



# PERFORMANCE ASSEMBLY SOLUTIONS

OBSOLETE

Work Instruction

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| <b>Operation:</b> 85<br><b>Description:</b> Packaging       | <b>Prepared By:</b> Quality<br><b>Approved by:</b> Manufacturing |
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| <b>Title: Final Audit &amp; Packaging</b>                   |  |

## FINAL AUDIT & PACKAGING



1. Ensure that all paperwork has been completed and that all operations are complete and have evidence of approval on the Assembly Router.
2. Remove Engine from Cold Test Unit, using the appropriate hook configuration and remove any excess oil with a clean, soft cloth.
3. Ensure all caps and plugs, have been applied.



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4. Start on the side furthest from the cold test and place engines in the dunnage, three on the left and three on the right as they come off cold test. This will allow access to the engines to be bolted to the pallet.
5. Bolt the engines to the pallet using three (3) 5/16 inch washers and three locking nuts. Tighten fasteners.



6. After the engine is secured to the pallet, clean the engine using a clean, soft cloth. Zep cleaner is optional.
7. Place two strips of Mylar Plastic Protective Film over the tops of each of the two Rocker Covers.
8. Place a strip of Mylar over the cam cover.
9. Place a red plastic plug-cap over the threaded end of the sprocket shaft.
10. Check to ensure that all of the external components are present.
11. Perform any and all required audits.
12. Once there are two engines secured to the pallet, place one (1) Plastic Engine Cover Bag over the two engine assemblies.
13. Once the pallet is full, (6 engines) place one 3/8-16 x 3/4 bolt and one (1) 3/4 washer, in each of the assembly's mounting boss', and apply with minimal engagement.



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14. Contact Floor Auditor for Final Audit.
15. Place one (1) steel cross member across the tops of three engines. Line up the bolt holes accordingly and tighten. Repeat step 11 for the second row of engines.
16. Boxes consist of four (4) sides, front, back, left and right.
17. Secure the sides, front and back using two drywall screws in each of the bottoms of the walls.
18. Secure the walls to each other with six (6) drywall screws down the left and right sides.
19. Apply two (2) support bars across the top running parallel to the two rows (between the cylinder heads) of engines and secure with one (1) drywall screw in each end.
20. Fill out the Dunnage Check Sheet and any Certifications and secure to one of the engine bags with adhesive film (Tape).
21. Complete the "OKAY TO SHIP" tag and forward to the Shipping and Receiving Authority. All other acceptance documentation is then forwarded to the line auditor.  
**NOTE: the 2004 Model Year part number for the PP100 engine is 01-333.**
22. Move Pallet to Finished Goods.