

STA 060  
KEYSHEET  
WEIGHT: 377.36\*

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
Actalent	06/08/2022
Approved	Date
XX	XX
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Document Title	REAR WALL
Document No.	END EFFECTOR
Version	RW-060-WH2
Sheet No.	01
Document Type	REQ_REF

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.

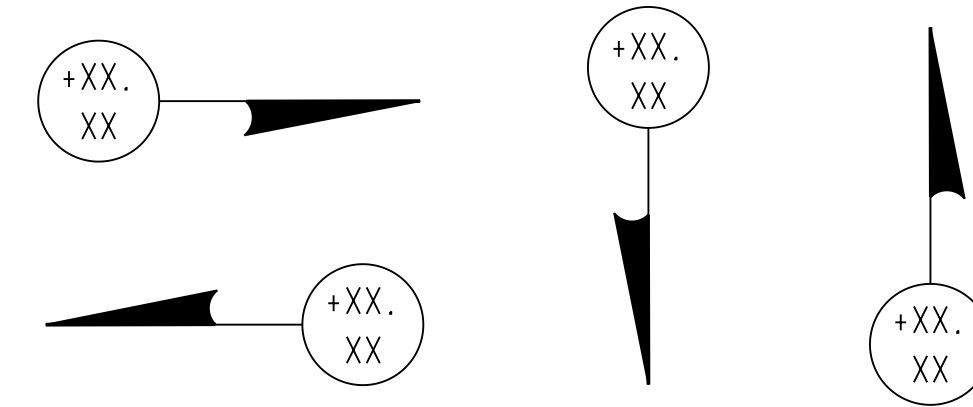
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 DYNAMIC WELDMENTS  
 ALL WELD SIZES TO BE EQUAL TO THE THINNEST CONNECTING MEMBER.

**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 040  
UNIT  
WEIGHT:

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

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.