

SHEET METAL NOTES:

- 1. Deburring to smooth the rough edges.
- 2. Grind all spot welds as necessary to avoid interferences with other parts.
- 3. Steel parts to be painted must be processed and pre-pared for painting using any cleaning method (chemical or mechanical).
- 4. All surfaces (int. & ext.) must be free of oil, grease, silicon, or any other substance to avoid powder coated defects.
- 5. All steel parts must be phosphate-treated after cleaning.

**FOLDED SHEET METAL
BACK PLATE, ENCLOSURE SERVER**
PN: SV01-SM-BKP001
MATERIAL: SA-36
GAUGE: 18

THIS PART NUMBER WILL
BE ASSEMBLED WITH PN'S:
SV01-SM-CVR001
SV01-SM-BAS001
SV01-SM-BKT001

FINISH NOTES:

A) Surface: (Primary or External Surface)
The coating on the primary external surfaces shall be of uniform appearance, color, and texture, and be free from significant defects.

B) Surface: (Secondary or Internal Surface)
Secondary surfaces are checked for acceptable powder coat coverage and are free from significant defects but may contain minor defects. The coating requirement for secondary surfaces is for a light coverage only where possible.

C) Possible Defects
Possible defects that may be seen includes: inclusions (foreign particles in the powder), contamination (different color powder in the surface finish), excessive roughness, craters, dull spots, scratches, sagging or any other unacceptable flaws.
See the document: "Troubleshooting guide en 1016.pdf" for furter defects reference or any other realted guidance book.

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		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONAL: ± 1/16 DECIMAL .XX ± .03 .XXX ± .010 ANGLES: ± 1/2 °		NAME	DATE
			DRAWN	GL	12/21
			CHECKED	GL	12/21
			ENG APPR.	GL	12/21
		ANGLES: ± 1/2 °	MFG APPR.	HA	12/21
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.		
		MATERIAL	COMMENTS:		
		SA-36			
		FINISH			
NEXT ASSY	USED ON	POWDER COATED			
APPLICATION		DO NOT SCALE DRAWING			

