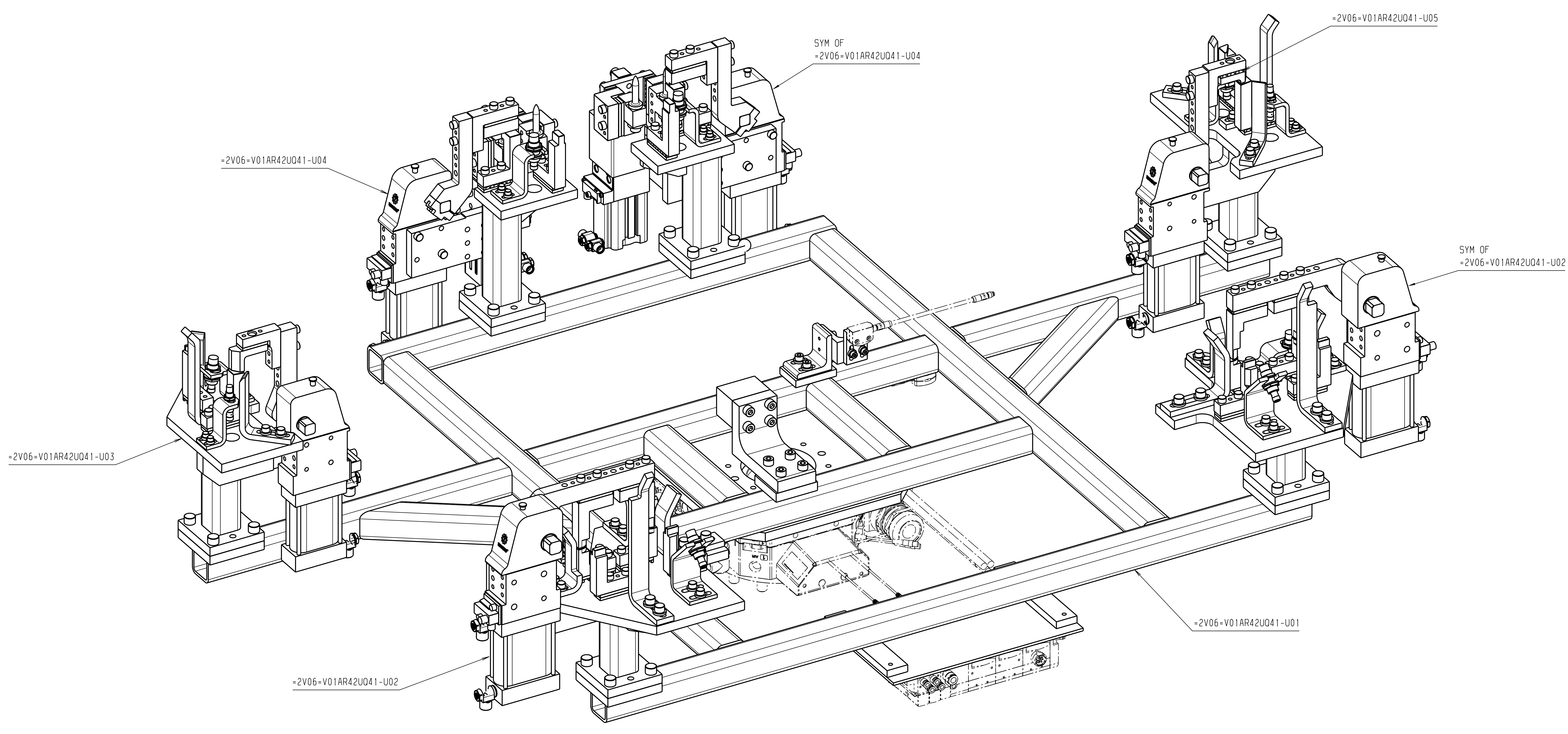


Engineering Release	Location	Change description	Subject	Drawings	Doc. Rel. Status
XX	XX				DOC_REL_STATUS
ERN	XX	XX			Date: XXXX-XX-XX Revision: XX



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
 2 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 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 m6
 FOR SLIP FIT USE F7

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

STA 020
 KEYSHEET
 WEIGHT: 500.71#

External Company	EXTERNAL COMPANY		
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	Drawn by	Date
ACTALENT	5/9/2022	AO	AO
Approved	Date	Projection	Request reference
XX	XX	1st	REQ_REF
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		REAR WALL END EFFECTOR RW-020-MH3	

VOLVO	
Volvo Truck Corporation	
Document No	Version
XX	01
Document No	Version
=2V06-V01AR42U04	1/1

16148-1020-420-3

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.

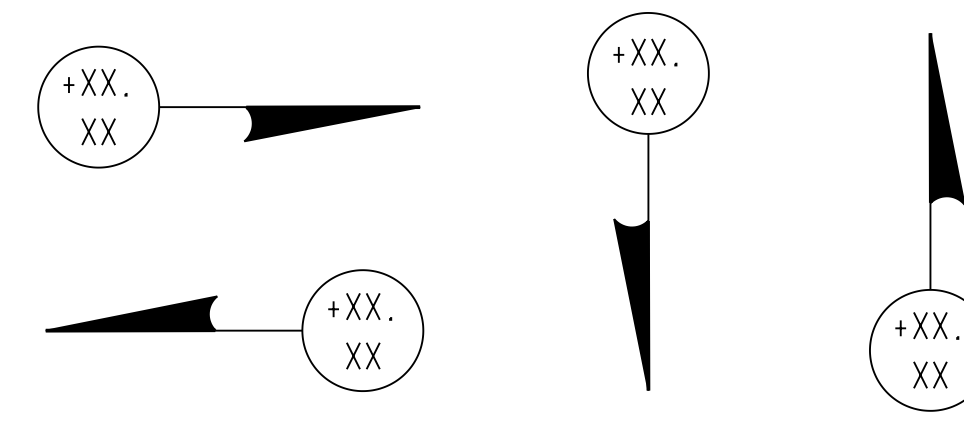
DYNAMIC WELDMENT:
CONTINUOUS WELDS ON ALL CONNECTING MEMBER EDGES ONLY (NO STITCH WELDS UNLESS OTHERWISE NOTED).
FOR ALUMINUM WELDMENTS ENSURE PARTS ARE PROPERLY CLEANED AND CORRECT PREHEAT IS USED.

(XXX) WELDED CONST.
STRESS RELIEF
PAINT CODE :
STOCK SIZE

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

CONTACT SURFACE

STAMP/ETCH THIS SIDE



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

LPP Data:

FINISH TO CLEAN-UP STA XXX UNIT XXX

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 :

POS	QTY	MATERIAL	STOCK SIZE

XXXX-XXXX-XXX-X-XXX-XXX

ZONE A GRAVER

XXXX

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