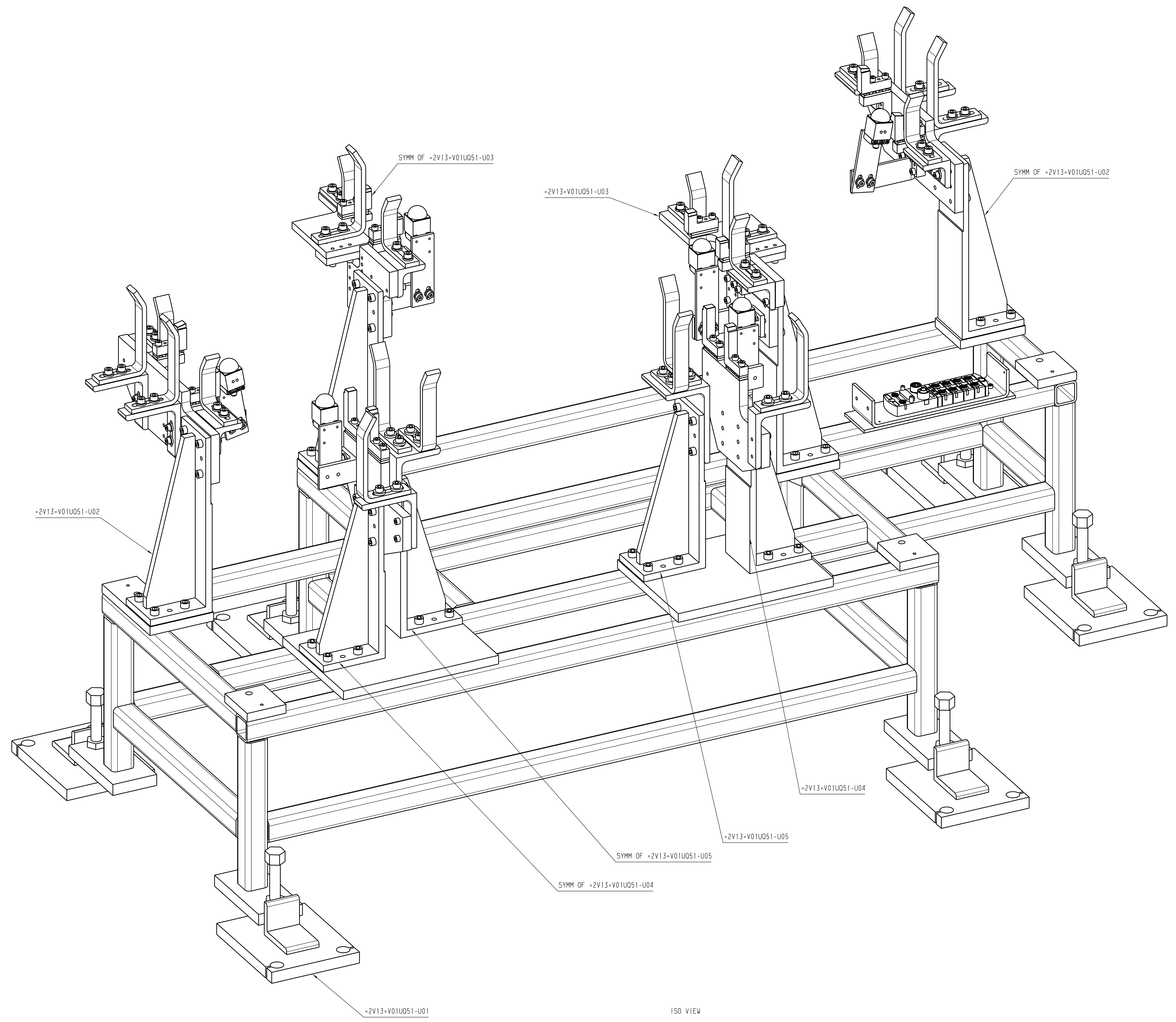


Engineering Release	Location	Change description	Subject	Version	Document release status
ERN	XX	XX	Substrate		DOC_REL_STATUS
					Date: XXXX-XX-XX
					Specification count: XX



STA 020  
KEYSHEET  
WEIGHT: 998.89\*

External Company	VOLVO		
External Specification	EXTERNAL SPECIFICATION		
Material	MATERIAL		
Surface Treatment	SURFACE TREATMENT		
DSM Number	DSM_NUMBER		
Symbois, 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	File
ACTALENT	6/02/2022	12.4:100	A0
Approved	Date	Projection	Request reference
XX	XX	1st	REQ_REF
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Document title		Document type	
SUB FLOOR		VOLVO FRAME E A0	
PASS TABLE			
RCM-020-PT			
Owner: actalent Document prefix			
Document No	Version	Sheet No	
=2V13-V01U051	01	11/1	

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.

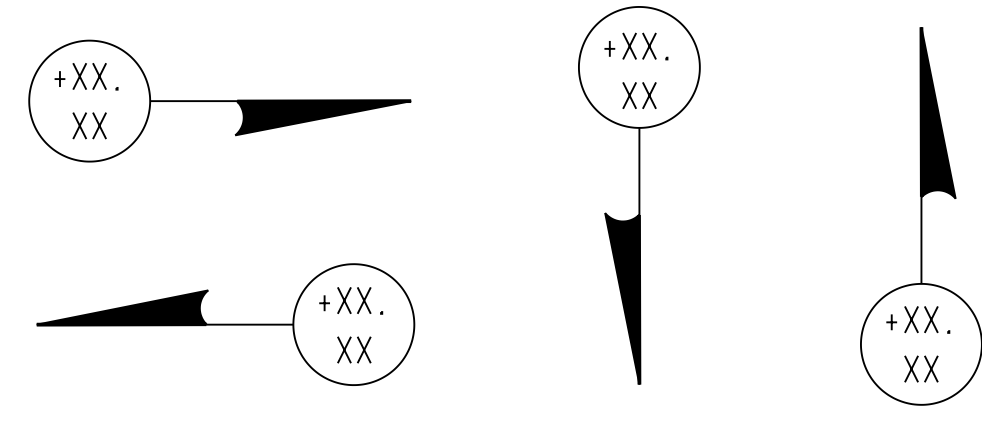
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CSA W59.2 OR AWS D1.2 FOR ALUMINUM  
DYNAMIC WELDMENTS  
ALL WELD SIZES TO BE EQUAL TO THE THINNEST CONNECTING MEMBER.

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



TO BODY \*Y\* TO BOL \*Z\* TO FOL \*X\*

LPP Data:

FINISH TO CLEAN-UP STA XXX UNIT XXX

- 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 :

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.