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<td>Unit B.O.M. Instructions</td>
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<td>Line B.O.M. Template</td>
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<td>Unit B.O.M. Template</td>
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1. INTRODUCTION
   1.1 These Metric Drafting Standards are an integral part of the NAAMS Global Standard Components, Assembly.

2. DEFINITIONS
   2.1 Hard Metric: A dimension in millimeters, established in metric and not a result of converting from U.S. customary units to equivalent metric.
   2.2 Soft Metric: A dimension in millimeters, resulting from directly converting an established U.S. customary base dimension.

3. DRAWING PROJECTION
   3.1 Current drafting practices pertaining to multiview and sectional view drawings are defined and illustrated in ANSI Y 14.5M - 1994.
   3.2 All drawings should be drafted using third angle projection on orthographic views.
   3.3 When sections or views are projected on the same or on other sheets, they shall be projected and drawn perpendicular to the cutting or viewing plane.
   3.4 When sections or views are projected onto other sheets, directional arrows shall be shown and cross referencing notes added onto the respective view.

4. CONSTRUCTION MATERIAL
   4.1 When plate, tubing, angles, channels, etc. that are produced to U.S. customary units are specified, the cross section dimensions should be called out in U.S. customary units and the cut length in metric.

5. TRANSFERS
   5.1 Transfers within a tooling system shall have their construction dimensioned in metrics.
   5.2 Travel distance, both horizontal and vertical, shall be dimensioned in metrics, with equivalent U.S. customary setup dimensions to interface coordination points with plant facilities and plant equipment.

6. FASTENERS
   6.1 It is recommended that all tool builders and suppliers use only hard metric fasteners.
   6.2 All metric threads are assumed to be coarse unless otherwise specified.
   6.3 The preferred minimum screw size is M8, except for the attachment of commercial and standard items that have predetermined mounting holes.
   6.4 Fasteners for kits shall remain to their existing standard screw size.

7. ENERGY, INERTIA, TORQUE, POWER AND WORK
   7.1 These entities shall remain to current standards.
   7.2 For future U.S. customary / metric conversion, refer to the NAAMS Metric Equivalent Charts #1 & #2.

8. DIMENSIONING AND TOLERANCING
   8.1 Dimensioning and tolerancing practices shall be as defined and illustrated in ANSI Specification #Y14.3M - 1994.
   8.2 A zero before the decimal point shall be used for a number less than 1.0 (Example 0.5).
9. METRIC DRAWING SCALE
   9.1 For general design work, drawing scales shall be full size wherever possible.
   9.2 The recommended reduced scale for fixture designs are 1:2, 1:5, 1:10, 1:20 and 1:50.
   9.3 When increased scales are necessary, the scales shall be 2:1, 5:1, 10:1, 20:1 and 50:1.
   9.4 The drawing scale for system layout drawings should be coordinated with each individual plant.

10. LETTERING
   10.1 All text height shall be 2 mm minimum on 11 x 17 CAD drawings and 3 mm minimum on all other drawings.
   10.2 Notes and descriptions shall be 5 mm minimum.
   10.3 View callouts, section, unit no's, switch and cylinder callouts shall be 7 mm minimum.

11. BODYLINES
   11.1 On fixture drawings, only one body line is required in each direction provided its relationship to the zero datum line is shown. These shall be identified with a 25 mm diameter balloon.
   11.2 All auxiliary worklines shall be identified with a 25 mm square box, showing originating bodyline intersection and angle used for worklines.
   11.3 When a dimension originates from a workline, the origin should be indicated.

12. DIMENSION ARRANGEMENT
   12.1 Dimensions should be shown in true views and should not be taken from hidden lines.
   12.2 Dimensions should be located outside the outline of the detail wherever possible.
   12.3 Screw and dowel sizes shall be written along the center-line of the fastener in its side view on assembly drawings.

13. COMMERCIAL COMPONENTS
   13.1 Metric commercial components are preferred when available and approved by customer.
   13.2 Pivot shaft diameters, bushing & bearing sizes, cylinders and stroke of cylinders etc., shall remain to existing standards.
   13.3 Gears, racks, etc., shall retain inch pitch diameters.
   13.4 Pipe threads shall remain to existing standards.

14. SETUP DIMENSIONS
   14.1 Machined surfaces, pivot centerlines, hole patterns, fab dimensions and NC block mounting surfaces should be set up in 5 mm increments whenever possible.

15. DETAILS OF A UNIT
   15.1 All items that are detailed shall be identified with a 20 mm diameter split balloon with the item number of the detail in the top half and the sheet number where the detail is drawn in the bottom half.
   15.2 If a detail is shown & opposite on a particular unit, the same detail number should be used with “SHN.” and “OPP.” written alongside the appropriate balloon.
15.3 For all items that are not detailed, such as purchased and standard items, the balloon shall contain only the identification number of the detail; no sheet number is required.

16. READING DIRECTION
16.1 Unless otherwise specified, all dimensions and notes should be placed on the drawing so that they may be viewed from the bottom of the sheet.

17. OUT OF SCALE
17.1 Dimensions out of scale should be avoided, but when a dimension cannot be made to scale (as a result of a drawing revision), then the dimension should be underlined. (Example: 5.62 DIA.)
17.2 When details must be shown broken due to sheet size restrictions, the dimension for the missing section shall be written.

18. CHANGES
18.1 The information recorded in the change column should be brief and accurate, but complete to the extent that the drawing could be reverted back to its original form.
18.2 A change letter used when recording a change should continue to be used on all of the affected sheets (assembly, B.O.M., etc.) pertaining to that change.
18.3 A change letter (upper case) should be enclosed in a 6 mm diameter balloon.
18.4 All changes should be recorded in the change column on the affected sheet or sheets.
18.5 Change letters should be placed in a vertical row in the change column.
18.6 A change letter and balloon should be placed near the revision on the affected sheet.
18.7 A change letter and balloon should also be placed at the bottom and end of the sheet (title block end) outside the border for ease of locating revisions made to the drawing.

