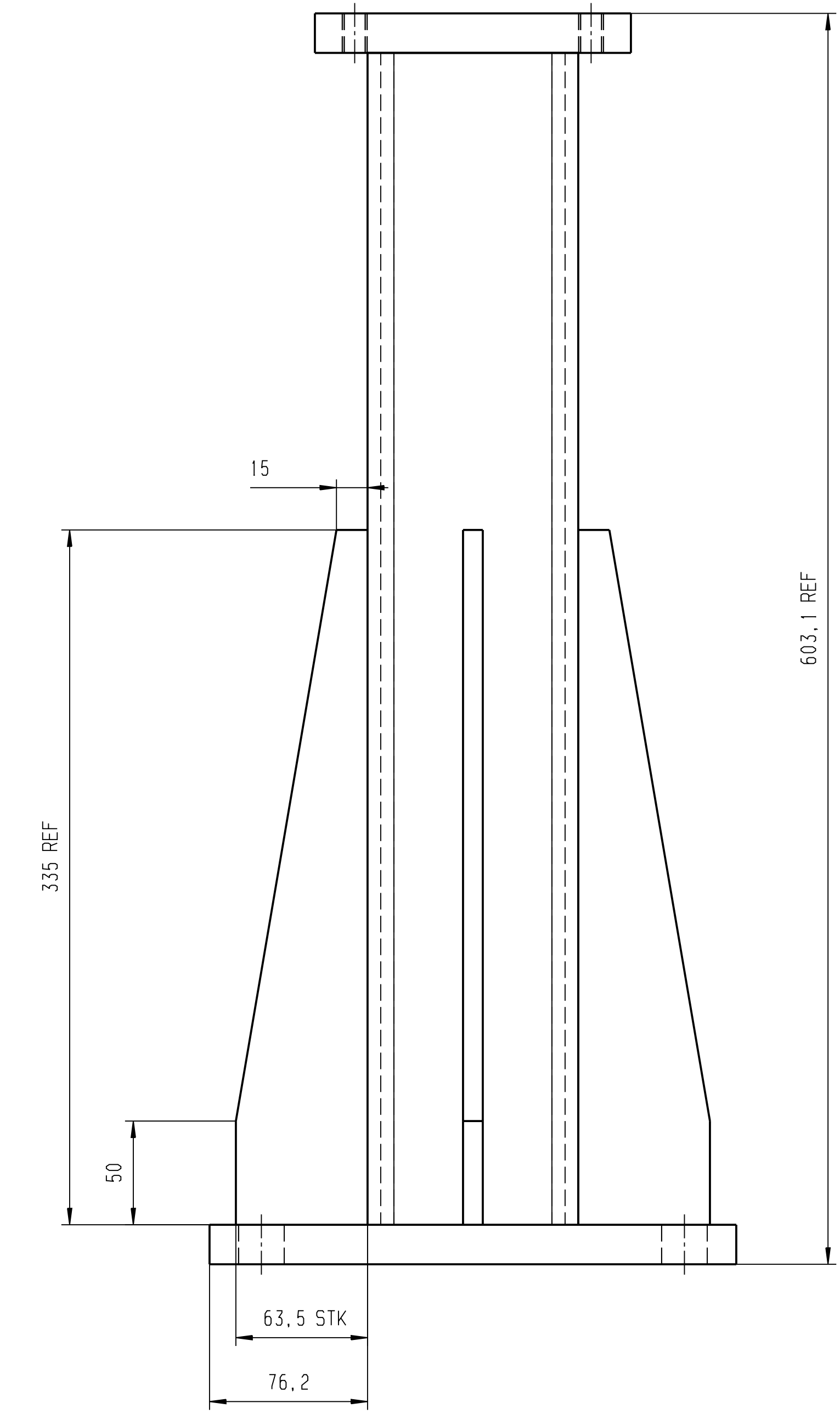
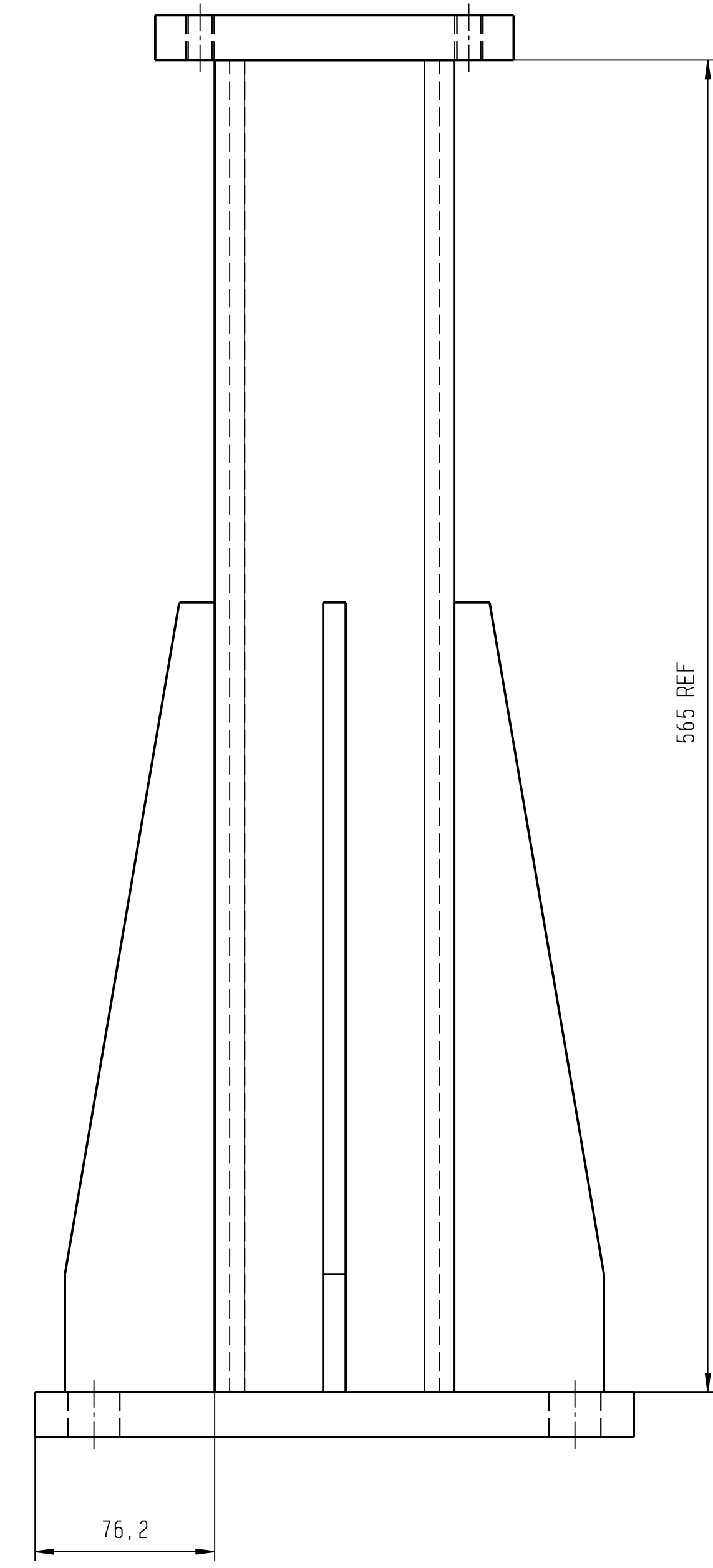


