



ALMC HEAD  
FINISHED GOODS  
INVENTORY - 1.5  
DAYS @ 800 U/D

ALMC BLOCK  
FINISHED GOODS  
INVENTORY - 1.5  
DAYS @ 800 U/D

- Head Mist Collectors**
1. Cell #1-2
  2. Cell #3-4
  3. Intermediate Wash
  4. GA Milling Machine
  5. Linebore Machine
  6. Final Wash
  7. Coolant Systems

- Head Part Hoist**
1. Input
  2. Final Inspection
  3. Tool Preset

Head Process	Head Vendor
Input Conveyor	Harry Major MC
CNC Cell #1	Sakurai VM (EG)
Conveyor A	Harry Major MC
CNC Cell #2	Makino J4M A30 (EG)
Conveyor B	Harry Major MC
CNC Cell #3	Makino J4M A30 (EG)
Conveyor C	Harry Major MC
CNC Cell #4	Makino J4M A30 (EG)
Conveyor D	Harry Major MC
R/L Module MC	EG
Conveyor E	Harry Major MC
#1 Module MC	EG
Conveyor F	Harry Major MC
#2 Module TR	EG
Conveyor G	Harry Major MC
Inter Wash MC	Harry Major MC
Guide/Seat Measure	Accretech
Conveyor H	Harry Major MC
U-Cap MC	Innovative
Leaktest MC	Coretec
Conveyor I	Harry Major MC
Press MC	EG
Conveyor J	Harry Major MC
#3 Module MC	EG
GA Final Cell	Sakurai VM (EG)
GA Washer	Harry Major MC
Valve Leaktest	Biken
Valve Guide Measure	Accretech
Conveyor L	Harry Major MC
Linebore MC	EG
LB Measure MC	Accretech
Conveyor M	Harry Major MC
Final Washer	Coretec
Final Leaktest	Coretec
Output Conveyor	Harry Major MC
Final Inspection	EG

Troughing	Henry Filters/DURR
Coolant Tank	Henry Filters/DURR
Mist Collectors	Absolent

- Block Mist Collectors**
1. Cell #1
  2. Cell #2
  3. Cell #3
  4. Coolant System #1
  5. Coolant System #2
  6. Coolant System #3
  7. Intermediate Washer
  8. FB Hone A-side
  9. FB Hone B-side
  10. Linebore Cell
  11. GA final Mill
  12. Final Washer

- Block Part Hoists**
1. Input
  2. Cell #1
  3. A-Conveyor
  4. B-Conveyor
  5. C-Conveyor
  6. D-Conveyor
  7. E-Conveyor
  8. F-Conveyor
  9. Leak Test
  10. G-Conveyor
  11. Lower Block Assy
  12. Hone A-side load
  13. Hone A-side unload
  14. Bore measure
  15. Bore inspection
  16. Journal measure
  17. GA Final
  18. Final Inspection
  19. Die cast repair

Block Process	Block Vendor
Input Conveyor	Harry Major MC
CNC Cell #1	Makino J4M A30 (EG)
Conveyor A	Harry Major MC
#1 Module MC	EG
Conveyor B	Harry Major MC
CNC Cell #2	Makino J4M A32 (EG)
Conveyor C	Harry Major MC
#2 Module MC	EG
Conveyor D	Harry Major MC
CNC Cell #3	Makino MJ71 (EG)
Conveyor E	Harry Major MC
Inter Wash	Harry Major MC
Conveyor F	Harry Major MC
Leaktest	Coretec
Conveyor G	Harry Major MC
Lower Block Assy	Innovative
Conveyor H	Harry Major MC
FB Hone Cell	EG
Conveyor I	Harry Major MC
Bore Measure	Accretech
Conveyor J	Harry Major MC
Linebore MC	EG
Linebore Measure	Accretech
Conveyor K	Harry Major MC
GA Final Cell	Makino MJ71 (EG)
Conveyor L	Harry Major MC
Final Washer	Harry Major MC
Final Inspection	Harry Major MC

Troughing	Henry Filters/DURR
AL Coolant Tank	Henry Filters/DURR
Cast Iron Tank	Henry Filters/DURR
Hone Tank	Henry Filters/DURR
Mist Collectors	Absolent