19. STOCK LIST OR BILL OF MATERIALS
19.1 Stock lists or bills of material should not be shown on layout drawings. (See Bills of Material in this section.)

20. FAB “O” LINE DIMENSIONING
20.1 Fab “O” line dimensions should always start from the same edges as the machining datum line start dimensions.
20.2 Primary Fab “O” lines (X, Y & Z planes) should be established on the primary sub-detail. (Usually the largest sub-detail or the footprint of the detail.)
20.3 All fab setup dimensions for sub-details should be dimensioned from the two primary Fab “O” lines.
20.4 When sub-details require “CUT” dimensions, secondary Fab “O” lines should be established for that particular sub detail.
20.5 The Fab “O” line callout should reflect the sub-detail item letter. Example: Fab “O” line “A”, Fab “O” line “B” etc: these cut dimensions are used only for the specific sub-detail that is being defined.
21. HOLES AND SLOTS

21.1 All tapped, dowel and clearance holes on details are assumed to be through; it will no longer be specified on a drawing that the hole is "THRU". When a hole requires that a depth be specified, the depth shall be incorporated into the hole callout.

21.2 Construction holes are assumed to be through as shown on the drawing, or to a cross hole if applicable.

21.3 Depths for counterbored holes shall not be specified unless they are non-standard, in which case "AS SHOWN" should be noted on the drawing.

21.4 All tapped holes are assumed to have coarse threads unless otherwise specified.

21.5 On detail drawings with 3 or more hole sizes, holes shall be tabulated using the label shown.

<table>
<thead>
<tr>
<th>#</th>
<th>AFTER DOWEL SIZE, &quot;H6&quot; INDICATES PRESS FIT AND &quot;F7&quot; INDICATES SLIP FIT</th>
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<tr>
<td></td>
<td>ALL HOLES THRU EXCEPT AS NOTED</td>
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<tr>
<td>QTY.</td>
<td>TAPS</td>
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<td>-----</td>
<td>-------------------------</td>
</tr>
<tr>
<td></td>
<td>AM-M5 X 0.8</td>
</tr>
<tr>
<td></td>
<td>BM-M6 X 1.0</td>
</tr>
<tr>
<td></td>
<td>CM-M8 X 1.25</td>
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<tr>
<td></td>
<td>DM-M10 X 1.5</td>
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<td></td>
<td>EM-M12 X 1.75</td>
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<tr>
<td></td>
<td>FM-M16 X 2.0</td>
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<td>GM-M20 X 2.5</td>
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21.6 For slots, callouts for “CENT.”, “TYP.”, and “RADIUS” or “R” are assumed, and are no longer required.

22. GENERAL

22.1 All detail drawings should be datum lined.

22.2 Numbers should be used when labeling “AUX. MACHINE O-LINES”.

22.3 No stock sizes shall be dimensioned on the drawing except that, when a stock size is close to being square, one side should be dimensioned.

22.4 Stock sizes should not be noted on Bills of Material unless the item is ND (non-detailed item).

22.5 Detail identification balloons (detail sheet) shall be 20 mm diameter and sub-detail balloons 7 mm diameter.

22.6 The recommended construction or tooling ball stud diameter is 6 mm.
METRIC DETAIL TOLERANCES

NOTE:
UNLESS OTHERWISE SPECIFIED:
MAXIMUM ALLOWABLE ROUGHNESS OF ALL:
  1 PLACE FINISH DIMENSIONS TO BE 6 MICRONS
  2 PLACE FINISH DIMENSIONS TO BE 3 MICRONS
  3 PLACE FINISH DIMENSIONS TO BE 1.6 MICRONS
EXCEPT AS NOTED TOLERANCES SHALL BE:
  1 PLACE MACHINING ±0.3
  1 PLACE FABRICATION ±1.5
  2 PLACE ±0.08 BETWEEN MACHINED SURFACES
     ±0.03 BETWEEN SINGLE DOWEL AND A HEEL SURFACE
     ±0.03 BETWEEN DOWELS IN THE SAME PLANE
     ±0.10 BETWEEN DOWELS IN DIFFERENT PLANES
     ±0.13 TO SCREW HOLES, NON ACCUMULATIVE

Dowel hole tolerances
FOR PRESS FIT USE H6
FOR SLIP FIT USE F7

ALL MACHINING Q SURFACES MUST BE FINISHED EXCEPT FOR COLD DRAWN OR COLD ROLLED SURFACES.

U.S. SYSTEM DETAIL TOLERANCES

NOTE:
UNLESS OTHERWISE SPECIFIED:
MAXIMUM ALLOWABLE ROUGHNESS OF ALL:
  2 PLACE FINISH DIMENSIONS TO BE 250 MICROINCHES
  3 PLACE FINISH DIMENSIONS TO BE 125 MICROINCHES
  4 PLACE FINISH DIMENSIONS TO BE 63 MICROINCHES
EXCEPT AS NOTED TOLERANCES SHALL BE:
  2 PLACE MACHINING ±0.01
  2 PLACE FABRICATION ±0.06
  3 PLACE ±0.003 BETWEEN MACHINED SURFACES
     ±0.001 BETWEEN SINGLE DOWEL AND A HEEL SURFACE
     ±0.001 BETWEEN DOWELS IN THE SAME PLANE
     ±0.004 BETWEEN DOWELS IN DIFFERENT PLANES
     ±0.005 TO SCREW HOLES, NON ACCUMULATIVE

Dowel hole tolerances
P.F. +0.0000/-0.0005
S.F. +0.0010/+0.0005

ALL MACHINING Q SURFACES MUST BE FINISHED EXCEPT FOR COLD DRAWN OR COLD ROLLED SURFACES.
This page has been discontinued.
Please refer to the Fastener Installation and Torquing Procedure, page F-2.3.
The purpose of the Bill of Material (B.O.M.) forms is to supply the Processing and Manufacturing Departments with a common order/build document, rather than utilizing various customers stock list and build charts.

