

DOCKET NO.: SA-515
EXHIBIT NO. 8B-1

NATIONAL TRANSPORTATION SAFETY BOARD
WASHINGTON, D.C.

VOLVO MANUFACTURING DRAWING 0-169282
SHEETS 1 AND 4

VOLVO HUB FRONT DRILL PROCESS HISTORY

(3 PAGES)

DETTA DOCUMENT ÄR VOLVO FLYGMOTORS EGENDOM. DET
 FÅS INTE REPRODUCERA, KOPIERA, FÖRÄNDRA, FÖR
 SÄLJA, UTLÄNDA, UTAN VOLVO FLYGMOTORS SKRIFTELIG
 TILLÅTTELSE. MEDFÖRÄNDE PRODUCERAS, DELS, FREDJE PART, ELLER
 ANVÄNDAS FÖR ANRAT ANDAMÅL, ÄR FÖR VILKET DET TILL-
 HÅNDVÄLLITS, ÖVERTRÄDELSE HÄRAV BEIVRAS MED STDB
 AV GÅLLARDE LAB.

NR NO	OPERATIONSSTEG OPERATION SEQUENCE		GGR NUMBER	POS	VERKTYG REFNR REF NO OF TOOL
	C.BORRA	V3-1309304:9	48	1	01025
	BORRA 11.25	V4-1311324:16	24	2	02189
	BORRA 12.25	V4-1311324:17	24	3	02190
	ARBORRA 12.60	V4-1311557	1	4	06046
	ARBORRA 12.85	V4-1311557	1	5	06047
	FRÅS ÖRON	DIAM. 8 STD.	17	6	08053
	FRÅS ÖRON	DIAM.6 STD.	17	7	08035
	BORRA 2.90	V4-1326004	24	8	02055
	C.DRILL	V3-1309304:9	48	1	01025
	DRILL 11.25	V4-1311324:16	24	2	02189
	DRILL 12.25	V4-1311324:17	24	3	02190
	BORE 12.60	V4-1311557	1	4	06046
	BORE 12.85	V4-1311557	1	5	06047
	MILL TABS	DIAM. 8 STD.	17	6	08053
	MILL TABS	DIAM. 6 STD.	17	7	08035
	DRILL 2.90	V4-1326004	24	8	02055

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 VOLVO ABRO CORPORATION
 Trollhättan, Sweden

Handwritten signature

FÖR INFORMATION
 EV. ÄNDRINGAR MEDDELAS EJ

TITAN HANTERAS
ENL 18 98 01

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VOLVO FLYGMOTOR AB			SKÄRANDE BEARBETNING MACHINING NC			
	DATUM / DATE	NAMN / NAME	SIGN	CSD	KRITISK CRITICAL 17 79 15	TILLV GRUPP MFG GROUP
FRTAD DRAWN	930901	INGE OSCARSSON	IO			02
GRANSKAD CHECKED	930901	ROGER OHLSSON	RO			
GODKÄND APPROVED	930901	TONY KARLSSON	<i>[Signature]</i>	RITNING NR / DRAWING NO	UTGÅVA ISSUE	BLADNR SHEET NO
				0-169282	04	4 (4)

(2)

16047
16046
121

Addendum 1 to DWG 0-169292

HUB FRONT DRILL HISTORY

DATE	DRILLTYPE	DIM.	SPEED R.P.M.	FEED MM/REV
① -84	HSS STD DRILL	11.0	300	0.1
	" "	12.3	300	0.1
② 880211	COOLANT DRILL			
	V4-1326399:1	11.20	700	0.1
	V4-1326399:2	12.20	700	0.1
③ 900830	SANDVIK DELTA			
	STD. } 2 DIREK.	11.25	1000	0.2
	STD. }	12.25	920	0.2
④ 900914	HSS DRILL 1 DIREK			
	V3-1311324:16	11.20	300	0.1
	V3-1311324:17	12.20	300	0.1
90.11.27				
⑤ 901210	HSS DRILL 2 DIREK			
	V3-1311324:18	11.20	300	0.1
	V3-1311324:19	12.20	300	0.1
⑥ 910226	COOLANT DRILL			
	SOLID CARBIDE			
	V4-1326615:1	11.25	1000	0.15
	V4-1326615:2	12.25	920	0.15
	2 DIREK.			
⑤ 910331	HSS DRILL 2 DIREK			
	V3-1311324:18	11.20	300	0.1
	V3-1311324:19	12.20	300	0.1
920505				
⑦ 920908	COOLANT DRILL			
	V4-1326280:1	11.25	700	0.1
	V4-1326280:2	12.25	700	0.1
	1 DIREK.			
⑤ 920916	HSS DRILL 2 DIREK			
	V3-1311324:18	11.20	300	0.1
	V3-1311324:19	12.20	300	0.1
④ 930902	HSS DRILL 1 DIREK			
	V3-1311324:16	11.20	300	0.1
	V3-1311324:17	12.20	300	0.1
⑧ 960418	COOLANT DRILL			
	SOLID CARBIDE			
	V4-1315683:7	11.25	700	0.1
	V4-1315683:8	12.25	700	0.1
	1 DIREK.			
④ 960419	HSS DRILL 1 DIREK			
	V3-1311324:16	11.20	300	0.1
	V3-1311324:17	12.20	300	0.1

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Tollstättan, Sweden

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