



LPP Data:

- Weight in KG: +5.21 KG.
- Volume in Cc: +663.4 Cc.
- Steel or Aluminium: Steel
- of Plate components: 1
- of Tubular Components: 2
- Tapped Holes: 3
- Drilled Holes: 0
- 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.

002 SUPPORT
 WELDED CONST.
 STRESS RELIEVE
 PAINT CODE :RAL 7035
 STK:

- (01) 1 REQ'D - 3/8" X 2 1/2" X 150MM - SAE 1018
- (02) 1 REQ'D - 2" X 2" X 3/16" WT. X 130MM ASTM A500 GRADE B
- (03) 1 REQ'D - 2" X 2" X 3/16" WT. X 600MM ASTM A500 GRADE B

APPROX WT: 11.46

16153-1435-704-1-001-0002

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 MACHINING +/-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 <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.

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	Scale	Proj
JET	27/11/2023	1:2	A0
Approved	Date	Projection	Request reference
XX	XX	1st	REQ_REF
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