TITLE: BACK PLATE, ENCLOSURE, SERVER					
SIZE B	DWG. NO. SV01-SM-BKP001-R4			REV 4	
SCALE: 1:3		WEIGHT:		SHEET 1 OF 3	

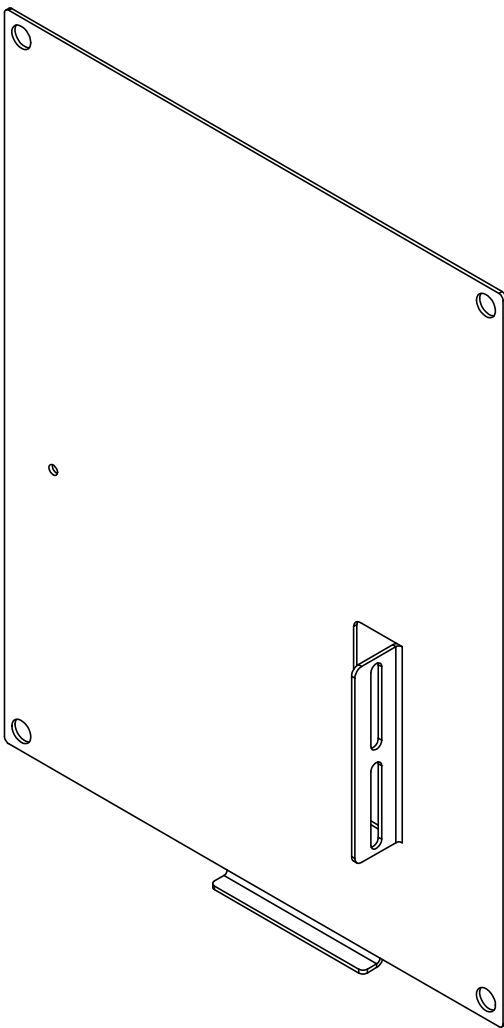
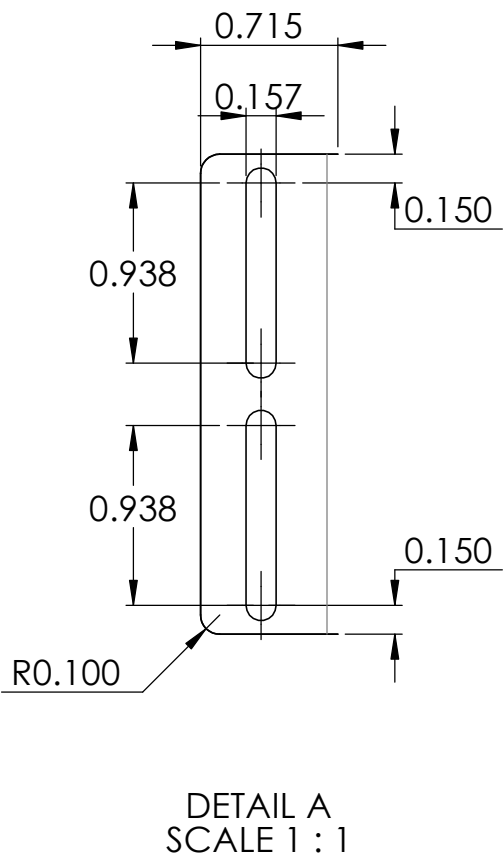
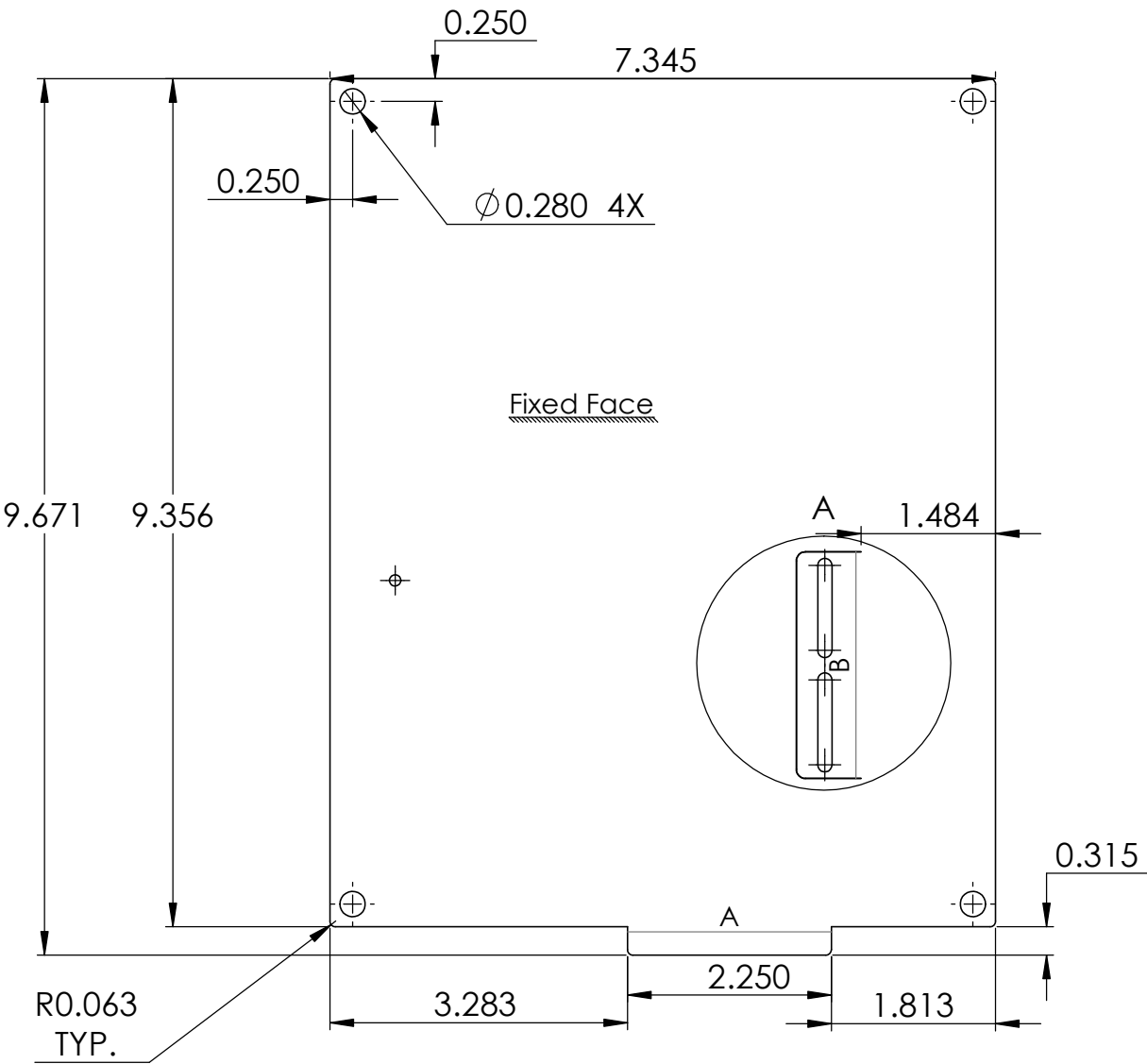
8 7 6 5 4 3 2 1

