

SUB-DETAIL :XX SCALE :X:X

STRESS RELIEVE

000.00 000.00 000.00

WELDING REQUIREMENTS WELDS SHALL NOT BE MACHINED OR DRILLED THRU WELDS SHALL BE COMPLETED TO: CSA W59 OR AWS D1.1 FOR STEEL CSA W59.2 OR AWS D1.2 FOR ALUMINUM DYNAMIC WELDMENTS ALL WELD SIZES TO BE EQUAL TO THE THINNEST CONNECTING MEMBER. STATIC WELDMENT: CONTINUOUS WELDS FOR ANY CONNECTING MEMBER EDGES LESS THAN OR EQUAL TO 4 TIMES THE NOMINAL WELD SIZE.

STITCH WELDS TO BE COMPLETED PER APPLICABLE CODE.

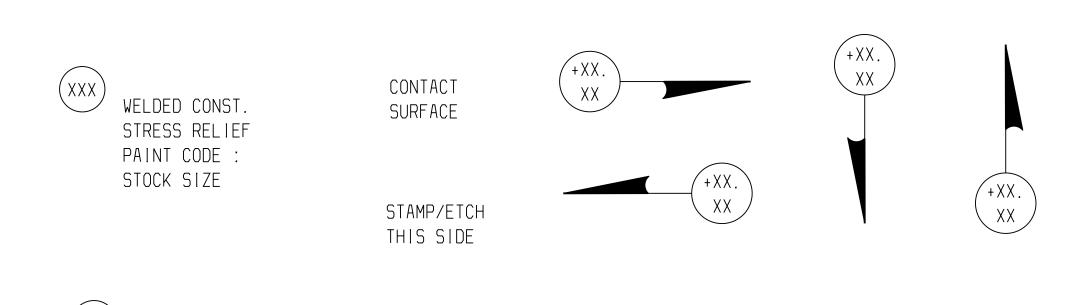
MINIMUM 50% WELD COVERAGE PER CONNECTING MEMBER EDGE.

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CONTINUOUS WELDS ON ALL CONNECTING MEMBER EDGES ONLY (NO STITCH WELDS UNLESS OTHERWISE NOTED). FOR ALUMINUM WELDMENTS ENSURE PARTS ARE PROPERLY CLEANED AND CORRECT PREHEAT IS USED.

> SHOP CHANGE DATE CHANGED BY
> 07/08/22 Actalent
> 09/27/22 ACTALENT A UNIT # 15 AND UNIT # 21 MODIFIED B UNIT #01 AND UNIT #21 MODIFIED

STRESS RELIEF PAINT CODE : STOCK SIZE



(XXX)STOCK SIZE MATERIAL : PAINT CODE APPROX WT =

TO BOL "Z" TO FOL "X" TO **Ç** BODY "Y"

STA XXX

UNIT XXX

FINISH TO LPP Data: CLEAN-UP Weight in KG. = Volume in Cc = Steel or Aluminium = # of Plate components = # of Tubular Components = # Tapped Holes = # Drilled Holes = # Dowel =

Panel name left / Panel name right Panel number left / Panel number right Thickness : 0.00 Direction :

STOCK SIZE MATERIAL

| XXXXX-XXXX-XXX-X-XXX|

ZONE A GRAVER XXXX

THIS DRAWING MAY USE BOTH INCH AND METRIC UNITS OF MEASUREMENT (* INDICATES INCH DIMENSIONS) MAXIMUM ALLOWANCE ROUGHNESS OF ALL 1 PLACE mm FINISH DIMENSIONS TO BE 3.2 MICRONS 2 PLACE mm FINISH DIMENSIONS TO BE 1.6 MICRONS 3 PLACE mm FINISH DIMENSIONS TO BE 0.5 MICRONS ALL GROUND SURFACES TO BE 0.4 MICRONS. METRIC - EXCEPT AS NOTED TOLERANCES SHALL BE: 1 PLACE MACHINING +/-0.3 1 PLACE FABRICATION +/-1.5 2 PLACE +/-0.08 BETWEEN MACHINED SURFACES +/-0.03 BETWEEN SINGLE DOWEL AND A HEEL SURFACE +/-0.03 BETWEEN DOWELS IN THE SAME PLANE +/-0.10 BETWEEN DOWELS IN DIFFERENT PLANES +/-0.13 TO SCREW HOLES, NON ACCUMULATIVE ALL <%TRI_OLIN> SURFACES MUST BE FINISHED EXCEPT FOR COLD DRAWN SUFACES. WELDMENTS. ALL WELD FILLETS TO BE 1/4 INCH.

ALL "V" GROOVES TO BE 90 EXCEPT AS SHOWN. ADD VENT HOLES IN ALL WELDMENTS WHERE TRAPPED AIR IS A POSSIBILITY, I.E. TUBING CAPPED AT BOTH ENDS, BOXED FORMS ETC. SPOTFACE SCREW AND / OR BOLT HEAD AND / OR WASHERS IS INFRINGED UPON BY WELD BEADS.

ALL EDGES OF PART CONTACT SURFACES ON LOCATING BLOCKS AND FINGERS TO HAVE .12 INCH / 3.00 mm AFTER SPOTTING.

BUILD VENDOR TO BE RESPONSIBLE FOR ACCURACY OF STANDARD PRODUCTS AFTER ALTERATION.

DOWEL HOLE TOLERANCES DOWEL TOLERANCE FOR PRESS FIT USE H6 FOR SLIP FIT USE F7

MARK IDENTIFICATION AND MATERIAL NUMBERS ON DETAILS. PAINT IDENTIFICATION NUMBERS ON STRUCTURAL WORK.