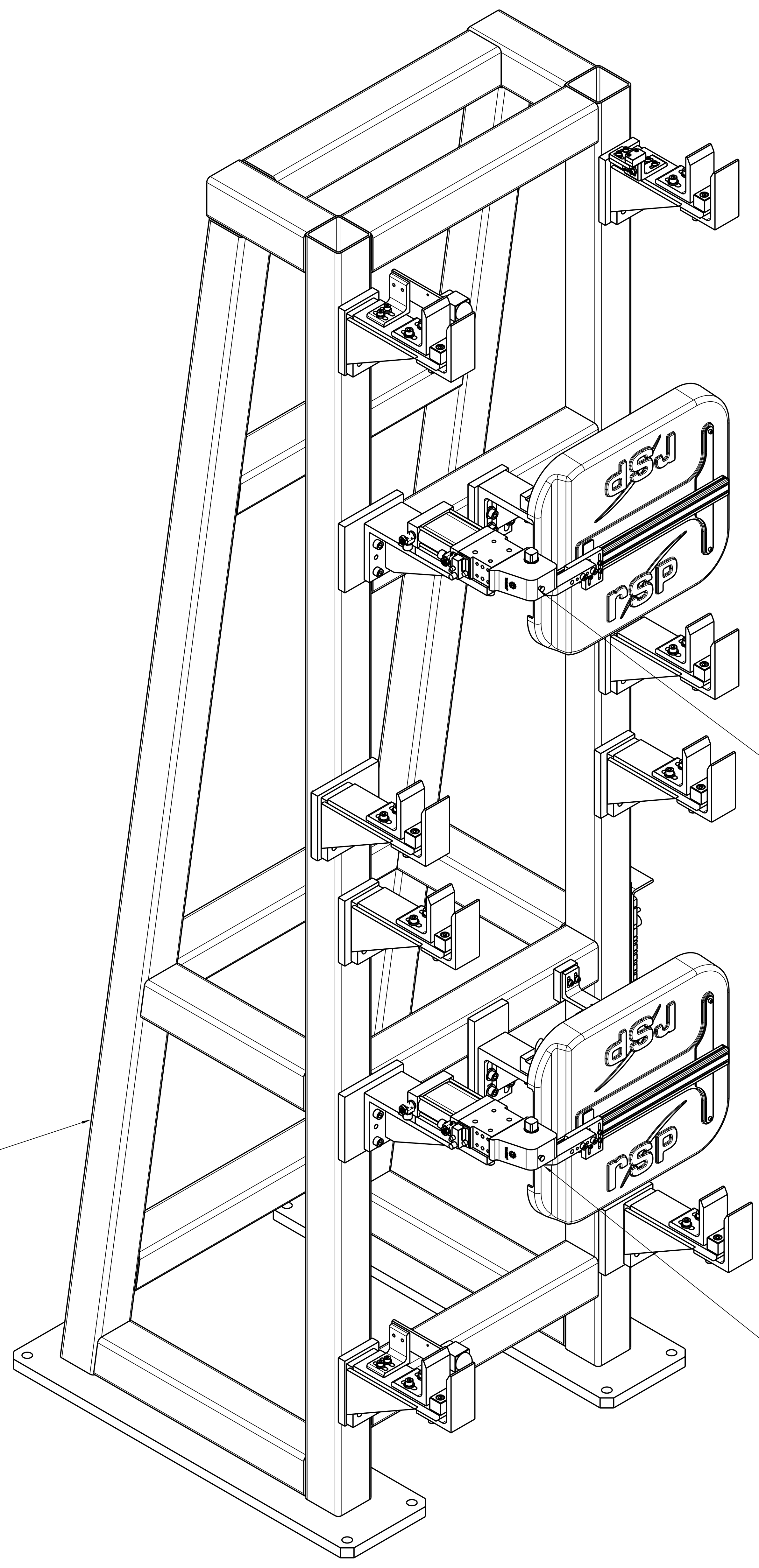


Engineering Release Notice	Location	Change description	Author	Checked	Drawn	Checked	Doc. release status
ERN	XX	XX					DOC_REL_STATUS Date: XXXX-XX-XX Specification count: XX

SHOP CHANGE			
CHANGES	DATE	CHANGED BY	
B Unit #001 revised	07/21/22	Actalent	



=2V06=V03AR42UR41-U01
ⓑ

=2V06=V03AR42UR41-U03

=2V06=V03AR42UR41-U02

ISO VIEW

16148-1060-430-1

STA 060
KEY SHEET
WEIGHT : 1243.4#

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	-	A0
Approved	Date	Projection	Request reference
XX	XX	1st angle	REQ_REF
The copying, distribution and utilization of this document as well as the compilation of its contents to generate a third document without the express authorization of the author is prohibited. All rights reserved in the event of a dispute, all titles shall be considered design registrations.		Document title	Sheet No.
		REAR WALL GRIPPER STAND RW-060-SR1	11/1
		Document type	Version
			01
		Supplier name/Document prefix	Sheet No.
		XX	11/1
		Document No.	Version
		2V06=V03AR42UR41	01



Volvo Truck Corporation

SUB-DETAIL :XX
SCALE :X:X

STRESS RELIEVE

X	000.00
Y	000.00
Z	000.00

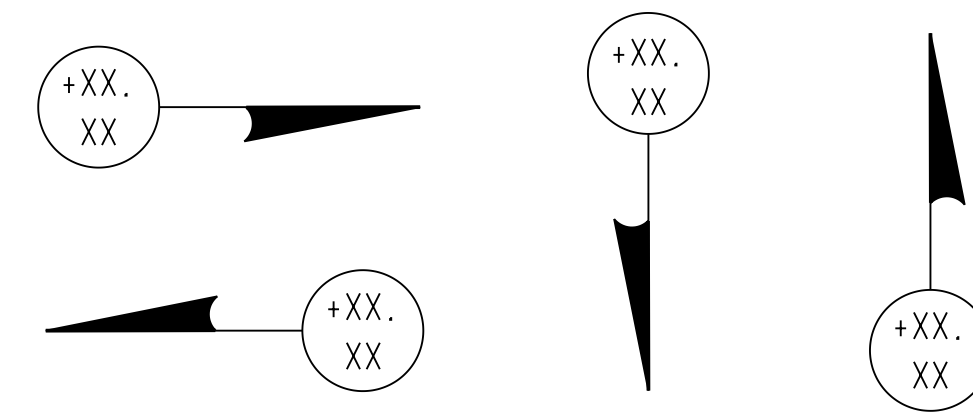
WELDING REQUIREMENTS
 WELDS SHALL NOT BE MACHINED OR DRILLED THRU
 WELDS SHALL BE COMPLETED TO:
 CSA W59 OR AWS D1.1 FOR STEEL
 CSA W59.2 OR AWS D1.2 FOR ALUMINUM
 DYNAMIC WELDMENTS
 ALL WELD SIZES TO BE EQUAL TO THE THINNEST CONNECTING MEMBER.

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.

(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 060
 KEY SHEET

Panel name left / Panel name right
 Panel number left / Panel number right
 Thickness : 0.00 Direction :

POS	QTY	MATERIAL	STOCK SIZE

16148-1060-430-1

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.

ⓑ

SHOP CHANGE			
CHANGES	DATE	CHANGED BY	
B UNIT #001 REVISION	07/21/22	Actalint	