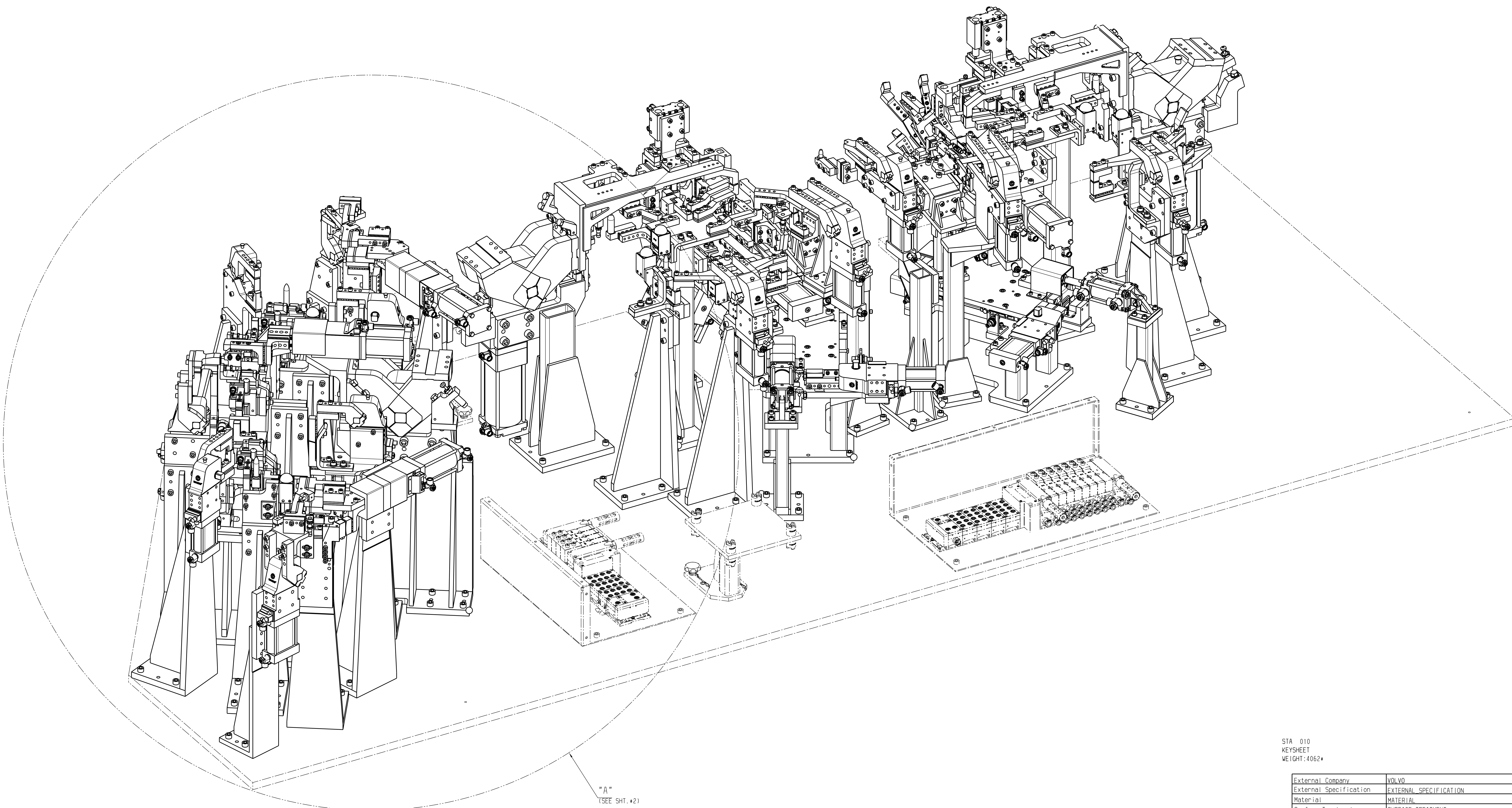


NOTE:

	X	Y	Z	Rx	Ry	Rz
FIREWALL OUTER ASSEMBLY LHD/RHD	0mm	0mm	0mm	0°	0°	0°
WINDSHIELD LOWER ASSEMBLY	360mm	-3682mm	2177mm	90°	35°	90°

