



Engineering Release	Release	Location	Change description	Change	Subject	Version	Document release status
XX	XX	XX			SS-010-MH		DOC_REL_STATUS
							Date
ERN							XXXX-XX-XX

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
- 2 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 <XTRI_OLIN> 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.

STA 010
UNIT 001
196.8

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	Scale	First
JET	11/07/2022	-	A0
Approved	Date	Projection	Request reference
XX	XX	1	REQ_REF

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