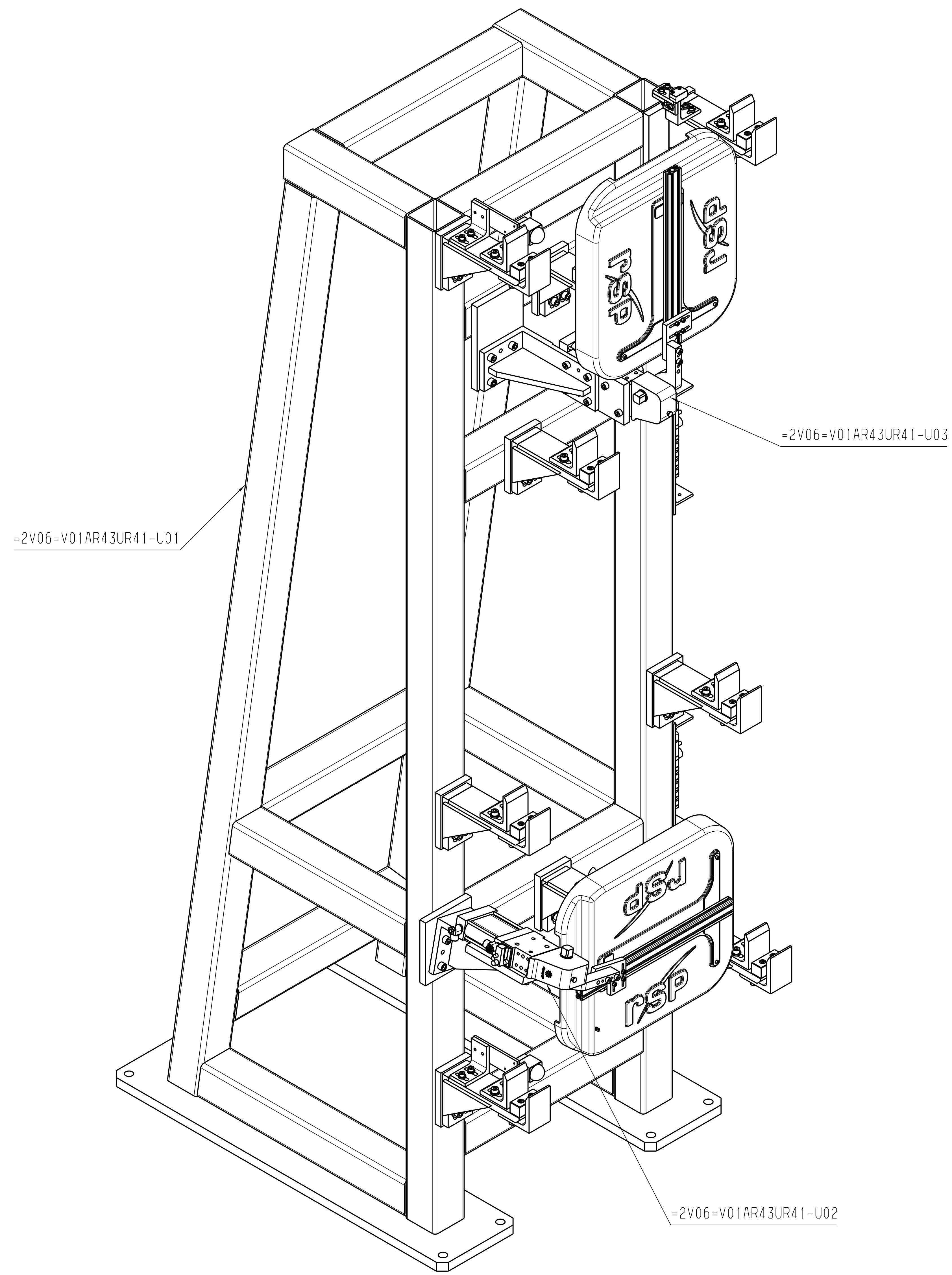


Engineering Release Notice	Release Location	Change description	Subject Drawing	Version	Document release status
ERN	XX	XX			DOC_REL_STATUS Date: XXXX-XX-XX Specification count: XX



ISO VIEW

STA 020
KEY SHEET
WEIGHT : 1171.54*

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	ACTALENT	Date	06/07/2022	Scale	-	File	A0
Approved	XX	Date		Projection	1st	Request reference	REQ_REF

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Document title	REAR WALL GRIPPER STAND
Document No	RW-020-SR3
Document type	
Supplier name/Document prefix	
Document No	XX
Version	01
Sheet No	1/1

16148-1020-430-3

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.