Four types of B.O.M.'s are available to supply the necessary information for processing and manufacturing. All of the following B.O.M.'s or a combination of the four may be needed.

1. **SYSTEM B.O.M.** — To be completed by the Project Engineer, which lists all the **assembly lines** that make one complete system.

2. **ASSEMBLY LINE B.O.M.** — To be completed by the Project Engineer and/or Design Supervisor, which lists all the **tools** that make one complete Right Hand and/or Left Hand assembly line or group of tools.

3. **TOOL B.O.M.** — To be completed by the Design Supervisor, which lists all the **units** that make one complete Right Hand and/or Left Hand tool.

4. **UNIT B.O.M.** — To be completed by the Tool Designer, which lists all **details** and commercial items that make one complete Right Hand and/or Left Hand unit.

   Note: On non-unitized tools, this B.O.M. would be used to list all details and commercial items for one Right Hand and/or Left Hand tool.
B.O.M. TREE DIAGRAM

FOR A SYSTEM WITH UNITIZED TOOLS

SYSTEM B.O.M.
(LISTS ALL THE LINES ON A SYSTEM)

LINE B.O.M.
(LISTS ALL THE TOOLS ON A LINE)

LINE B.O.M.
LINE B.O.M.
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TOOL B.O.M.
(LISTS ALL THE UNITS ON A TOOL)

TOOL B.O.M.
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UNIT B.O.M.
(LISTS ALL THE DETAILS AND COMMERCIAL COMPONENTS ON A UNIT)

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B.O.M. TREE DIAGRAM

FOR A SYSTEM WITH TOOLS THAT ARE NOT UNITIZED

SYSTEM B.O.M.
(LISTS ALL THE LINES ON A SYSTEM)

LINE B.O.M.
(LISTS ALL THE TOOLS ON A LINE)

UNIT B.O.M.
(LISTS ALL THE DETAILS AND COMMERCIAL COMPONENTS ON A NON-UNITIZED TOOL)

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UNIT B.O.M.

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UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

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UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.

UNIT B.O.M.
This B.O.M. is necessary for all systems which consist of multiple assembly lines. A system B.O.M. lists all the assembly lines which make up the entire system.

All spaces on the B.O.M. are to be completed by the designed Project Engineer as described below. See the following pages for the location of System B.O.M. identification balloons and B.O.M. example.

1. DESCRIPTION
   The name of the system is to be printed in this block, on the first sheet of any group of Bill of Materials. Leave this space blank in all subsequent sheets of a B.O.M.

2. B.O.M. PAGE:
   List the page number on each page and the total number of system B.O.M. pages on page #1 only. When adding a sheet to the sequence of a released group of B.O.M. sheets, you must revise the first sheet, you must revise the first sheet, “1 of–”, to coincide. Then list the change in the revision column accordingly and include sheet #1 in the release to processing.

3 CUSTOMER:
   Enter customer name.

4. PROGRAM:
   Enter program code name.

5. ASSEMBLY LINE/TOOL NUMBER:
   When a customer has assigned a number to each assembly line which covers a group of tools, then enter the assembly line number. If the right hand assembly line has a different assembly line number than the left hand, write the numbers on different spaces. Leave a blank space between each line of text for subsequent revisions.

<table>
<thead>
<tr>
<th>ASSEMBLY LINE NO.</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1234</td>
<td>B/S INNER LINE</td>
</tr>
<tr>
<td>1235</td>
<td>B/S INNER LINE</td>
</tr>
</tbody>
</table>
6. DESCRIPTION:
List the name of each assembly line when the right hand and left hand lines have
different assembly line numbers. (See example above). If the right hand and left
hand assembly lines do not have different assembly line numbers assigned to
them, the names can be entered on the same description line. Then note the
quantity of each in area nine (See example below). Leave a blank space between
each line for subsequent revisions.

<table>
<thead>
<tr>
<th>DESCRIPTION</th>
<th>DESIGN SOURCE</th>
<th>BUILD SOURCE</th>
<th>L.H. LINE</th>
<th>R.H. LINE</th>
</tr>
</thead>
<tbody>
<tr>
<td>B/S OUTER LINE</td>
<td>B. ENGINEERING</td>
<td>D. FABRICATION</td>
<td>J. BLOUGH</td>
<td>J. DOE</td>
</tr>
</tbody>
</table>

7. DESIGN SOURCE/CONTACT:
For inside design, list the design supervisor. For outside design vendors, list the
name of the design company, and below it list the Project Engineer.

8. BUILD SOURCE/CONTACT:
For inside build, list the build processor. For outside build vendors, list the name
of the build company and below it, list the contact.

9 QUANTITY:
List quantities in their respective column. If the assembly line is neither hand, the
quantities are shown in the right hand column. If the assembly line is right hand
and left hand, the quantities are shown in both columns.