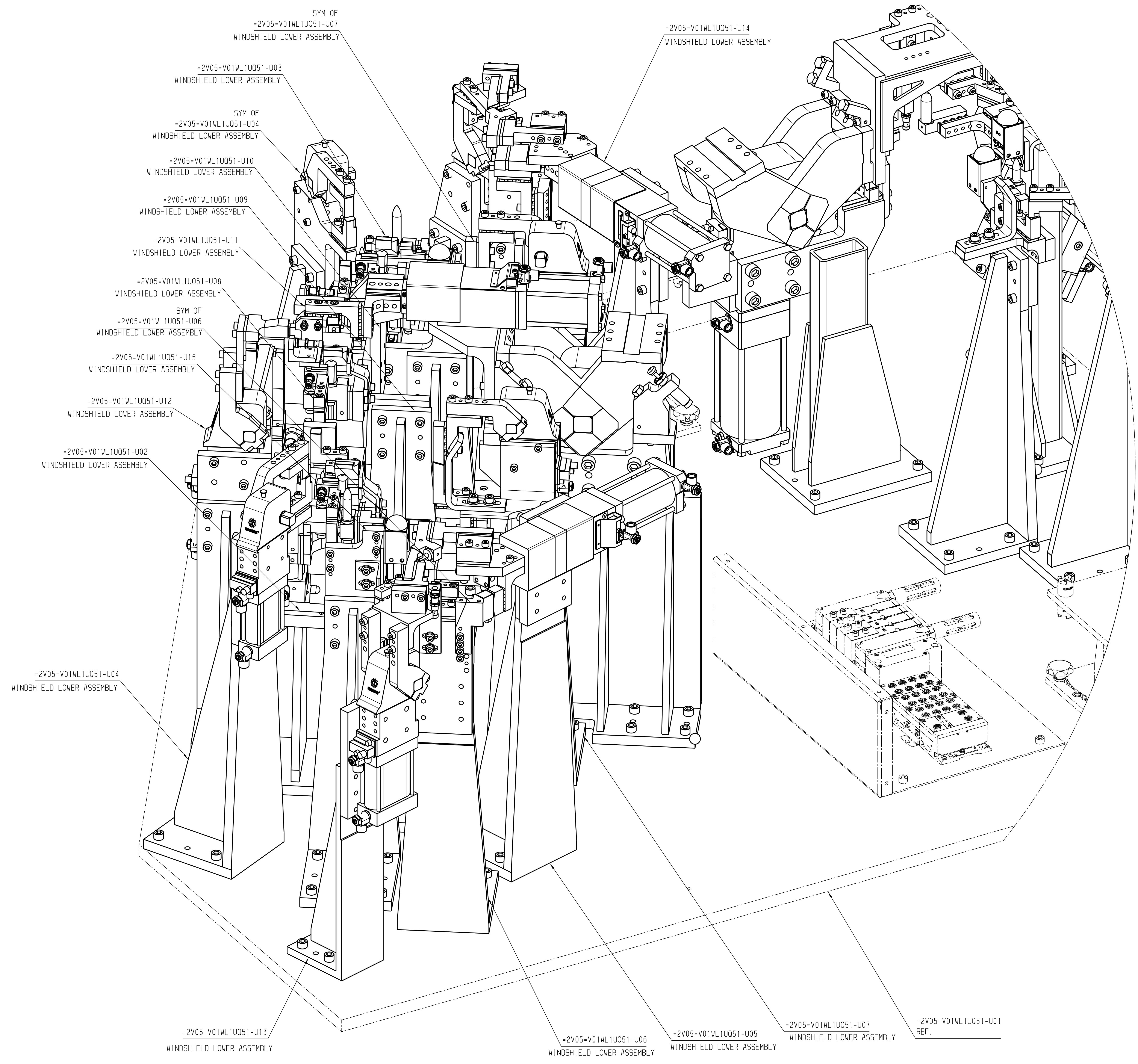


"A"
(SEE SHT. #2)

