

SUB-DETAIL :XX SCALE :X:X

STRESS RELIEVE

000.00 000.00 000.00

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.

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.

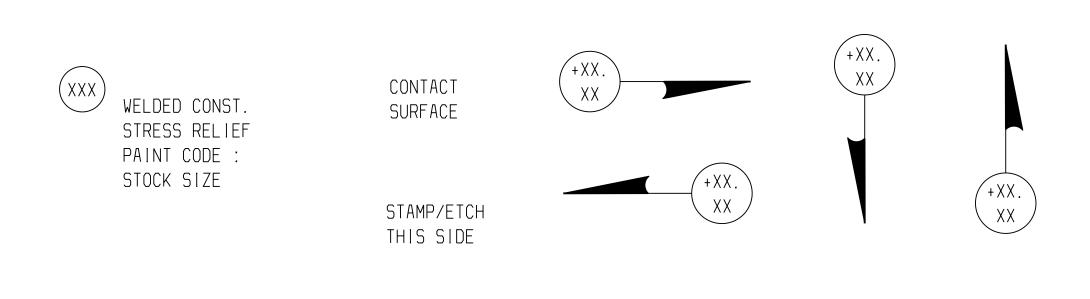
DYNAMIC WELDMENT:

STITCH WELDS TO BE COMPLETED PER APPLICABLE CODE.

MINIMUM 50% WELD COVERAGE PER CONNECTING MEMBER EDGE.

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.

STRESS RELIEF PAINT CODE : STOCK SIZE



(XXX)STOCK SIZE MATERIAL : PAINT CODE APPROX WT =

TO BOL "Z" TO FOL "X" TO **Ç** BODY "Y"

FINISH TO

CLEAN-UP

STA XXX

UNIT XXX

LPP Data: Weight in KG. = Volume in Cc = Steel or Aluminium = # of Plate components = # of Tubular Components = # Tapped Holes = # Drilled Holes = # Dowel =

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

STOCK SIZE MATERIAL

XXXX

| XXXXX-XXXX-XXX-X-XXX|

ZONE A GRAVER

```
THIS DRAWING MAY USE BOTH INCH AND METRIC
UNITS OF MEASUREMENT
(* INDICATES INCH DIMENSIONS)
MAXIMUM ALLOWANCE ROUGHNESS OF ALL
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_OLIN> 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
FOR SLIP FIT USE F7
```

MARK IDENTIFICATION AND MATERIAL NUMBERS ON DETAILS.

PAINT IDENTIFICATION NUMBERS ON STRUCTURAL WORK.