10. SOURCE:
Enter a symbol from the source legend which indicates the method of acquisition
of each assembly line.

11. BY:
Enter the Project Engineer's name.

12. CHECKER:
The checker will enter their first initial and last name after completion of check,

13. DATE RELEASED/RELEASED BY:
Enter the release date and initials, diagonal arrowed lines are acceptable. The
System B.O.M. will be the first B.O.M. released on a multiple assembly line
system. The System B.O.M. will be released to processing one time only, unless
there are revisions, cancellations, or additions.
14. REVISIONS:
   Enter the revision date and change letter for this particular B.O.M. page. Enter a
description of the revision and note what the B.O.M. "was" before the revision.
Enter the initials of the designer and checker upon completion of revision. All
changes to a released B.O.M., such as quantity or a cancellation, must be recorded
in the revision column and released immediately to the Processing Department. If a
line has been canceled or removed from a B.O.M., then that change only affects
that particular B.O.M. sheet. Lines removed or canceled from a B.O.M. must be
crossed out with a single line and not erased.

15. LOGO BLOCK:
   This area is reserved for the appropriate logo.
<table>
<thead>
<tr>
<th>BOM PAGE</th>
<th>DATE RELEASED</th>
<th>RELEASER</th>
<th>SOURCE</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>SYSTEM B.O.M.</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>PROGRAM</th>
<th>DESCRIPTION</th>
<th>CUSTOMER ASSEMBLY LINE NO.</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>R.H. LINE</th>
<th>L.H. LINE</th>
<th>BUILD SOURCE</th>
<th>CONTACT</th>
<th>DESIGN SOURCE</th>
<th>CONTACT</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
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<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>SOURCE LEGEND</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>CHG LTR</th>
<th>DRAWN</th>
<th>CHK'D</th>
<th>DATE</th>
<th>REVISIONS/REASON FOR CHECKER</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>M - MAKE</th>
<th>I - ITEM, SUB CONTRACTED BUILD</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>P - PURCHASE ITEM, SUPPLIED BY CUSTOMER</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>F - FURNISHED, SUPPLIED BY CUSTOMER</th>
</tr>
</thead>
</table>

©1997 Auto/Steel Partnership This document is Uncontrolled when printed.
<table>
<thead>
<tr>
<th>SYSTEM B.O.M.</th>
<th>DESCRIPTION</th>
<th>L.H. LINE</th>
<th>r.h. LINE</th>
<th>CONTACT</th>
<th>BUILD SOURCE</th>
<th>DESIGN SOURCE</th>
<th>CONTACT</th>
<th>SOURCE</th>
</tr>
</thead>
<tbody>
<tr>
<td>1999 BRAND &quot;X&quot; BODYSIDE SYSTEM</td>
<td>BODYSIDE MAINLINE</td>
<td>1</td>
<td>M</td>
<td>COMPANY &quot;W&quot;</td>
<td>COMPANY &quot;X&quot;</td>
<td>COMPANY &quot;Y&quot;</td>
<td>JANE DOE</td>
<td>M</td>
</tr>
<tr>
<td></td>
<td>BODYSIDE INNER LINE</td>
<td>1</td>
<td>M</td>
<td>COMPANY &quot;W&quot;</td>
<td>COMPANY &quot;X&quot;</td>
<td>COMPANY &quot;Y&quot;</td>
<td>JANE DOE</td>
<td>M</td>
</tr>
<tr>
<td></td>
<td>BODYSIDE MAINLINE SUB-ASSYS</td>
<td>1</td>
<td>M</td>
<td>COMPANY &quot;W&quot;</td>
<td>COMPANY &quot;X&quot;</td>
<td>COMPANY &quot;Y&quot;</td>
<td>JANE DOE</td>
<td>M</td>
</tr>
<tr>
<td></td>
<td>SURGE SYSTEM</td>
<td>1</td>
<td>M</td>
<td>COMPANY &quot;W&quot;</td>
<td>COMPANY &quot;X&quot;</td>
<td>COMPANY &quot;Y&quot;</td>
<td>JANE DOE</td>
<td>M</td>
</tr>
<tr>
<td></td>
<td>CENTER PILLAR SU-ASS'Y LINE</td>
<td>1</td>
<td>M</td>
<td>COMPANY &quot;W&quot;</td>
<td>COMPANY &quot;X&quot;</td>
<td>COMPANY &quot;Y&quot;</td>
<td>JANE DOE</td>
<td>M</td>
</tr>
</tbody>
</table>
ASSEMBLY LINE
B.O.M. INSTRUCTIONS

This B.O.M. is necessary for all assembly lines or group of tools which consists of multiple tool numbers. A Line B.O.M. lists all the separate tool numbers which make one right hand and/or left hand line. It acts as a multiplier of tool B.O.M.’s much like a build chart. All spaces are to be completed by the project engineer and/or design supervisor as described below for each assigned assembly line or group of tools. See the following pages for the location of Line B.O.M. Identification balloons and B.O.M. example.

1. DESCRIPTION:
The name of the system, assembly line or group of tools is to be printed in this block, on the first sheet of any group of Bill of Materials. Leave this space blank in all subsequent sheets of a B.O.M.

2. TOOL NUMBER:
If a customer has assigned a tool number to an assembly line or a group of tools, then enter the tool number which is shown, in the upper space and the one which is opposite, in the lower space.

Right hand and left hand lines must be indicated using the suffix of -R or -L after the tool number.

<table>
<thead>
<tr>
<th>TOOL NO.</th>
<th>RIGHT HAND SHOWN &amp; LEFT HAND OPPOSITE</th>
</tr>
</thead>
<tbody>
<tr>
<td>16ZF-53515-R</td>
<td>(SHOWN)</td>
</tr>
<tr>
<td>16ZF-53516-L</td>
<td>(OPPOSITE)</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>TOOL NO.</th>
<th>SINGLE HAND TOOL</th>
</tr>
</thead>
<tbody>
<tr>
<td>16ZF-53518</td>
<td>(SHOWN)</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>TOOL NO.</th>
<th>LEFT HAND TOOL SHOWN &amp; RIGHT HAND OPPOSITE (TRUCK &amp; BUS)</th>
</tr>
</thead>
<tbody>
<tr>
<td>T49465-S-L</td>
<td>(SHOWN)</td>
</tr>
<tr>
<td>T49465-S-R</td>
<td>(OPPOSITE)</td>
</tr>
</tbody>
</table>

3. B.O.M. PAGE:
List the page number on each page and the total number of line B.O.M. pages on page #1 only. When adding a sheet to the sequence of a released group of B.O.M. sheets, you must revise the first sheet, "1 of—", to coincide. Then list the change in the revision column accordingly and include sheet #1 in the release to processing.