ISO VIEW-1

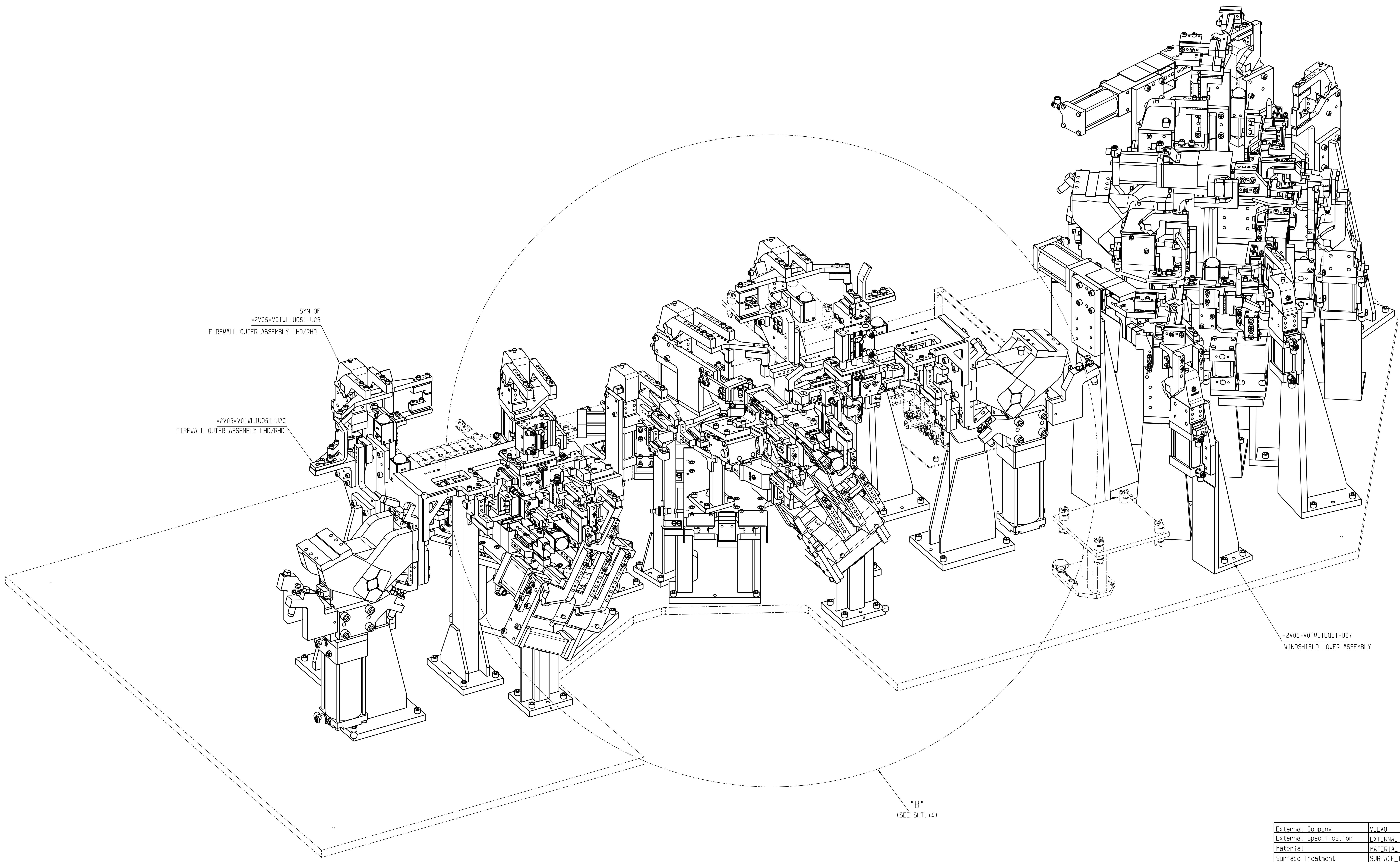
STA 010
KEYSHEET
WEIGHT: 4062*

External Company	VOLVO		
External Specification	EXTERNAL SPECIFICATION		
Material	MATERIAL		
Surface Treatment	SURFACE TREATMENT		
DSM Number	DSM_NUMBER		
Symbols, designations and general drawing method STD 101-0005			
Tolerance unless otherwise stated ISO 2768-m Sharp edges broken when function allows			
Drawn by	Date	Proj	Rev
ACTALENT	5/29/2022	-	A0
Approved	Date	Projection	Request reference
XX	XX	1st	REQ_REF
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		Document type	Sheet No
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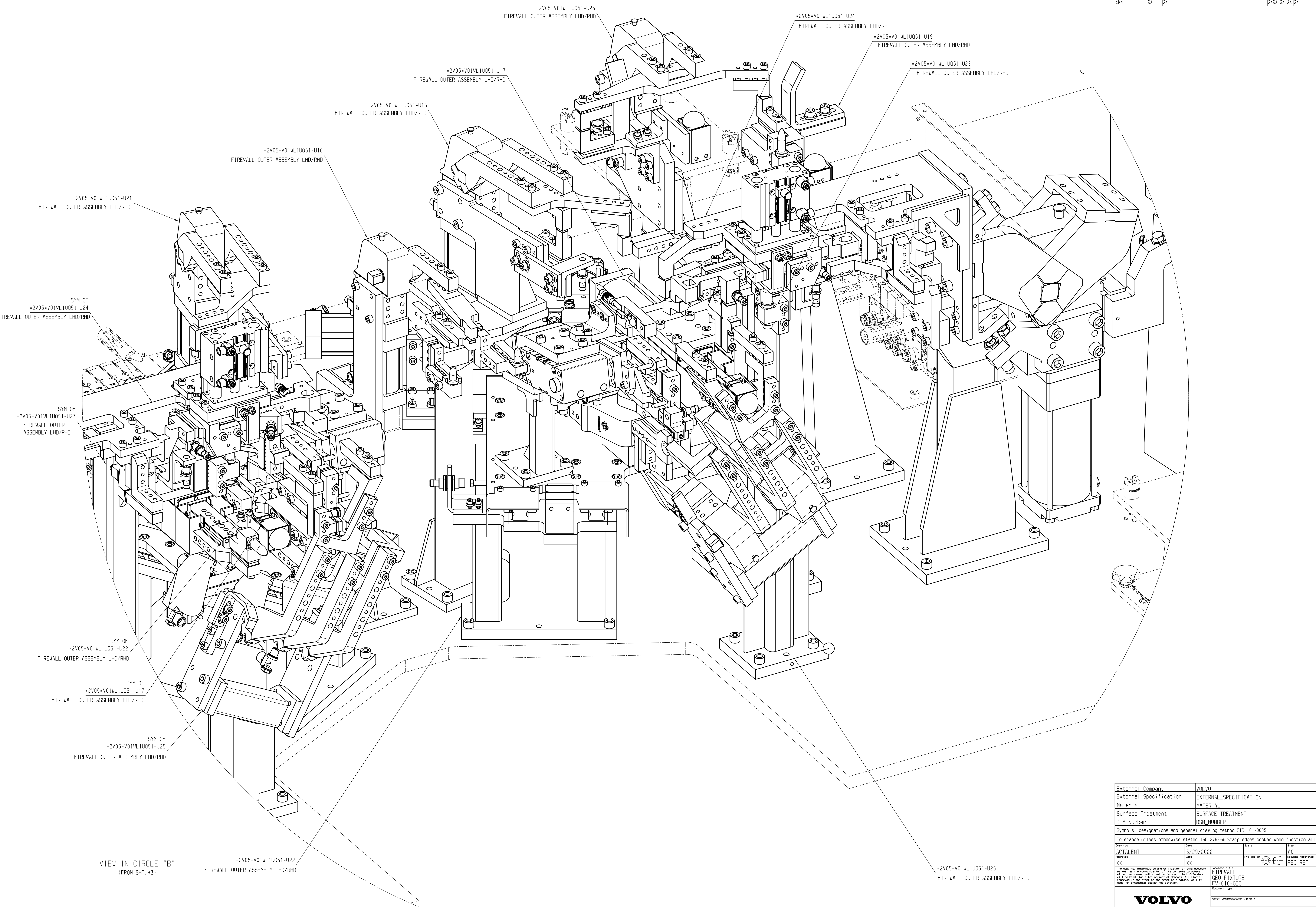
VIEW IN CIRCLE "A"
(FROM SHT. #1)

External Company	VOLVO		
External Specification	EXTERNAL SPECIFICATION		
Material	MATERIAL		
Surface Treatment	SURFACE TREATMENT		
DSM Number	DSM_NUMBER		
Symbols, designations and general drawing method STD 101-0005			
Tolerance unless otherwise stated ISO 2768-m Sharp edges broken when function allows			
Drawn by	Date	Proj	Rev
ACTALENT	5/29/2022	-	A0
Approved	Date	Projection	Request reference
XX	XX	1	REQ_REF
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VOLVO Volvo Truck Corporation		Doc. name/Document prefix	Doc. No.
		=2V05-V01WL1U051	01
		Version	Sheet No.
			2/4



ISO VIEW-2

External Company	VOLVO		
External Specification	EXTERNAL SPECIFICATION		
Material	MATERIAL		
Surface Treatment	SURFACE TREATMENT		
DSM Number	DSM_NUMBER		
Symbols, designations and general drawing method STD 101-0005			
Tolerance unless otherwise stated ISO 2768-m Sharp edges broken when function allows			
Drawn by	Date	Scale	Proj
ACTALENT	5/29/2022	-	A0
Approved	Date	Projection	Request reference
XX	XX	1st	REQ_REF
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		Document title FIREWALL GEO FIXTURE FW-010-GEO Document type	
Document No =2V05=V01WL1U051		Version 01	Sheet No 3/4



