



- 002 POST WELDED CONST. STRESS RELIEVE PAINT CODE : RAL 7035 STK:
- (01) 1 REQ'D - 3/4" X 6" X 152MM - SAE 1020 HR
 - (02) 1 REQ'D - 2" X 2" X 3/16" X 2200MM - ASTM A500 GRADE B
 - (03) 4 REQ'D - 3/8" X 1 3/4" X 400MM - SAE 1020 HR
- APROX WT. 47*

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

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		
Symbols, designations and general drawing method STD 101-0005			
Tolerance unless otherwise stated ISO 2768-m Sharp edges broken when function allows			
Drawn by	VAL LANT	Date	14/02/2024
Checked by	VAL LANT	Date	14/02/2024
Project	REQ_REF	Scale	1:2
Request reference	REQ_REF	Sheet No	01
The copyright, distribution and utilization of this document is restricted to the project it was created for. All rights reserved. No part of this document may be reproduced, stored in a retrieval system, or transmitted in any form or by any means, electronic, mechanical, photocopying, recording, or by any information storage and retrieval system, without the prior written permission of Volvo Group.			
LIGHT INSPECTION =2V15=V01U051 NE-475-L11			
Document Code			
Docnr: 16175-1475-1-001-0002			
Document No =2V15=V01U051			
Version 01			
Sheet No 1/1			

16175-1475-1-001-0002

LPP Data:

Weight in KG. =21.28 Kg.

Volume in Cc =2706.919cm3

Steel or Aluminium =

- # of Plate components =5
- # of Tubular Components =1
- # 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

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.