4. CUSTOMER:
Enter customer name.

5. PROGRAM:
Enter program code name.
6. DESIGN SOURCE:
The name of the design source is to be printed in this block on Sheet #1 only.

7. BUILD SOURCE:
The name of the build source is to be printed in this block on Sheet #1 only.

8. TOOL NUMBER:
List the tools in numerical order. Leave one blank space between each line of text for subsequent revisions.

9. DESCRIPTION:
Enter a simple tool description.

10. QUANTITY:
Enter the quantity of each tool required to build only one SHOWN and/or OPPOSITE line in their respective columns. If the line will be built as shown on the tool layout drawings, place the required quantity in the SHOWN column. If the line will be built opposite (mirror image) to what is shown on the tool layout drawings, place the required quantity in the OPPOSITE column. The line B.O.M. acts as a multiplier of tool B.O.M.’s.

11. SOURCE:
Enter a symbol from the source legend which indicates the method of acquisition of each assembly line.

12. PROJECT MANAGER:
Enter the Project Managers first initial and last name.

13. DESIGN SUPERVISOR:
Enter the Design Supervisors first initial and last name.

14. CHECKER:
The checker will enter their first initial and last name after completion of check.

15. DATE RELEASED/RELEASED BY:
Enter the release date and initials. Diagonal arrowed lines are acceptable. The Line B.O.M. will be released to the processing department after the system B.O.M. (if applicable) and before the tool B.O.M.’s are released. The Line B.O.M. will be released to processing one time only unless there are revisions, cancellations or additions.
16. REVISIONS:

Enter the revision date and change letter for this particular B.O.M. page. Enter a description of the revision and note what the B.O.M. “was” before the revision. Enter the initials of the designer and checker upon completion of revision. All changes to a released B.O.M., such as quantity or a cancellation, must be recorded in the revision column and released immediately to the Processing Department. If a tool has been canceled or removed from a B.O.M., then that change only affects that particular B.O.M. sheet. Tools removed or cancelled from a B.O.M. must be crossed out with a single line and not erased. If a carry over tool has been removed or canceled from all lines, then all affected line B.O.M.’s and line layout drawings must be revised and released.

17. LOGO BLOCK:

This area is reserved for the appropriate logo.
<table>
<thead>
<tr>
<th>TOOL NO.</th>
<th>DESCRIPTION</th>
<th>REMARKS OR SPECIAL INSTRUCTIONS</th>
<th>OPP</th>
<th>SHN</th>
<th>SOURCE</th>
<th>DATE RELEASED</th>
<th>CHG LTR</th>
<th>DRAWN BY</th>
<th>CHK'D BY</th>
<th>PROJECT MGR.</th>
<th>DESIGN SUPV.</th>
<th>CHECKER</th>
</tr>
</thead>
<tbody>
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</tr>
</tbody>
</table>

**SOURCE LEGEND**

- M: MAKE ITEM
- P: PURCHASE ITEM, SUB CONTRACTED BUILD
- F: FURNISHED, SUPPLIED BY CUSTOMER
<table>
<thead>
<tr>
<th>TOOL NO.</th>
<th>DESCRIPTION</th>
<th>REMARKS OR SPECIAL INSTRUCTIONS</th>
<th>OPP</th>
<th>SHN</th>
<th>OPP</th>
<th>SHN</th>
<th>DATE RELEASED</th>
</tr>
</thead>
<tbody>
<tr>
<td>16ZF-55802-3</td>
<td>15 STA. B/S ASS'Y TL'G</td>
<td></td>
<td>1</td>
<td></td>
<td>1</td>
<td>M</td>
<td>2/12/97</td>
</tr>
<tr>
<td>12ZF-690-1</td>
<td>15 STA. TRANSFER</td>
<td></td>
<td>1</td>
<td></td>
<td>1</td>
<td>M</td>
<td>2/12/97</td>
</tr>
<tr>
<td>16ZF-55814-5</td>
<td>BODY VISION CHECKING SYS.</td>
<td></td>
<td>1</td>
<td></td>
<td>1</td>
<td>M</td>
<td>2/12/97</td>
</tr>
<tr>
<td>56ZF-28361-2</td>
<td>B/SIDE OTR. DEL. HOOK</td>
<td></td>
<td>1</td>
<td></td>
<td>1</td>
<td>M</td>
<td>2/12/97</td>
</tr>
<tr>
<td>16ZF-55769-7</td>
<td>B/SIDE OTR. DEL. HOOK</td>
<td>QUALIFYING FIXTURE</td>
<td>1</td>
<td></td>
<td>1</td>
<td>M</td>
<td>2/12/97</td>
</tr>
</tbody>
</table>
TOOL B.O.M. INSTRUCTIONS

Assembly 02/12/97

This B.O.M. is necessary for all tools which consist of multiple units. A Tool B.O.M. lists all the separate units which make one right hand and/or left hand tool. The Tool B.O.M. acts as a multiplier of unit B.O.M.'s much like a build chart. All spaces are to be completed by the Design Supervisor as described below. See the following pages for the location of Line B.O.M. identification balloons and B.O.M. example.

1. DESCRIPTION:
The name of the system, assembly line or group of tools is to be printed in this block, on the first sheet of any group of Bill of Materials. Leave this space blank in all subsequent sheets of a B.O.M.

