



SUB DET. #03
(BEFORE WELD)

SUB DET. #04
(BEFORE WELD)

STA 435
UNIT 001

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 FABRICATION +/-0.3
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 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 FOR PRESS FIT USE H6 FOR SLIP FIT USE F7

DOWEL TOLERANCE m6

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

LPP Data:
Weight in KG. =25.84 KG.
Volume in Cc =3000 Cc.
Steel or Aluminium =Steel
• of Plate components = 4
• of Tubular Components = 2
• Tapped Holes = 0
• Drilled Holes = 8
• Dowel = 0

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

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.

(001) FRAME
WELDED CONST.
STRESS RELIEVE
PAINT CODE :RAL 7035
PAINT:

- (01) 3 REQ'D - 3/8" X 3" X 150MM - SAE 1018
- (02) 1 REQ'D - 1/2" X 8" X 400MM - SAE 1018
- (03) 1 REQ'D - 2 1/2" X 2 1/2" X 3/16" WT. X 1715MM ASTM A500 GRADE B
- (04) 1 REQ'D - 2 1/2" X 2 1/2" X 3/16" WT. X 140MM ASTM A500 GRADE B

APPROX WT: 56.84*

16153-1435-704-1-001-0001

External Company	VOLVO
External Specification	EXTERNAL SPECIFICATION
Material	MATERIAL
Surface Treatment	SURFACE TREATMENT
DSM Number	DSM_NUMBER
Symbolic designations and general drawing method STD 101-0005	
Tolerance unless otherwise stated ISO 2768-m Sharp edges broken when function allows	
Drawn by	Date
JET	27/11/2023
Approved	Date
XX	XX
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VOLVO FRAME 4	