

Engineering Release Location Change description A=Added W=Was Notice (ERN) DOC_REL_STATUS

Date | Modification count | XXXX-XX-XX | XX

A Unit # 01 modified.

16146-1005-326-1

WEIGHT: 343.60#

STA 005 UNIT 000

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 ACTALENT Approved Projection Request reference REQ_REF The copying, distribution and utilization of this document as well as the communication of its contents to others without expressed authorization is prohibited. Offenders will be held liable for payment of damages. All rights reserved in the event of the grant of a patent, utility model or ornamental design registration.

Document title SUB FLOOR MANUAL REPAIR TABLE RCM-005-RT

Document type **VOLVO** Owner domain:Document prefix Document No = 2 V 1 3 = V 0 1 UQ52 Volvo Truck Corporation



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.

STITCH WELDS TO BE COMPLETED PER APPLICABLE CODE. MINIMUM 50% WELD COVERAGE PER CONNECTING MEMBER EDGE.

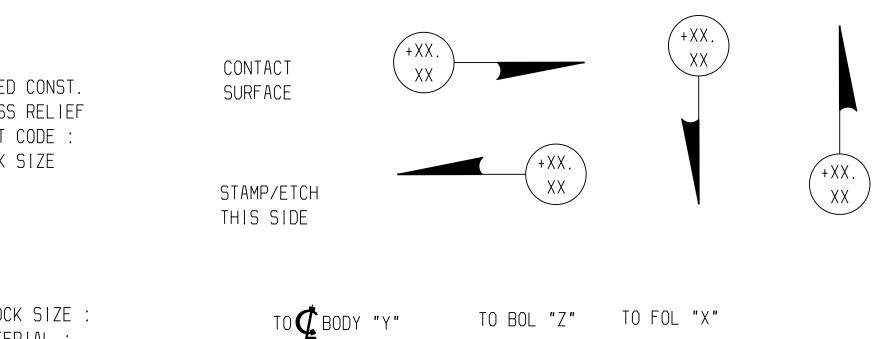
WELDING REQUIREMENTS WELDS SHALL NOT BE MACHINED OR DRILLED THRU WELDS SHALL BE COMPLETED TO: CSA W59 OR AWS D1.1 FOR STEEL CSA W59.2 OR AWS D1.2 FOR ALUMINUM DYNAMIC WELDMENTS

ALL WELD SIZES TO BE EQUAL TO THE THINNEST CONNECTING MEMBER.

DYNAMIC WELDMENT:

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 =

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

LPP Data:

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

STOCK SIZE MATERIAL

> ZONE A GRAVER XXXX

| XXXXX-XXXX-XXX-X-XXX|

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.