2. TOOL NUMBER:
Enter the customers assigned tool number which is shown, in the upper space and the one which is opposite, in the lower space.

Right hand and left hand lines must be indicated using the suffix of -R or -L after the tool number.

   TOOL NO.   RIGHT HAND SHOWN & LEFT HAND OPPOSITE
   16ZF-53515-R (SHOWN)  16ZF-53518 (SHOWN)
   16ZF-53516-L (OPPOSITE)

   TOOL NO.   SINGLE HAND TOOL
   16ZF-53518 (OPPOSITE)

3. B.O.M. PAGE:
List the page number on each page and the total number of system B.O.M. pages on page #1 only. When adding a sheet to the sequence of a released group of B.O.M. sheets, you must revise the first sheet, “1 of—”, to coincide. Then list the change in the revision column accordingly and include sheet #1 in the release to processing.

4. CUSTOMER:
Enter customer name.

5. PROGRAM:
Enter program code name.

6. DESIGN SOURCE:
The name of the design source is to be printed in this block on Sheet #1 only.

7. BUILD SOURCE:
The name of the build source is to be printed in this block on Sheet #1 only.
8. TOOL NUMBER:
   Enter the tool number for each unit. Diagonal arrowed lines are acceptable to
   minimize writing. This column is necessary because some customers will allow
   units to be carried over from other tools.

9. UNIT NUMBER:
   List the units in numerical order starting with the Key Sheet. This information is
   basically a duplication of the Key Sheet.
   Carry over units will be identified with the symbol C/O following the unit number.
   In the special instruction column show from what tool it originated from within that
   program. Leave one blank space between each line of text for subsequent revi-
   sions.

10. DESCRIPTION:
    Enter a simple unit description.

11. QUANTITY:
    Enter the quantity of each unit required to build only one SHOWN and/or OPPO-
    SITE tool in their respective columns. If the unit will be built as shown on the unit
    layout drawings, place the required quantity in the SHOWN column. If the unit will
    be built opposite (mirror image) to what is shown on the unit layout drawings,
    place the required quantity in the OPPOSITE column. The tool B.O.M. acts as a
    multiplier of unit B.O.M.'s.

12 SOURCE:
   Enter a symbol from the source legend which indicates the method of acquisition
   of each unit.

13. PROJECT MANAGER:
    Enter the Project Managers first initial and last name.

14. DESIGN SUPERVISOR:
    Enter the Design Supervisors first initial and last name.

1.5 CHECKER:
   The checker will enter their first initial and last name after completion of check.

16. DATE RELEASED/RELEASED BY:
    Enter the release date and initials. Diagonal arrowed lines are acceptable. The
    Tool B.O.M. will be released to the processing department after the Line B.O.M.
    (if applicable) and before the unit B.O.M.'s are released. The Tool B.O.M. will be
    released to processing one time only unless there are revisions, cancellations or
    additions.
17. REVISIONS:
   Enter the revision date and change letter for this particular B.O.M. page. Enter a
description of the revision and note what the B.O.M. “was” before the revision. Enter
the initials of the designer and checker upon completion of revision. All changes to
a released B.O.M., such as quantity or a cancellation, must be recorded in the
revision column and released immediately to the Processing Department. If a unit
has been canceled or removed from a B.O.M., then that change affects only that
particular B.O.M. sheet. Units removed or canceled from a B.O.M. must be crossed
out with a single line and not erased. If a carry over unit has been removed or
canceled from all tools, then all affected tool B.O.M.'s and tool Key sheet drawings
must be revised and released.

18. REVISIONS LEVEL:
   Enter Rev. level letter of the unit in this column when the job is completed and
shipped.

19. SUPPLIER UNIT NO.:
    When applicable, list the Supplier Unit Number.

20. LOGO BLOCK:
    This area is reserved for the appropriate logo.
## TOOL B.O.M.

### Tool B.O.M. Instructions

**Description:** (Fill out on sheet one only)

<table>
<thead>
<tr>
<th>TOOL NO.</th>
<th>CUSTOMER UNIT NO.</th>
<th>SUPPLIER UNIT NO.</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>1</td>
<td>1</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>2</td>
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<tr>
<td>7</td>
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</tbody>
</table>

**Remarks or Special Instructions:**

<table>
<thead>
<tr>
<th>COPY</th>
<th>SHN</th>
<th>OPP</th>
<th>SOURCE</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
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</tr>
</tbody>
</table>

**Source Legend:**

- M - Make Item
- P - Purchase Item, Subcontracted Build
- F - Furnished, Supplied by Customer

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**Notes:**

- The table is designed to organize and track various components, their suppliers, and notes related to them.
- Each row can be filled out to detail specific components and their specifications.
- The source legend helps in identifying the type of each component (Make Item, Purchase Item, Furnished Item).
<table>
<thead>
<tr>
<th>Tool No.</th>
<th>Customer Unit No.</th>
<th>Supplier Unit No.</th>
<th>Description</th>
<th>Remarks or Special Instructions</th>
<th>Source</th>
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</table>

**Source Legend**

- **M**: Make Item
- **P**: Purchase Item, Sub Contracted Build
- **F**: Furnished, Supplied by Customer

**Assembly**

- Brand "X" Bodyside Mainline

**Tool B.O.M.**

- Opposite Tool Shown
- Opposite of Tool
- B.O.M. Page 1 of 1
UNIT B.O.M. INSTRUCTIONS

This B.O.M. is necessary for all units or non-utilized tools. A unit B.O.M. lists all the commercial, manufactured, and customer furnished components which make one right hand and/or left hand unit. All spaces are to be completed by the Tool Designer as described below, except where noted. See the following pages for the location of Unit B.O.M. identification balloons and B.O.M. example.

