

=2V06=V03AR13T1-U01

ISO VIEW

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

STA 080
UNIT KEY SHEET
WEIGHT: 447.6*

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	Scale	First
ACTALENT	06/08/2022	1:2	A0
Approved	Date	Projection	Request reference
XX	06/08/2022	1st	REQ_REF
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		DATE SCRIBE	RX-080-DS
		TOOLING NUMBER	
		Document No	XX
		Document No	=2V06=V03AR13T1
		Version	01
		Sheet No	1/1

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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.

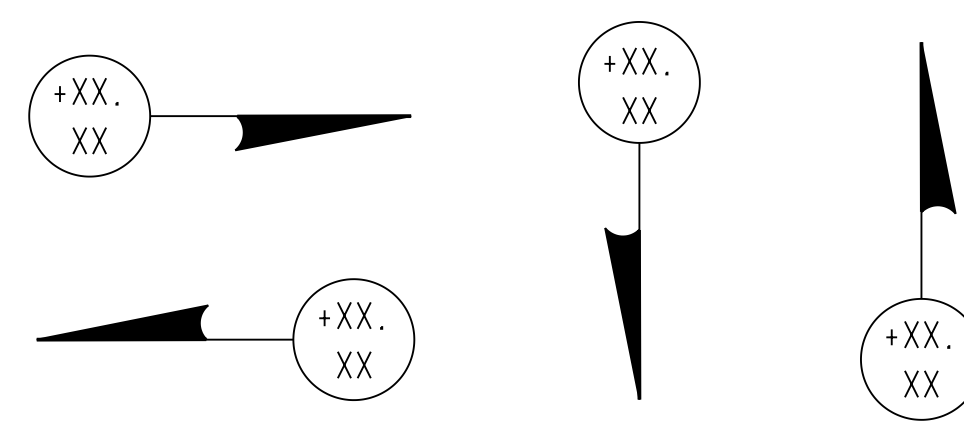
WELDING REQUIREMENTS
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 CSA W59 OR AWS D1.1 FOR STEEL
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 DYNAMIC WELDMENTS
 ALL WELD SIZES TO BE EQUAL TO THE THINNEST CONNECTING MEMBER.

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:

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 080 UNIT KEY SHEET

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_0L 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.