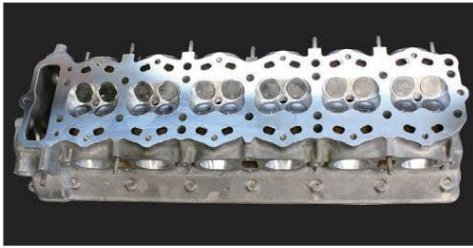


S20 Head full processing process

- 1 Valve guide replacement
- 2 Seat ring replacement
- 3 Head water pressure inspection
- 4 Valve guide inner diameter reamer
- 5 Cam center seat cut
- 6 Head correction surface grinding
- 7 Final inspection
- 8 delivery of materials



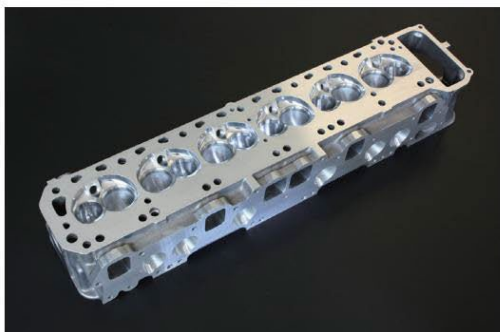
S20 Block processing process

- 1 Liner removal
- 2 Internal inspection (corrosion, cracks, etc.)
- 3 O-ring replacement
- 4 Block top surface correction grinding
- 5 Liner press fit
- 6 Cylinder water pressure inspection
- 7 Liner height adjustment
- 8 Cylinder boring
- 9 Final inspection
- 10 delivery of materials



L-type SPL head machining process

- 1 Valve guide and seat ring removal
- 2 Enlarged intake port machining
- 3 Combustion chamber argon welding
- 4 Head roughening (underside)
- 5 Seat ring insert
- 6 Ports hand polished
- 7 Hydraulic testing (if necessary)
- 8 Valve guide insert
- 9 Valve guide inner diameter reamer
- 10 Minimum surface grinding
- 11 Cam center seat cut
- 12 Bottom surface grinding amount specified
- 13 Combustion chamber shape marking
- 14 Combustion chamber processing (hand-finished)
- 15 Combustion chamber volume measurement
- 16 Bottom volume adjustment surface grinding (fine adjustment)
- 17 Final inspection of each dimension
- 18 delivery of materials



U20 Lower body full processing work process

Cylinder block

- 1 Crank housing measurement
- 2 Calculating corrected dimensions
- 3 Line Boring
- 4 Minimum grinding of block bottom surface
- 5 Cylinder OS Boring
- 6 Block top surface engraving relief minimum amount of surface grinding
- 7 Removing the oil line plug
- 8 Final inspection of each dimension
- 9 delivery of materials

Crankshaft

- 1 Journal and pin wear measurement
- 2 Undersize polishing amount calculation
- 3 Bending correction before polishing
- 4 Undersize Polishing
- 5 Crank balancing
- 6 Journal & Pin Wrapping
- 7 Final inspection of each dimension
- 8 Washing
- 9 delivery of materials