Items not required on the Unit B.O.M.'s will be listed separately per Build Source.

1. DESCRIPTION:
   The name of the system, assembly line or group of tools is to be printed in this block, on the first sheet of any group of Bill of Materials. Leave this space blank in all subsequent sheets of a B.O.M.

2. TOOL NUMBER:
   Enter the customers assigned tool number which is shown, in the upper space and the one which is opposite, in the lower space.
   Right hand and left hand lines must be indicated using the suffix of -R or -L after the tool number.

3. UNIT NUMBER:
   Enter the unit's number. Do not add a suffix to show the unit's hand. The “shown/opposite” information is found on the tool B.O.M.
   Cross out this space for non-unitized tools.

4. B.O.M. PAGE:
   List the page number on each page and the total number of Unit B.O.M. pages on page #1 only. When adding a sheet to the sequence of a released group of B.O.M. sheets, revise the first sheet, “1 of___”, to coincide. Then list the change in the revision column accordingly and include sheet #1 in the release to processing.

5. CUSTOMER:
   Enter customer name.

6. PROGRAM:
   Enter program code name.

7. DESIGN SOURCE:
   The name of the design source is to be printed in this block on Sheet #1 only.
UNIT B.O.M.
INSTRUCTIONS

8. BUILD SOURCE:
The name of the build source is to be printed in this block on Sheet #1 only.

9. CUSTOMER DETAIL NUMBER:
List all detail components as shown on the layout drawings in the following order: commercial items, customer standard items, and make items last.

10. SUPPLIER DETAIL NUMBER:
When applicable list the Supplier’s Detail Number.

11. SUB-DETAIL:
Enter sub-detail identification number/letter.

12. REVISION:
Enter revision level shown on the individual detail.

13. SHOWN ON LAYOUT (L/O) SHEET:
When a unit consists of three assembly layout sheets or more, enter the layout sheet number on which the detail has been “called out” (ballooned). The detail number is “called out” on one layout sheet only, although it may be “referenced” on several sheets.

14. NAME:
A name is to be given to every item listed and it should be the same name as on the detail drawing.

15. MATERIAL:
List the specific material type for make details. Use the S.A.E. material code number and specify if it is H.R.S. or C.R.S. finish.

16. SPECIFICATION AND/OR SPECIAL INSTRUCTIONS:
Enter all information necessary to obtain the material and/or altered item. Size, material specifications, model numbers “altered see L/O”, one makes two symbol , cut to layout symbol , source of commercial items, are a few examples of information appearing in this column. N.D. (not drawn) detail stock sizes should also be listed in this column.

The stock sizes of each detail must be listed.
When plate, tubing, angles, channels, etc., that are produced to U.S. customary units are specified, the cross section dimensions should be called out in U.S. customary units and the cut length in metric.
17. QUANTITY:

Quantity entries are determined depending if the tool is non-handed, right and/or left handed whether the tool is unitized or not. “SHOWN” means to build the detail as it is drawn. “OPPOSITE” means to build the detail opposite (mirror image) of what is drawn.

1. The following rules apply:

A. If the tool has units that are non-handed, quantities are entered in the SHOWN unit column.

<table>
<thead>
<tr>
<th>OPPOSITE UNIT</th>
<th>SHOWN UNIT</th>
</tr>
</thead>
<tbody>
<tr>
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<td>OPP SHN</td>
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<tr>
<td>1</td>
<td>1</td>
</tr>
</tbody>
</table>

B. If the tool has both SHOWN and OPPOSITE units, quantities are entered in both the SHOWN and OPPOSITE unit columns.

<table>
<thead>
<tr>
<th>OPPOSITE UNIT</th>
<th>SHOWN UNIT</th>
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</thead>
<tbody>
<tr>
<td>OPP SHN</td>
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<td>1</td>
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<tr>
<td>1</td>
<td>1</td>
</tr>
</tbody>
</table>

C. If the tool contains SHOWN only or OPPOSITE only units, the quantities are entered in their respective columns.

<table>
<thead>
<tr>
<th>OPPOSITE UNIT</th>
<th>SHOWN UNIT</th>
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</thead>
<tbody>
<tr>
<td>OPP SHN</td>
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<table>
<thead>
<tr>
<th>OPPOSITE UNIT</th>
<th>SHOWN UNIT</th>
</tr>
</thead>
<tbody>
<tr>
<td>OPP SHN</td>
<td>OPP SHN</td>
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</table>

<table>
<thead>
<tr>
<th>OPPOSITE UNIT</th>
<th>SHOWN UNIT</th>
</tr>
</thead>
<tbody>
<tr>
<td>OPP SHN</td>
<td>OPP SHN</td>
</tr>
<tr>
<td>1</td>
<td>1</td>
</tr>
</tbody>
</table>
2. In all cases, the quantity of components is to reflect the amount necessary to build only one shown and/or opposite unit. On unitized jobs a tool B.O.M. is required to show the total number of units required to make one complete tool. On non-unitized jobs a line B.O.M. is required to show the total number of tools required to make one complete line. Non-unitized tools do not require a tool B.O.M. Treat the non-unitized tool like a unit, utilizing a Unit B.O.M.

18. SOURCE:
   Enter a symbol from the source legend which indicates the method of acquisition of each item.

19. PROJECT MANAGER:
   Enter the Project Managers first initial and last name.

20. DESIGNER:
    Enter the tool designers first initial and last name.

21. CHECKER:
    The checker will enter their first initial and last name after completion of check.

22. HI-SPOT:
    The person who performed the hi-spot will enter their first initial and last name.

23. DESIGN SUPERVISOR:
    Enter the Design Supervisors first initial and last name.
24. DATE RELEASED/RELEASED BY:

These columns are to be completed by the design supervisor or design leader.

