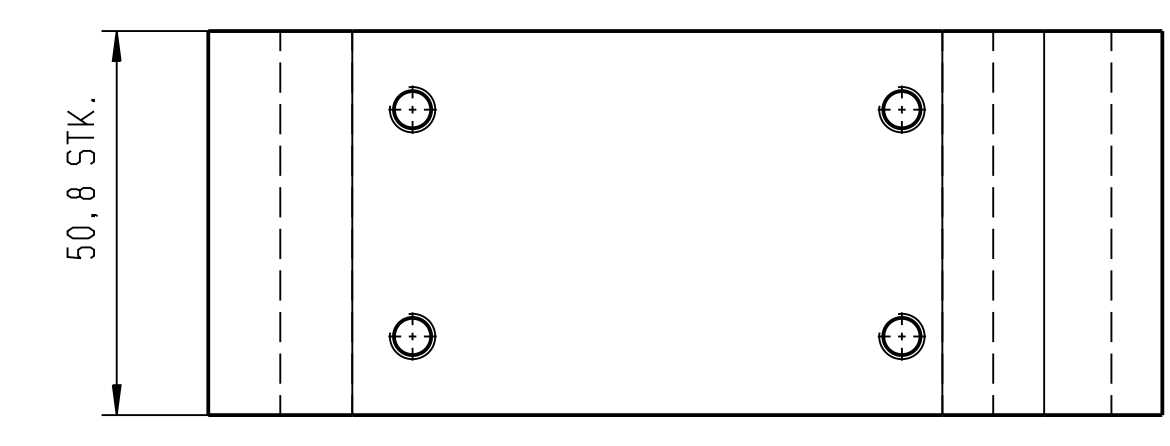
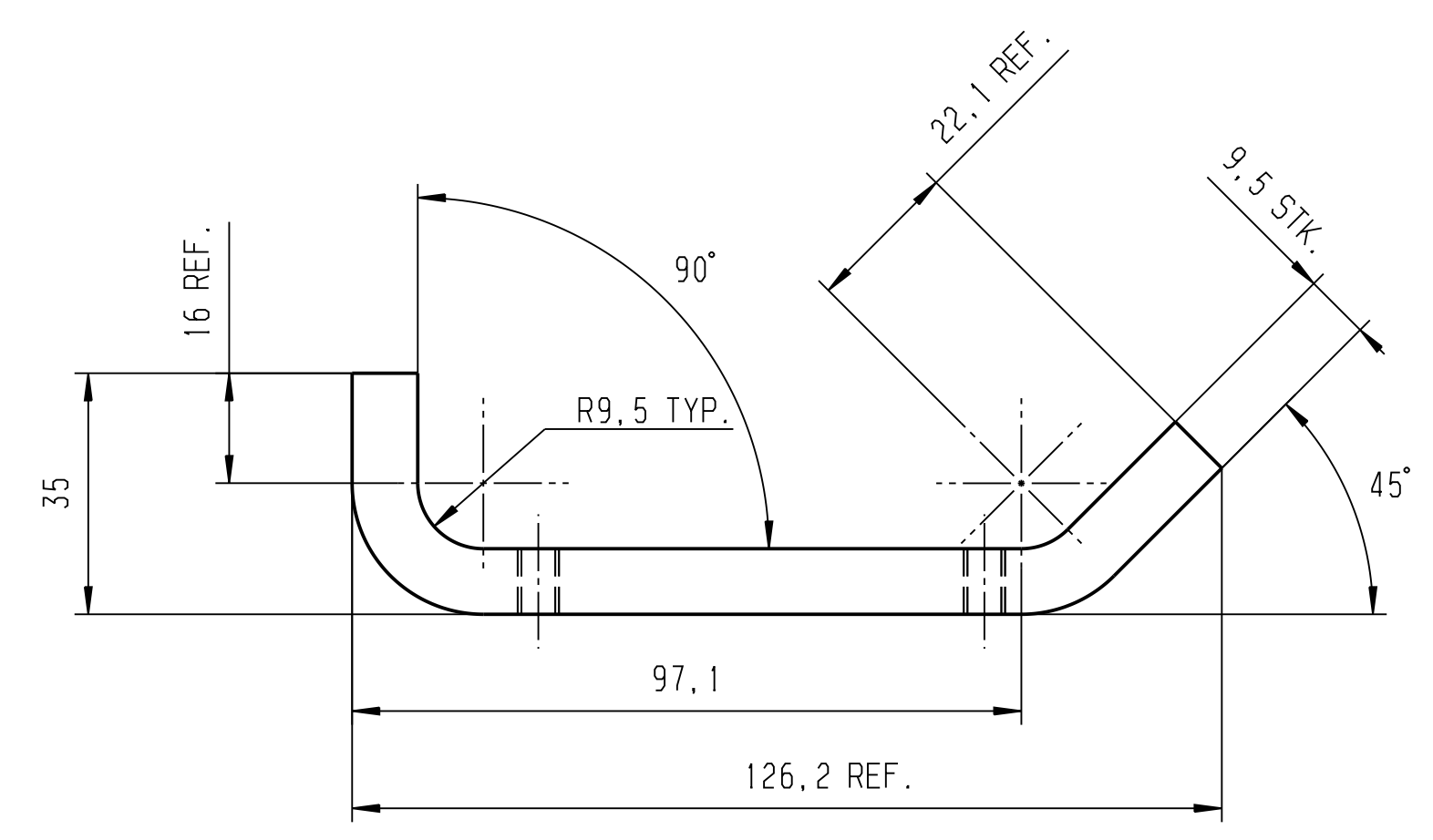
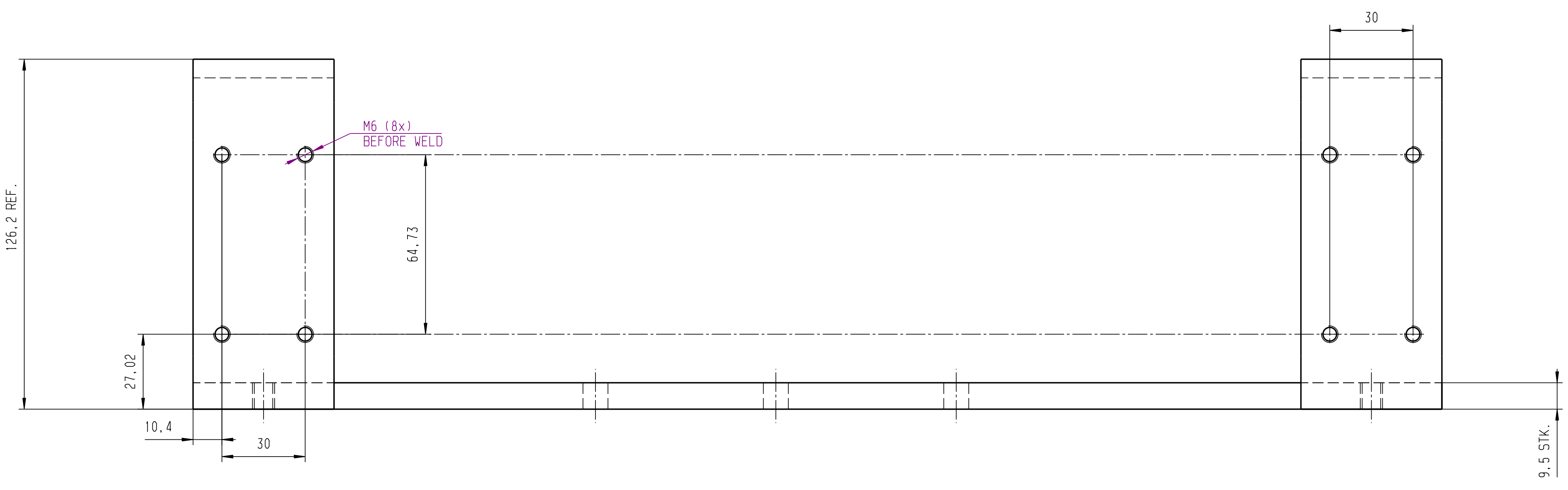


Make these surfaces flat for mating components (no excessive welds)



SUB DET. #02 (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 MACHINING +/-0.3  
2 PLACE FABRICATION +/-1.5  
3 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 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.

LPP Data:

Weight in KG. +2.8 KG.  
Volume in Cc +358.7Cc.  
Steel or Aluminium +Steel  
• of Plate components = 3  
• of Tubular Components =  
• Tapped Holes = 10  
• Drilled Holes = 3  
• 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.

008 BRACKET  
WELDED CONST.  
STRESS RELIEVE  
PAINT CODE :RAL 7035  
STK:

(01) 1 REQ'D \* 3/8" X 2" X 450MM - SAE 1018  
(02) 2 REQ'D \* 3/8" X 2" X 150MM - SAE 1018

APPROX WT: 6.20\*

16153-1435-704-1-001-0008

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