D

C

B

A



SHEET METAL FLAT PATTERN
BACK PLATE, ENCLOSURE SERVER
PN: SV01-SM-BKP001
MATERIAL: SA-36
GAUGE: 18

THIS PART NUMBER WILL
BE ASSEMBLED WITH PN'S:
SV01-SM-CVR001
SV01-SM-BAS001
SV01-SM-BKT001

Bend Table			
Tag	Direction	Angle	Inner Radius
A	UP	90°	0.05
B	UP	90°	0.05

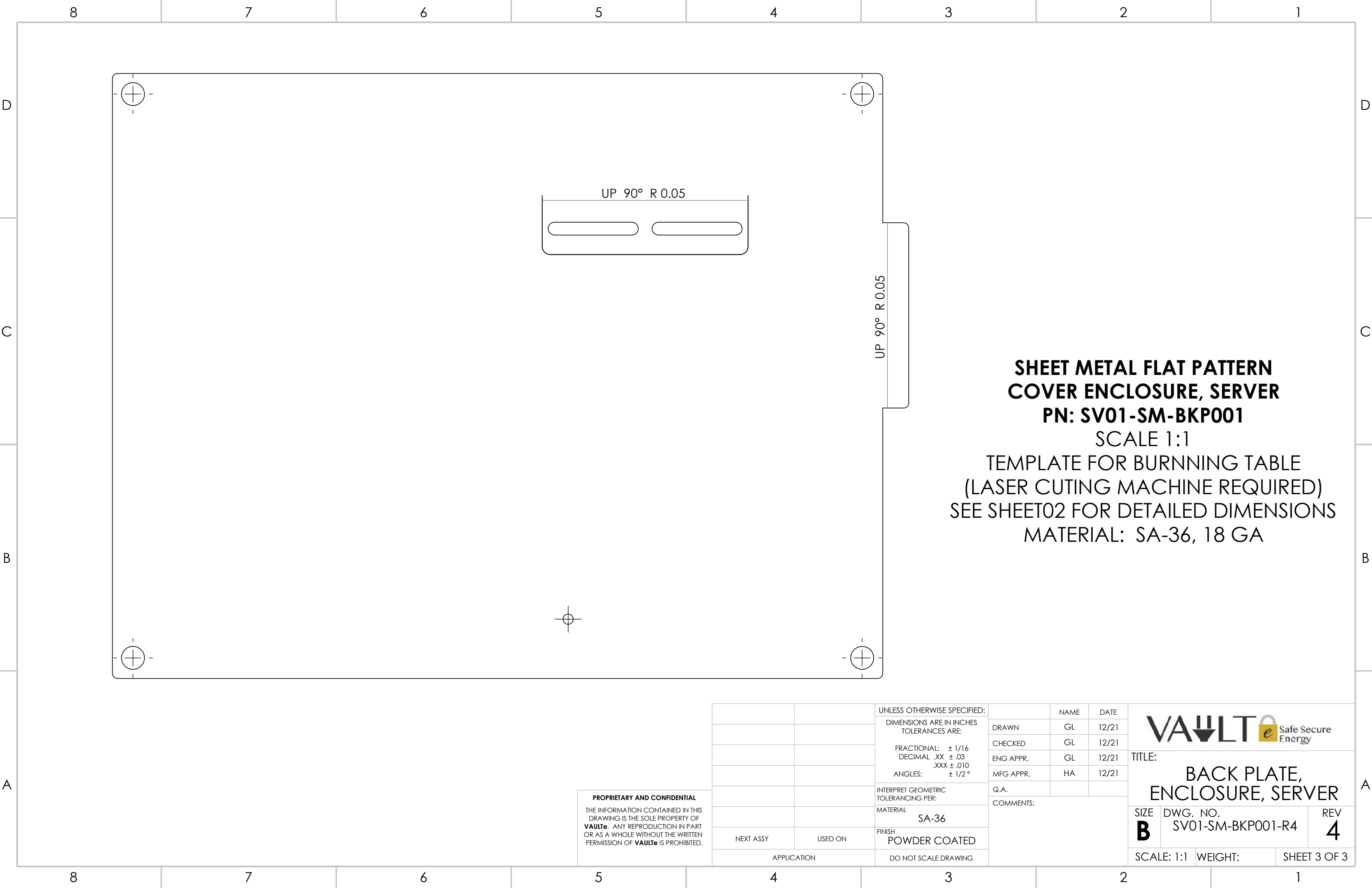
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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE
		DIMENSIONS ARE IN INCHES TOLERANCES ARE:	DRAWN	GL	12/21
		FRACTIONAL: ± 1/16 DECIMAL .XX ± .03 .XXX ± .010 ANGLES: ± 1/2°	CHECKED	GL	12/21
			ENG APPR.	GL	12/21
		INTERPRET GEOMETRIC TOLERANCING PER:	MFG APPR.	HA	12/21
		MATERIAL	Q.A.		
		SA-36	COMMENTS:		
		FINISH			
NEXT ASSY		POWDER COATED			
USED ON					
APPLICATION		DO NOT SCALE DRAWING			



TITLE: BACK PLATE, ENCLOSURE, SERVER			
SIZE B	DWG. NO. SV01-SM-BKP001-R4	REV 4	
SCALE: 1:2	WEIGHT:	SHEET 2 OF 3	



8 7 6 5 4 3 2 1



**SHEET METAL FLAT PATTERN
COVER ENCLOSURE, SERVER
PN: SV01-SM-BKP001**

SCALE 1:1
TEMPLATE FOR BURNNING TABLE
(LASER CUTING MACHINE REQUIRED)
SEE SHEET02 FOR DETAILED DIMENSIONS
MATERIAL: SA-36, 18 GA

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		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONAL: ± 1/16 DECIMAL .XX ± .03 .XXX ± .010 ANGLES: ± 1/2 °	DRAWN	GL	12/21	 			
			CHECKED	GL	12/21				
			ENG APPR.	GL	12/21				
			MFG APPR.	HA	12/21				
		INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.			TITLE: BACK PLATE, ENCLOSURE, SERVER			
		MATERIAL	COMMENTS:						
		SA-36							
NEXT ASSY	USED ON	FINISH POWDER COATED				SIZE B	DWG. NO. SV01-SM-BKP001-R4	REV 4	
APPLICATION		DO NOT SCALE DRAWING				SCALE: 1:1		WEIGHT:	SHEET 3 OF 3