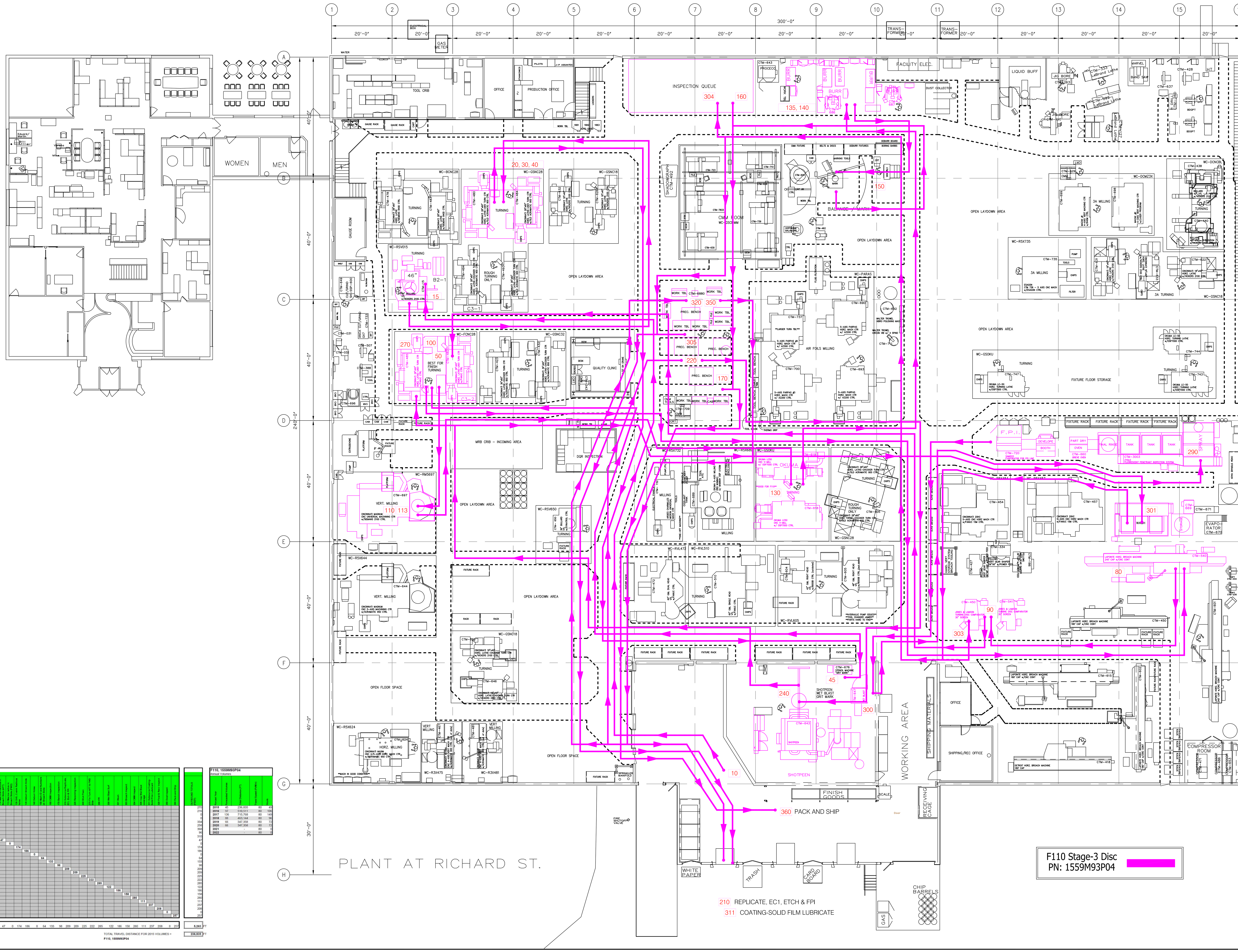

F110, 1559M93P04

From: \ To:	15 Qualify Face and OD Dia.	20 Rough Trn Fwd, mark PN OD	30 Rough Turn AFT Side	40 Fin Turn AFT side	45 Inprocess Marking	50 Fin turn FWD Side	80 Broach 48 Slots	90 Broach Inspection	100 Finish Turn Groove Fwd/Aft Side	110 Machine Radious in Broach Slots (AFT)	113 Macine radius in Broach Slots (FWD)	130 Drill, C-sink Radious holes	135 Deburr Broach Slots	140 Deburr Holes	150 Mark ID and Numbers on Broach Slots	160 CMM Inspection	170 Bench Inspection	210 Outsource Replicate, ECI, Etch & FPI	220 Receiving Inspection	240 Shot Peen	270 Fin Turn AFT & FWD Side	290 FPI	300 Wet Blast Surf	301 Wash	303 Broach Inspect	304 CMM Inspect	305 Insp Wet Blast coverage	311 Outsource Coating-Solid Film Lubricant	320 Final & Recv Inspect	350 Overinspect	360 Pack and Ship	OUTBOUND TOTALS (FEET)
10	270																															270
15		216																														216
20			0																													0
30				0																												0
40					334																											334
45						258																										258
50							368																									368
80								96																								96
90									310																							310
100										47																						47
110											0																					0
113												174																				174
130													186																			186
135														0																		0
140															64																	64
150																133																133
160																	98															98
170																		209														209
210																			209													209
220																				225												225
240																					222											222
270																						285										285
290																							122									122
300																								186								186
301																									158							158
303																										280						280
304																											111					111
305																												237				237
311																													208			208
320																														0		0
350																															257	257
INBOUND TOTALS (FEET)	270	216	0	0	334	258	368	96	310	47	0	174	186	0	64	133	98	209	209	225	222	285	122	186	158	280	111	237	208	0	257	

5,263 FT

TOTAL TRAVEL DISTANCE FOR 2015 VOLUMES = 236,835 FT

F110, 1559M93P04

F110, 1559M93P04
Annual Volumes

Forcast Year	Forecasted Volumes	Total Distance (FT)	Travel Speed (Ft/Min)	Hours
2015	45	236,835	80	49
2016	97	510,511	80	106
2017	136	715,768	80	149
2018	88	463,144	80	96
2019	66	347,358	80	72
2020	66	347,358	80	72
2021		-	80	0
2022		-	80	0

NORTH

REV.	DESCRIPTION	DATE
–	ORIGINAL DRAWING CREATED/CONVERTED	02/06/15

REV.	DESCRIPTION	DATE

NOTES:

PRELIMINARY
NOT FOR CONSTRUCTION

AVAKIAN & ASSOC., LLC
1622 Field Street
Fernandino Beach, FL
Harvey Cedars, NJ : York, PA

CLIENT: EDAC Technologies
Newington, CT Plant @ Richards St.

TITLE: PROCESS FLOW
F110 Stage-3 Disc (PN:1559M93P04)

PROJ. MGR.: A. MARK AVAKIAN
PROJ. CODE: –
PROJ. ENG.: KLAVETAN
SCALE: 3/32"=1'-0"
DATE: 08/23/2015

FILE NAME: EDAC030P.DWG
TYPE: P
REV.: –
DWG. NO.: EDAC030P