VIEW IN CIRCLE "B"
(FROM SHT. #3)

External Company	VOLVO
External Specification	EXTERNAL SPECIFICATION
Material	MATERIAL
Surface Treatment	SURFACE TREATMENT
DSM Number	DSM_NUMBER
Symbolic designations and general drawing method STD 101-0005	
Tolerance unless otherwise stated ISO 2768-m Sharp edges broken when function allows	
Drawn by	ACTALENT
Date	5/29/2022
Checked by	XX
Date	XX
Projection	1st
Request reference	REQ_REF
Document title	FIREWALL GEO FIXTURE FW-010-GEO
Document type	

SUB-DETAIL :XX
SCALE :X:X

STRESS RELIEVE

X	000.00
Y	000.00
Z	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.

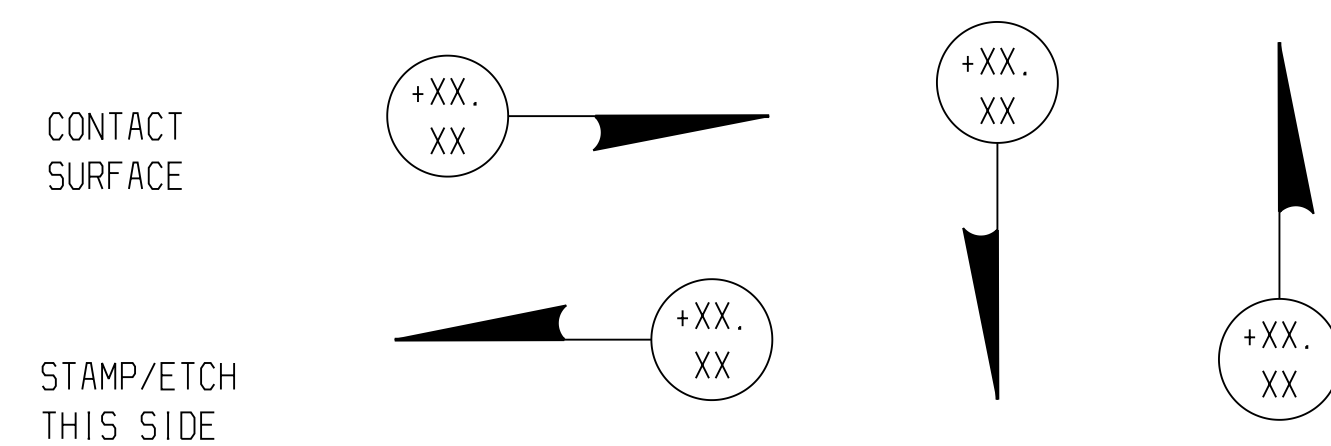
STATIC WELDMENT:
CONTINUOUS WELDS FOR ANY CONNECTING MEMBER EDGES LESS THAN OR EQUAL TO 4 TIMES THE NOMINAL WELD SIZE.
STITCH WELDS TO BE COMPLETED PER APPLICABLE CODE.
MINIMUM 50% WELD COVERAGE PER CONNECTING MEMBER EDGE.

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.

DYNAMIC WELDMENT:
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.

XXX WELDED CONST.
STRESS RELIEF
PAINT CODE :
STOCK SIZE

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



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

LPP Data:

- Weight in KG. =
- Volume in Cc =
- Steel or Aluminium =
- * of Plate components =
- * of Tubular Components =
- * Tapped Holes =
- * Drilled Holes =
- * Dowel =

FINISH TO
CLEAN-UP

STA XXX
KEYSHOXX
WEIGHT:

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

POS	QTY	MATERIAL	STOCK SIZE

XXXX-XXXX-XXX-X-XXX-XXX

ZONE A GRAVER

XXXX

THIS DRAWING MAY USE BOTH INCH AND METRIC
UNITS OF MEASUREMENT
(* INDICATES INCH DIMENSIONS)

MAXIMUM ALLOWANCE ROUGHNESS OF ALL METRIC

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_OL IN> SURFACES MUST BE FINISHED EXCEPT FOR COLD DRAWN SURFACES.

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	h6
FOR SLIP FIT USE F7	

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