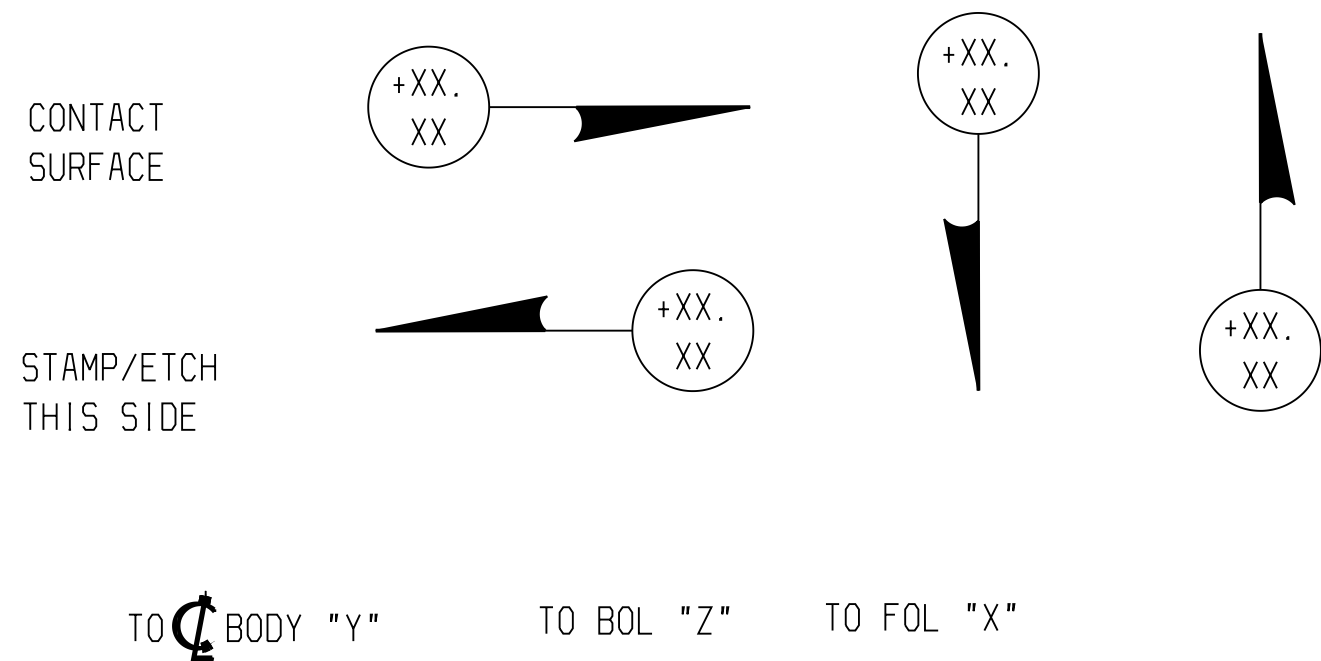
STATIC WELDMENT:
 CONTINUOUS WELDS FOR ANY CONNECTING MEMBER EDGES LESS THAN OR EQUAL TO 4 TIMES THE NOMINAL WELD SIZE.
 STITCH WELDS TO BE COMPLETED PER APPLICABLE CODE.
 MINIMUM 50% WELD COVERAGE PER CONNECTING MEMBER EDGE.

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 =



LPP Data:

FINISH TO CLEAN-UP STA 020
KEY SHEET

- 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

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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	m6
FOR SLIP FIT USE F7	

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