	EA-LEVEL-02	Setup:	0.0 Hrs	Fixed Scrap: 0.00

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Detail	Quantity	Engineer/Reference	Drawing ID	Rev
Service ID: Run: 1.0000 MIN/P Min Move: HEAT CYLINDER HEAD IN OVEN AT 150 FOR 30 MINUTES. Transit: 0.0 Days Capacity Min: FREEZE VALVE SEATS FOR 30 MINUTES.				
----A24-4003 INTAKE VALVE SEAT	2.00			
Qty Per:	2.0000	Unit of Measure	EA	
Fixed Qty:	0.00	Qty Per Basis:	Starting Qty	
----A24-4056 EXHAUST VALVE SEAT	2.00			
Qty Per:	2.0000	Unit of Measure	EA	
Fixed Qty:	0.00	Qty Per Basis:	Starting Qty	
--70 EA-LEVEL-02 - ENGINE ASSEMBLY LEVEL 2	Type:	0.0 %	Scra	
End Qty:	1.00	Start Qty:	1.00	
Resource ID: EA-LEVEL-02	Setup:	0.0 Hrs	Fixed Scrap:	0.00
	Run:	10.0000 MIN/P	Min Move:	
Service ID:	Transit:	0.0 Days	Capacity Min:	
ARBOR PRESS VALVE SEATS IN TO CYLINDER HEAD.				
--80 EA-LEVEL-02 - ENGINE ASSEMBLY LEVEL 2	Type:	0.0 %	Scra	
End Qty:	1.00	Start Qty:	1.00	
Resource ID: EA-LEVEL-02	Setup:	0.0 Hrs	Fixed Scrap:	0.00
	Run:	10.0000 MIN/P	Min Move:	
Service ID:	Transit:	0.0 Days	Capacity Min:	
ARBOR PRESS VALVE GUIDE SEATS (FROM THE TOP SIDE OF HEAD) IN TO CYLINDER HEAD USING ANTI-SEIZE LUBRICANT.				
----A24-4004 INTAKE VALVE GUIDE	4.00			
Qty Per:	4.0000	Unit of Measure	EA	
Fixed Qty:	0.00	Qty Per Basis:	Starting Qty	
--90 OUTSIDE SERVICE - OUTSIDE SERVICE CO	Type:OS-MACHININ	0.0 %	Scra	
End Qty:	1.00	Start Qty:	1.00	
Resource ID: OUTSIDE SER	Setup:	0.0 Hrs	Fixed Scrap:	0.00
	Run:	0.0000 DAYS/	Min Move:	
Service ID: MACHINING	Transit:	5.0 Days	Capacity Min:	
VALVE SEAT GRIND AND SIZING				