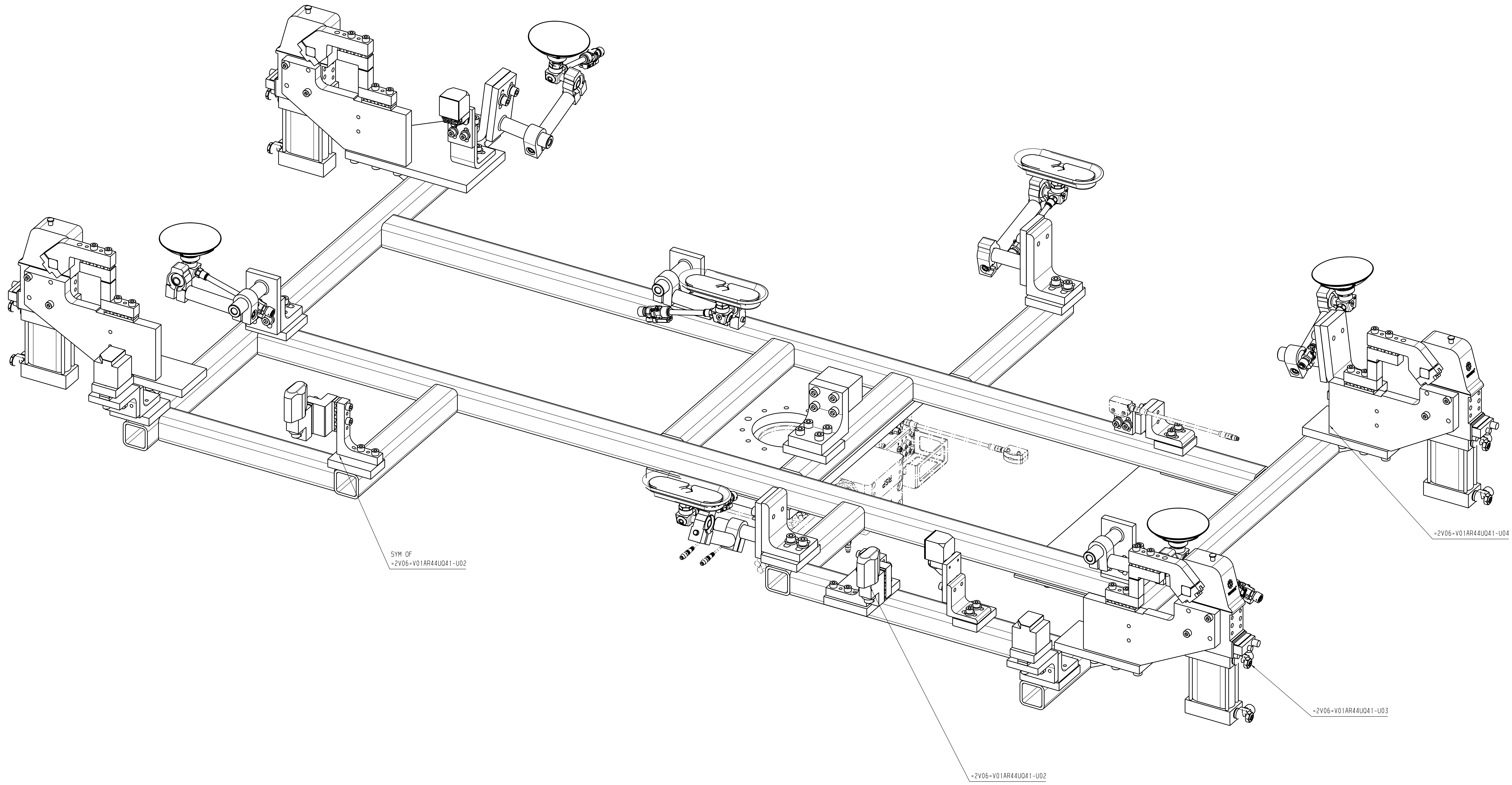


ISO VIEW-1

STA 040
UNIT KEYSHEET
WEIGHT: 499.63 #

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	05/20/2022	-	A0
Approved	Date	Projection	Request reference
XX	XX	1st	REQ_REF
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Document title	REAR WALL END EFFECTOR		
Document No.	RW-040-MH1		
Document type	KEYSHEET		



ISO VIEW-2

16148-1040-420-1

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	Date	Scale	First
ACTALENT	05/20/2022	-	A0
Approved	Date	Projection	Request reference
XX	XX	1st Angle	REQ_REF
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VOLVO Volvo Truck Corporation		Document title	Document type
		REAR WALL END EFFECTOR RW-040-MH1	
Document No	Version	Sheet No	
=2V06-V01AR44U041	01	2/2	

SUB-DETAIL :XX
SCALE :X:X

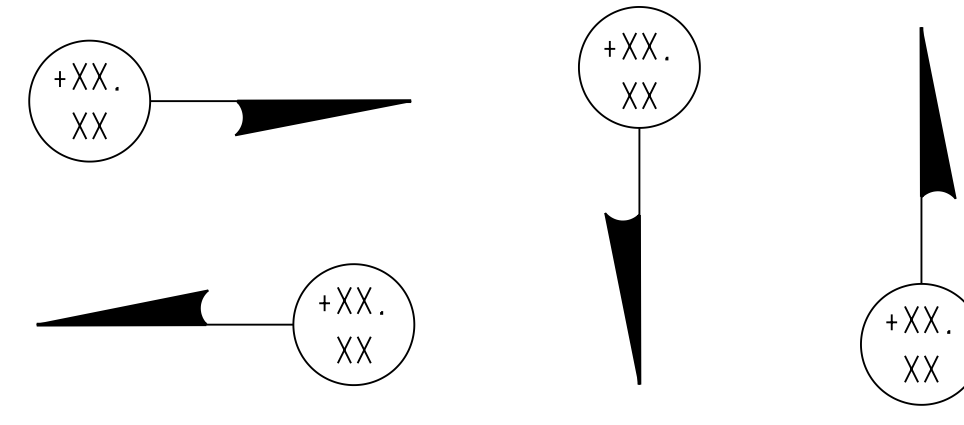
STRESS RELIEVE

X	000.00
Y	000.00
Z	000.00

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:

- 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
UNIT XXX

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

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.

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_0L IN> 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 m6
FOR SLIP FIT USE F7

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