

THERE WILL DO GRINDING AFTER WELDING

Ø15 -0,016
-0,027

Ø20 -0,02
-0,033

THIS HOLE MUST BE DRILLED AFTER
THE SPINDLE AND BODY HAVE BEEN WELDED

85,5 ±0,3

NOTES:

-AFTER WELDING, HEAT THREATMENT
AND SENSITIVE PROCESSING
-THIS AREA MUST BE PROTECTED
FROM COATING

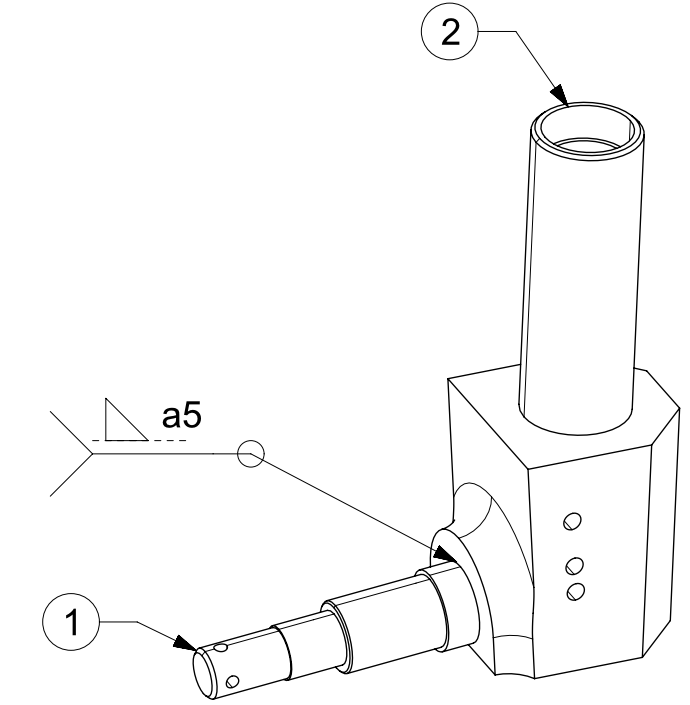
0.8

0.8

22,5 ±0,15

38,5 ±0,2



66,5 ±0,2

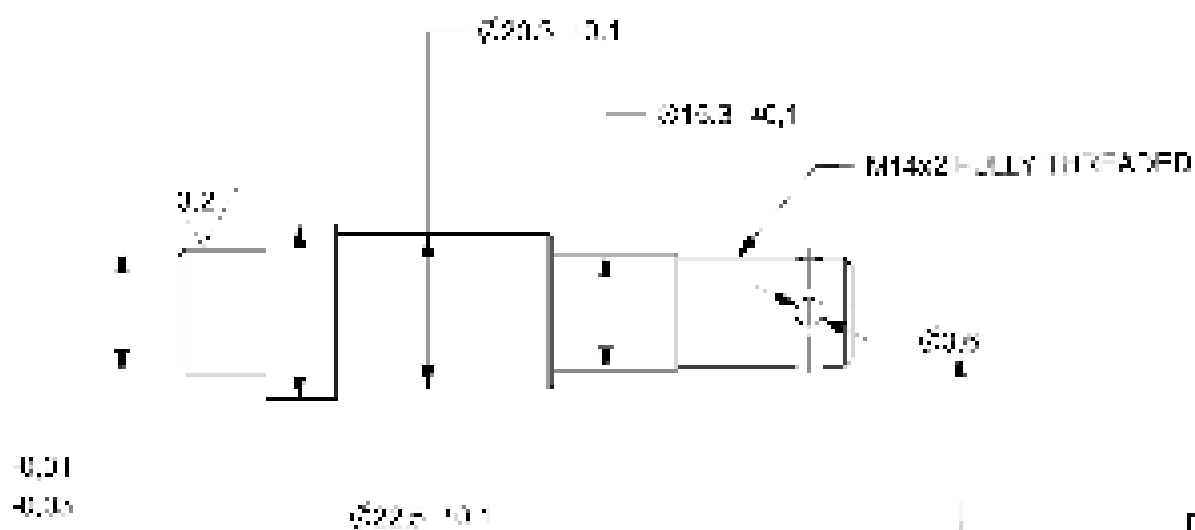


NOTES:

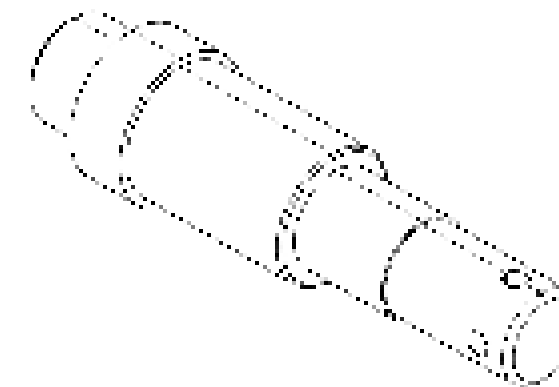
-WELDING METHOD: 287-1/135/MIG-MAG
-TOLERANCES NOT SHOWED IN THE WELDING
EN ISO 13920-A
-INDUCTION HEAT TREATMENT 48-52 HRc

Number	Part Number	Definition	Quantity	Revision	Tightening Torque (Nm)	Criticalities For Safety
1	FQK.213000.AA	KNUCKLE BODY	1	D		
2	FQK.213018.AA	KNUCKLE SPINDLE	1	D		

REVISED	03.05.2023	MATERIAL: MALZEME:	TRACEABILITY: İZLENEBİLİRLİK:	REGULATION: REG. İŞARET:		
ECO NO:	HARDNESS: SERTLİK:	COATING: KAPLAMA:	BLACK CATAPHORESIS	NORMES: ŞARTNAMELER:		
CHANGE DESCRIPTION	PART NAME: PARÇA ADI:			WEIGHT AĞIRLIK	DRAWN: ÇİZEN: Mert İNCİ	
	KNUCKLE WELDED ASSEMBLY			H	CHECKED: KONTROL: Yasin BORAN	
					APP: ONAY: Baki Orçun ORGÜL	
	DWG NO: RESİM NO:	FQK.A213003.AA	SSR: -	PAGE SAYFA 1/3	SCALE ÖLÇEK 1:1	MODEL: MODEL:
				FORMAT EBAT A3	UNSPECIFIED TOLERANCES GENEL TOLERANS -	VERSION: VERSİYON: D
	Fernihay LTD Elizabeth House 13-19 London Road Newbury Berkshire RG14 1JL United Kingdom					



218	-0.01
	-0.03
± 0.2 A	



THE DIMENSIONS GIVEN ARE THE MANUFACTURING DIMENSIONS.
WELDING AND GRINDING WILL BE APPLIED TO THE PART DURING ASSEMBLY.

[illegible]