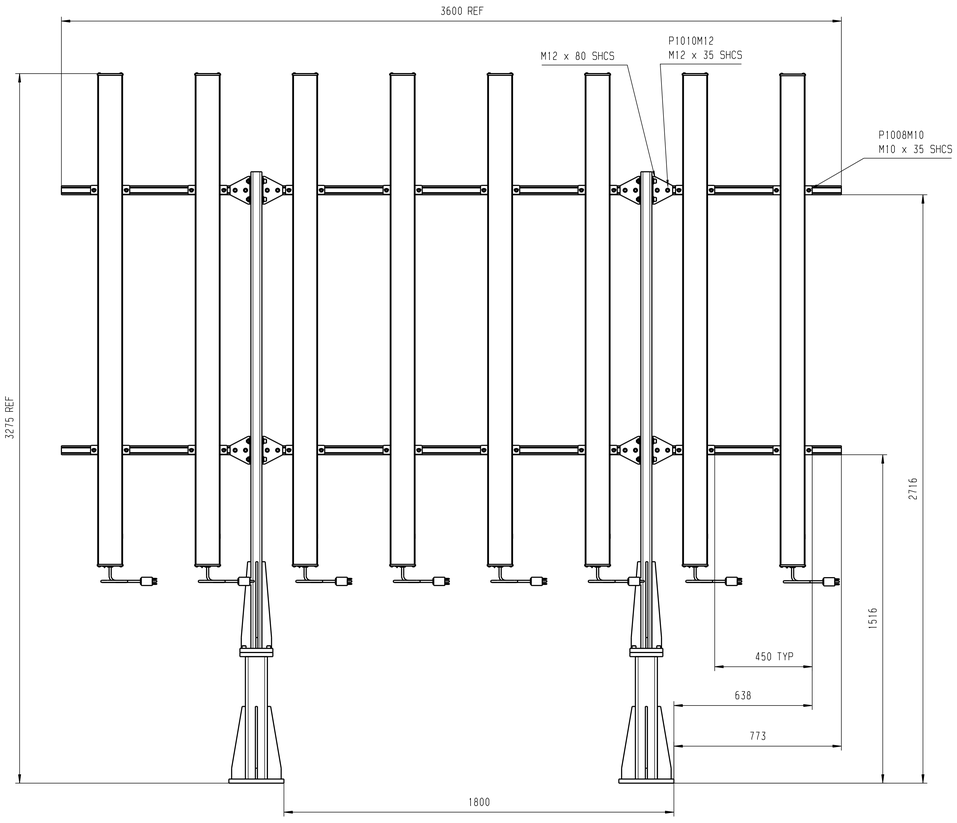
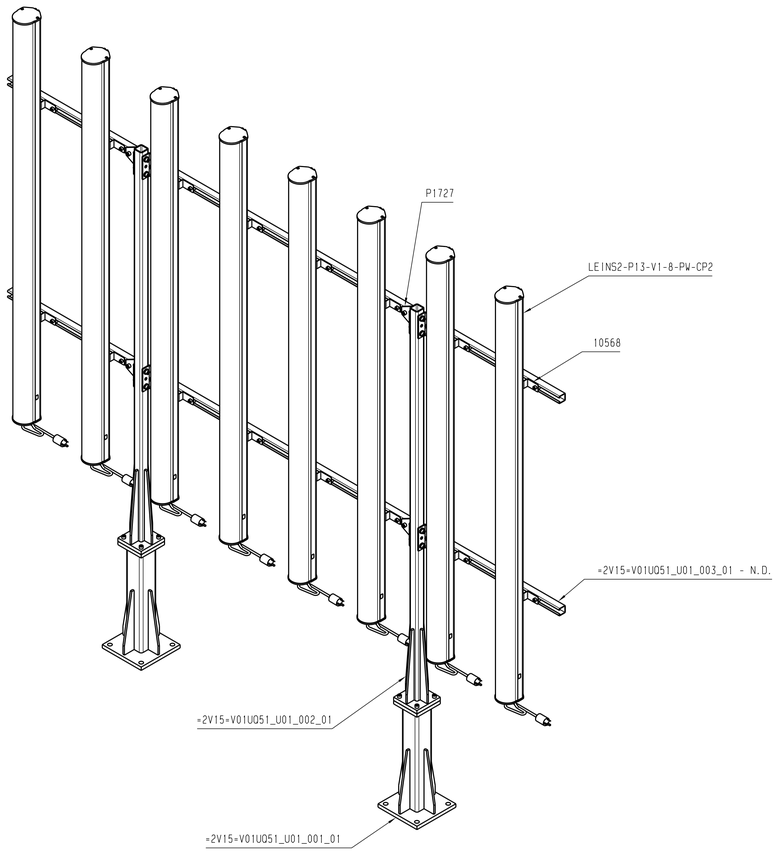
Engineering Release Notice (ERN)	Location	Change description A=Added D=Deleted	V=Valid	Document release status
				DOC_REL_STATUS
ERN	XX	XX		Date XXXX-XX-XX / Modification count XX





ISO VIEW

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
1 PLACE FABRICATION +/-1.5
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 SUFACES.

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

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	Size
VALIANT	14/02/2004	NONE	A0
Approved VALIANT	Date 14/02/2004	Projection	Request reference REQ_REF

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VOLVO
Volvo Truck Corporation

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STA 475
UNIT 001

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