

J-Box
REF.

=2V06-V04WR1-U01

CR1300C-75WS-5000-CA
REF.

Holes on Turntable will be drilled
with reference to weldment

STA 030
KEYSHEET
WEIGHT: 3401.50*

| | |
|---|------------------------|
| 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 |
| ACTALENT | 22/04/2022 |
| Approved | Date |
| XX | XX |
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| Document Title | REAR WALL TURNTABLE |
| Document No | RW-030-TT |
| 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.

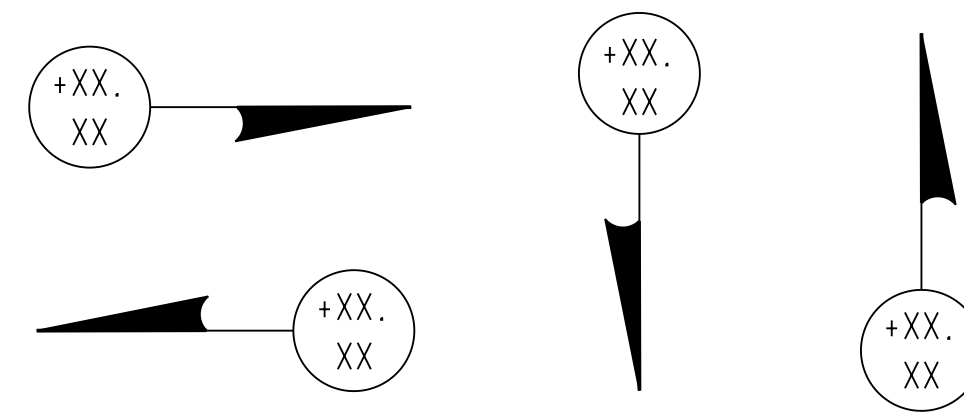
WELDING REQUIREMENTS
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 CSA W59.2 OR AWS D1.2 FOR ALUMINUM
DYNAMIC WELDMENTS
 ALL WELD SIZES TO BE EQUAL TO THE THINNEST CONNECTING MEMBER.

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 XXX
UNIT XXX

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 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 | g6 |
| FOR SLIP FIT USE F7 | |

MARK IDENTIFICATION AND MATERIAL NUMBERS ON DETAILS.
 PAINT IDENTIFICATION NUMBERS ON STRUCTURAL WORK.