

CUSTOMER #: MILES YOTE (MINUTE) WORK ORDER #: 50892

MODEL #: 10-540-KIAS. DATE: 02/13/19

ENGINE FLOW CHART
MAJOR OVERHAUL

1 INITIAL STEP

- Work Order Number Assigned
- Receiving Sheet
- Pictures

2 DISASSEMBLY

- Disassemble Engine
- Accessories Sent Out: Cam, Oil Cooler, Cad Plate, etc.

3 CLEANING

- Hardware Blast (Cad)
- Magnaflux and Zygo "B" Blast
- Cylinders Blast for Inspection
- Blast/Alodine appropriate parts

4 INSPECTION

- Magnaflux and Zygo *less case/crank*
- Visual & Dimensional Inspect
- AD & SB Check
- Parts Ordered

5 PRE-ASSEMBLY

- Prep Engine (Rods, Rocker Arm, etc.)
- Cylinder Build Up
- Paint Done

6 ASSEMBLE

- Parts Double Check
- Accessories Back
- Assemble

7 DELIVERY

- Cap Plug Install
- Yellow Tags / Copied
- Delivery Sheet Made
- Log Books / Invoice