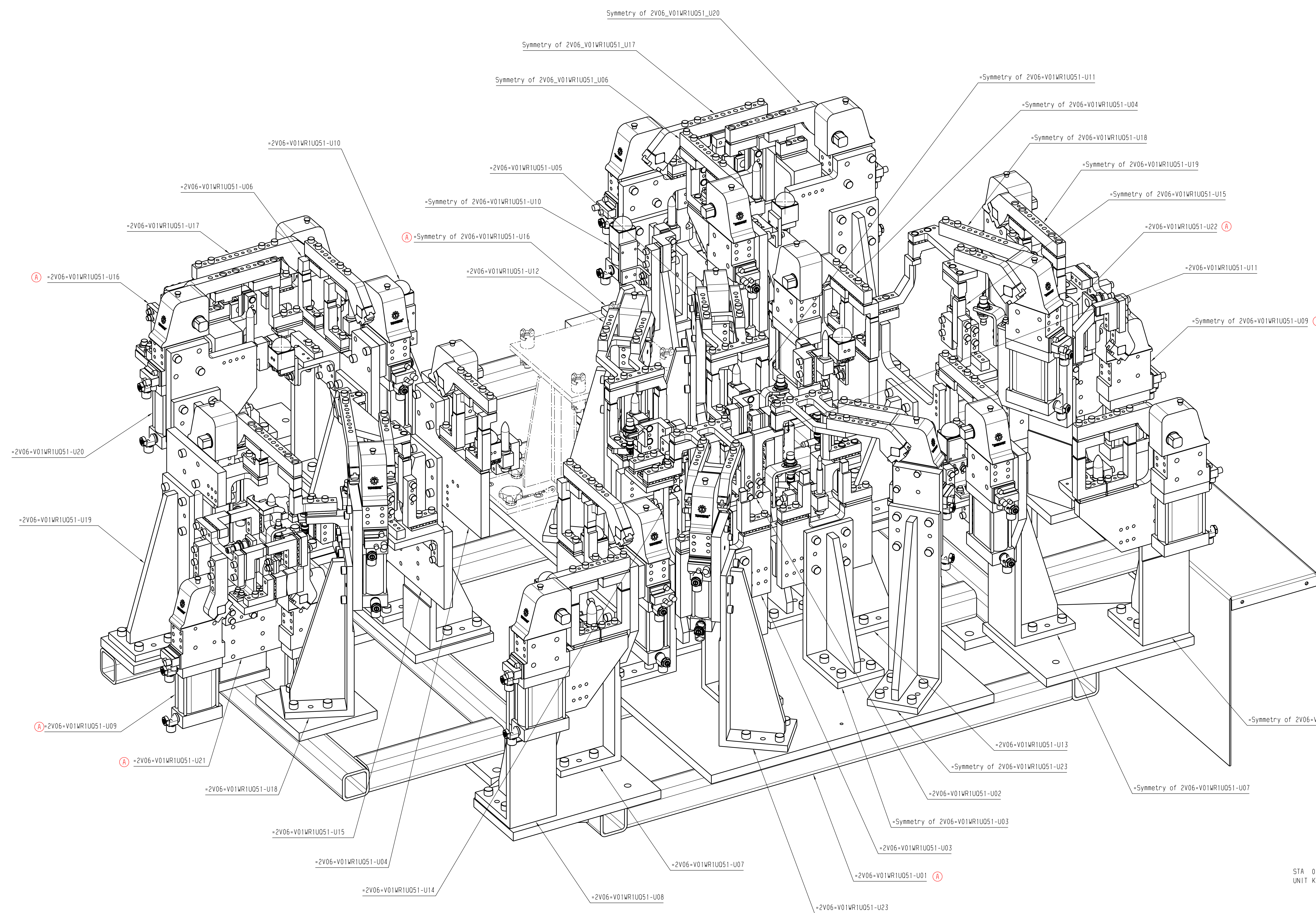


SHOP CHANGE		
CHANGES	DATE	CHANGED BY
A UNIT#01, 09 (LH/RH), 16 (LH/RH), 21, 22 MODIFIED	09/29/22	ACTALENT



ISO VIEW

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 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 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
UNIT KEYSHEET

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	04/14/2022	-	A0
Approved	Date	Projection	Request reference
XX	XX	1st	REQ_REF

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