1. Fab (fabrication) Release.

   To achieve the build completion dates on certain programs, it may be necessary to expedite the fabrication of some details before the machining information is available. On details such as large bases the detail drawing can be completed and checked for fabrication, but the hole pattern can not be checked and completed until the last unit that bolts to the base is drawn. Consult with the Project Engineer on which details should be preliminary released for fabrication only, to achieve the build completion dates.

   To preliminary order a detail for “fabrication only”, the design supervisor or design leader is to enter the release date and their initials in the “Fab” column. Diagonal arrowed lines are acceptable for the release of multiple details.

2. Final Release

   A “Final Release” on any detail or component constitutes authorization to construct or order those items. Long lead commercial items which take more than six weeks for delivery will be final released to Processing during the layout process. Check with the Project Engineer for the list of long lead items.

   When ordering special items use the special instructions column to enter the name of the supplier which worked with Engineering and the quoted price and delivery if available.

   To final order a detail, the Design Supervisor or Design Leader is to enter the release date and their initials in the “Final” column. Diagonal arrowed lines are acceptable for the release of multiple details.
25. REVISIONS:

Enter the revision date and change letter, when making a revision to an assembly and/or detail and/or B.O.M., the change letter will be the same on all affected sheets for that change. A change letter will only be used once per unit, regardless of the type of document. Enter a description of the revision, include the detail number and note what the B.O.M. “was” before the revision. Enter the initials of the designer and checker upon completion of revision. All changes to a released B.O.M., such as quantity or a cancellation, must be recorded in the revision column and released immediately to the Processing Department.

If a detail has been canceled or removed from a B.O.M., then that change only affects that particular B.O.M. sheet. Details removed or canceled from a B.O.M. must be crossed out with a single line and not erased. If a carry over detail has been removed or canceled from all units, then all affected unit B.O.M.’s and unit layout drawing must be revised and released.

26. SERVICE:

Place and “X” in this column if the detail is considered a wear item and spare parts need to be considered.

27. LOGO BLOCK:

This area is reserved for the appropriate logo.
### UNIT B.O.M. INSTRUCTIONS

<table>
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<tr>
<th>Column 1</th>
<th>Column 2</th>
<th>Column 3</th>
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<tbody>
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**Notes:**
- F - Furnished by Customer
- NC - Numerical Controlled Machining
- M/P - Make Item Containing Purchase Item(s)
- M - Make Item
- R - Rework
- P - Purchase Item
- APPROVAL REQUIRED FOR SUBSTITUTION

**Specifications and Special Instructions:**
- ONE MAKES TWO
- FILL OUT ON SHEET ONE ONLY
- THIS DOCUMENT IS UNCONTROLLED WHEN PRINTED
### 15 STATION B/S ASS'Y. LINE

**UNIT B.O.M.**

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**DESCRIPTION**: (FILL OUT ON SHEET ONE ONLY)

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**DESCRIPTION**: (FILL OUT ON SHEET ONE ONLY)

**UNIT B.O.M.**

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<th>DESCRIPTION</th>
<th>DESIGN SOURCE</th>
<th>BUILD SOURCE</th>
<th>L.H. LINE</th>
<th>R.H. LINE</th>
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</table>

**SOURCE LEGEND**

- **M** - MAKE ITEM
- **P** - PURCHASE ITEM, SUB CONTRACTED BUILD
- **F** - FURNISHED, SUPPLIED BY CUSTOMER
<table>
<thead>
<tr>
<th>TOOL NO.</th>
<th>DESCRIPTION</th>
<th>REMARKS OR SPECIAL INSTRUCTIONS</th>
<th>TOOL NO. (SHOWN)</th>
<th>TOOL NO. (OPPOSITE)</th>
<th>SOURCE</th>
<th>DATE RELEASED</th>
<th>DRAWN BY</th>
<th>CHK'D BY</th>
<th>PROJECT MGR</th>
<th>DESIGN SUPV</th>
<th>CHECKER</th>
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**SOURCE LEGEND**

- M - MAKE ITEM
- P - PURCHASE ITEM, SUB CONTRACTED BUILD
- F - FURNISHED, SUPPLIED BY CUSTOMER
<table>
<thead>
<tr>
<th>UNIT B.O.M.</th>
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<tr>
<td>SUPPLIER DETAIL NO.</td>
<td>DESIGN SOURCE</td>
</tr>
<tr>
<td>MATERIAL</td>
<td>DESIGN SUPV.</td>
</tr>
<tr>
<td>NAME</td>
<td>SOURCE LEGEND</td>
</tr>
<tr>
<td>SERVICE</td>
<td>HI-SPOT CHECKER</td>
</tr>
</tbody>
</table>

**SOURCE LEGEND**: M - MAKE ITEM; P - PURCHASE ITEM; MP - MAKE ITEM CONTAINING PURCHASE ITEM(S); NC - NUMERICAL CONTROLLED MACHINING

**SPECIFICATIONS AND/OR SPECIAL INSTRUCTIONS**: ONE MAKES TWO; CUT TO LAYOUT

**DATE RELEASED**: (SHOWN) (OPPOSITE)

**RELEASED BY**: NAME

**DATERELEASED**: (FILL OUT ON SHEET ONE ONLY)

**REVISION LEVEL**: SUB-LEVEL

**REVISION**: ON SHEET

**REVISIONS / REASON FOR**: DATE

**CUSTOMER DETAIL NO.**: (SHOWN) (OPPOSITE)

**BUILDSOURCE**: (SHOWN)

**DESIGNSOURCE**: (OPPOSITE)

**DESCRIPTION**: (SHOWN) (OPPOSITE)

**PROGRAM**: (SHOWN) (OPPOSITE)

**SUPPLIER DETAIL NO.**: (SHOWN) (OPPOSITE)