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|                                | 1   | 2 | 3  | 4  | 5  | 6 | 7 | 8  | 9  | 10 | 11   |   |  |  |  |  |  |  |
| A                              | MASTER-Zeichnung lt. QSVSTD / MASTER drawing accord. to QSVSTD                    |   |  |  | Technische Beschichtungstabelle QSV TECHNISCHEOBERFLAECHEN / Nichtsichtbereich<br>technical coating chart QSV TECHNICALSURFACES / non visible area |   |   |  | 3-D Daten / 3-D data                               |    |  | A |  |  |  |  |  |  |
|                                | - Variantenzeichnungen können zu MASTER-Zeichnung variierende Angaben enthalten   |   | - Variant drawings contain different definitions                                 |  | Technologie / technology   |   |   |  | - Zeichnung nur gültig in Verbindung mit 3-D Daten |    | - Drawing just valid in combination with 3-D data. |   |  |  |  |  |  |  |
|                                | - Bei überbestimmen Angaben auf Master und Variante, gilt die Angabe der Variante |   | - In the case of redundant definitions, definition from variant drawing is valid |  | Farbe - colour   |   |   |  | - Fehlende Maße sind den 3-D Daten zu entnehmen.   |    | - Missing dimensions according to 3-D data.        |   |  |  |  |  |  |  |
| B                              |   |   |  |  | Beschichtung / coating   |   |   |  |  |    |  | B |  |  |  |  |  |  |
|                                |   |   |  |  | Zusätzliche Spezifikationen / additional specifications  |   |   |  |  |    |  |   |  |  |  |  |  |  |
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| C                              |   |   |  |  | Powercron 937A empfohlen / Powercron 937A recommended  |   |   |  |  |    |  |   |  |  |  |  |  |  |
|                                |   |   |  |  | QSV Baustein I0711 Prüfdauer für 600h ohne Veränderung   |   |   |  |  |    |  |   |  |  |  |  |  |  |
|                                |   |   |  |  | QAA block I0711 test duration only 600h without a change   |   |   |  |  |    |  |   |  |  |  |  |  |  |
|                                |   |   |  |  | 360h Salzsprühnebeltest (ISO 9227) / 360h salt-water spray test (ISO 9227)   |   |   |  |  |    |  |   |  |  |  |  |  |  |
|                                |   |   |  |  | Gewinde lehrengängig, öl-, fettfrei / threads true to gauge, oil, grease free  |   |   |  |  |    |  |   |  |  |  |  |  |  |
| D                              |   |   |  |  |  |   |   |  |  |    |  |   |  |  |  |  |  |  |
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| E                              |   |   |  |  |  |   |   |  |  |    |  |   |  |  |  |  |  |  |
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| F                              |   |   |  |  |  |   |   |  |  |    |  |   |  |  |  |  |  |  |
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| G                              |   |   |  |  |  |   |   |  |  |    |  |   |  |  |  |  |  |  |
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| H                              |   |   |  |  |  |   |   |  |  |    |  |   |  |  |  |  |  |  |
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| 2                              |   |   |  | 1  |  |   |   |  |  |    |  |   |  |  |  |  |  |  |
| 1                              |   |   |  | 2  |  |   |   |  |  |    |  |   |  |  |  |  |  |  |
| POS                            |   |   |  | Stk. QTY                                   |  |   |   | Werkstoff MATERIAL                               |  |    |  |   |  |  |  |  |  |  |
| Artikelnummer ITEM NUMBER      |   |   |  | Bezeichnung (deutsch) DESCRIPTION (GERMAN) |  |   |   | Bezeichnung 2 (englisch) DESCRIPTION 2 (ENGLISH) |  |    |  |   |  |  |  |  |  |  |
|                                |   |   |  |  |  |   |   |  |  |    |  |   |  |  |  |  |  |  |
| STÜCKLISTE / BILL OF MATERIALS |   |   |  |  |  |   |   |  |  |    |  |   |  |  |  |  |  |  |
| 1                              |   |   | 2  |  |  | 3 |   |  | 4  |    |  |   |  |  |  |  |  |  |
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| Ausfuehrung der Widerstandsschweißungen /<br>Execution of resistance welding  |  |  |
| Qualiaetssicherung nach / quality assurance acc. to<br>KTM QSVSTD SCHWEISSBAUGRUPPEN WELDING ASSEMBLIES   |  |  |
| Schweißtech. Qualitaetsanforderungen nach /<br>Quality requirements f. welding accord. to: EN ISO 14554   |  |  |
| Schweißprocess / welding process nach ISO 4063: 23  |  |  |
| Darstellung der Schweißnaechte nach EN 22553 (EN ISO 2553) /<br>representation of the welds according to EN 22553 (EN ISO 2553)   |  |  |
| Bezeichnung Schweißprozesse nach / Name of the welding processes according to ISO 4063:<br>21 ...Widerstandspunktschweißen / Resistance spot welding<br>22 ...Widerstandsrollnahtschweißen / Resistance seam welding<br>23 ...Widerstandsbuckelschweißen / Projection welding |  |  |

|                           |   |  |
|---------------------------|---|--|
| Schweißmutter<br>Weld Nut | Ausdrehmoment min.<br>min. durable torque | Auspresskraft min.<br>min. durable force |
| M10                       | 40Nm                                      | 5000N                                    |
| M8                        | 30Nm                                      | 4000N                                    |
| M6                        | 20Nm                                      | 3000N                                    |
| M5                        | 15Nm                                      | 2500N                                    |

|   |  |  |
|---|--|--|
| Positionierung von Schweißmuttern<br>positioning of weld nuts |  |  |
|   |  |  |

|  |      |                               |  |   |            |
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| Rev (Count)  | Date | Name                          | Change description   |   |            |
|  |      |                               |  |   |            |
| KTM AG<br>Stallhofnerstraße 3<br>5230 Mattighofen<br>Austria |      | Mass: 0 g                     | Material: siehe Stückliste / see BOM   |   |            |
| for C-SAMPLE production<br>RELEASED                          |      | General tolerances: ISO 22081 | Blank part: -  |   |            |
|  |      | See table 1 in DIN 2769 - B5  | Standard QAA (QSVSTD) and part classification:<br>Schweisssbaugruppen-Weldingassemblies    |   |            |
|  |      | Linear sizes: ±12             |  | safety: mechanical stress: tightness: surface:<br>B B C B |            |
|  |      | See table 2 in DIN 2769 - b   |  |   |            |
|  |      | Angular sizes: ±13°           |  |   |            |
|  |      | See table 3 in DIN 2769 - 1   | Description:<br>Adapterblech Scheinwerferträger kpl<br>adapter plate headlight carrier cpl |   |            |
|  |      | Tolerances ISO 8015           |  |   |            |
|  |      | Approved by                   |  | Drawing number:<br>A67614010055                           |            |
|  |      | Date                          |  |   | Scale: 1:1 |
|  |      | ASM-Responsible               |  |   | Sheet: A2  |
|  |      | WichtID                       | 1/1  |   |            |
|  |      | 2023-04-17                    | Name: Hoffmann H.  | Current revision: -                                       |            |
|  |      |                               | Date: 14.12.2022   |   |            |
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