- 001 RISER
 WELDED CONST.
 STRESS RELIEVE
 PAINT CODE : RAL 7035
 STK:
 (01) 1 REO'D - 3/4" X 10" X 254MM - SAE 1020 HR
 (02) 1 REO'D - 4" X 4" X 1/4" X 565MM - ASTM A500 GRADE B
 (03) 1 REO'D - 3/4" X 6" X 152MM - SAE 1020 HR
 (04) 4 REO'D - 3/8" X 2 1/2" X 335MM - SAE 1020 HR
 APROX WT. 60.5*



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 FABRICATING +/-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.

STA 475
 UNIT 001

External Company	VOLVO
External Specification	EXTERNAL SPECIFICATION
Material	MATERIAL
Surface Treatment	SURFACE TREATMENT
DSM Number	DSM_NUMBER
Syntax, designations and general drawing method STD 101-0005	
Tolerance unless otherwise stated ISO 2768-m Sharp edges broken when function allows	
Drawn by	VALIANT
Date	14/02/2024
Scale	1:2
Projection	AO
Request reference	REQ_REF
Approved	VALIANT
Date	14/02/2024
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Version	01
Sheet No	11/1

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LPP Data:
 Weight in KG. =27.44 Kg.
 Volume in Cc =3490.668cm3
 Steel or Aluminium =
 # of Plate components =6
 # of Tubular Components =1
 # Tapped Holes =4
 # Drilled Holes =4
 # 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
 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.