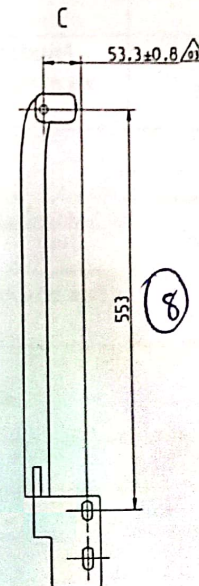
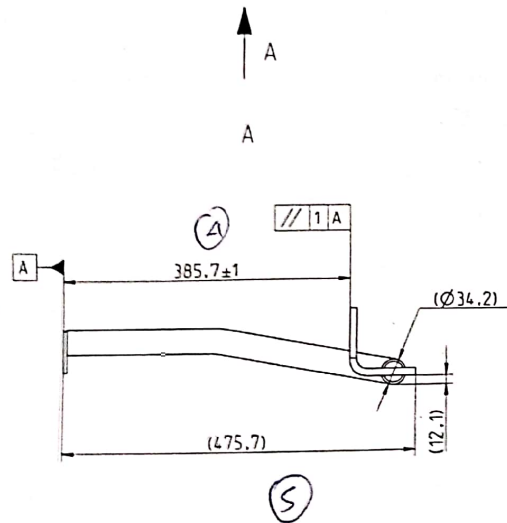
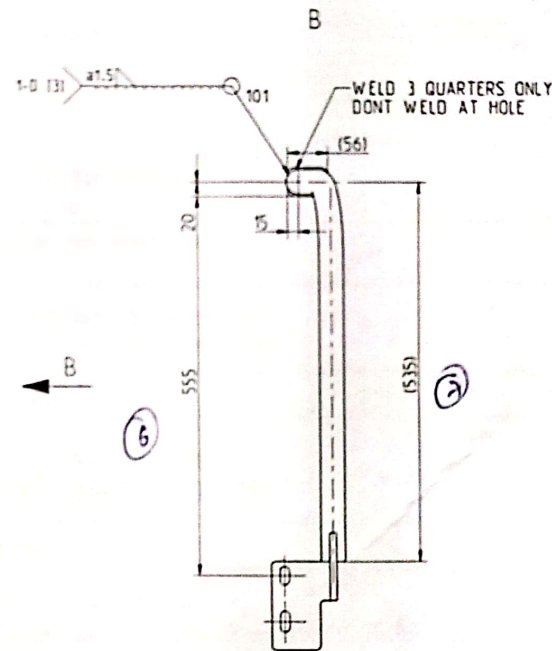
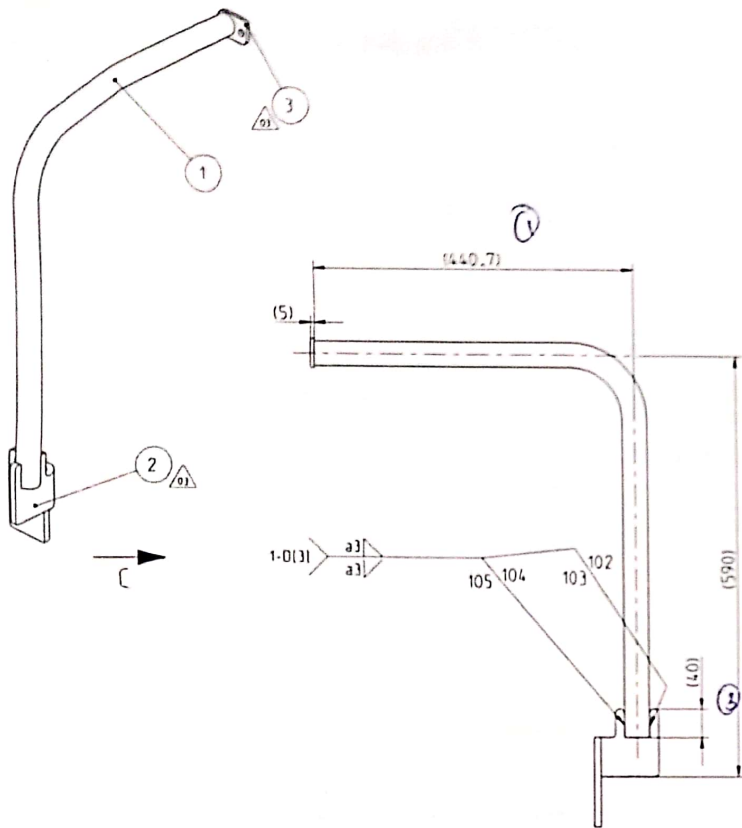


03	11-1761	ITEM#2 REPLACED WITH 12785198, ITEM#3 REPLACED WITH 12785199, DIM 53.3±0.8 WAS 43.3±0.8.	OE puri	2012-01-02	ASHOK
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WELDING REQUIREMENTS STD 180-0001

WELDING TOLERANCES ISO 13920-BF

UNSPECIFIED EDGES $\sqrt{1-0.5}$ $\sqrt{1-0.5}$

DIGITAL SHAPE MODEL
IS BASIS WHERE DIMENSIONS ARE OMITTED
STD 101-0001

FIRST WELD NUMBER 101

LAST WELD NUMBER 105



SCALE 1:5

Free from listed prohibited chemical substances STD 100-0005			
Height (kg)	Material designation, Standard	Surface Treatment, Standard	Colour, Standard
3,5	REF TO DRAWING	5751,51 Class K3	121-0007.5002
Symbols, designations and general drawing methods	View placement Reference name method	Document release status	
STD 101-0005	ISO 178-30 2001	RELEASED	
The copying, distribution and publication of this document as well as the communication of its contents to others without expressed authorisation is prohibited. Offenders will be held liable for payment of damages. All rights reserved in the event of a patent, utility model or industrial design registration.		Document title WELDING DRAWING COOLER TOP STAY AND RAILING	
VOLVO Construction Equipment		Document type DRAWING	
		Owner Domain: Document profile Bangalore, India	
		Document No 12761270	Issue 02
			Sheet No

VOLVO
Construction Equipment



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		Fixture Verification check sheet Mag/FVCS/01 REV 00	
Sl No.	Process Name	Standard parameters	Date: 15/05/23
			Fixture No: ME/VCE/SD110/03
			Fixture Description: Cooler top stay
			Customer: Volvo
			Part Name: Cooler top stay & Railly
			Location: Volvo FAB
1	Condition of Clamps	Should firmly hold the workpiece, Should not create marks on the surface	OK
2	Condition of Locating Blocks	Should be free from wear out, Check the flatness using steel rule	OK
3	Condition of Locating Pins or Hole dia	Check dia and record, Clearance between Hole dia and pin dia should not be more than 0.5mm	OK
4	Locating positions	Should be as per drawing	OK
5	Part resting surface	Should be free from uneven surface, High points (Projections), sticking of foreign particles.	OK
6	Bolt and screw Tightness	Free from loose fitment	OK
7	Child part resting blocks	Height should be uniform, the difference between block should not exceed 0.2mm, Proper resting of child parts without taper.	OK
8	Surface levelling	Fixture to be levelled, check using spirit level / Tube and Grouting / Levelling of fixture in its location.	OK
9	Operator Convenience	Ergonomics, Ease for part fitment, removal, rotation etc.	OK
10	Fixture Identification	Fixture should have No, Description and added in the Fixture list	OK
11	Part Inspection report	Part made out of the Fixture to be checked and report to be attached	OK
	Fixture Status / Remarks	OK / Conditionally accepted / Rejected	OK
Checked By 			Date: 15/5/23
Verified By			Date:

SANDHAR 2. map
SANDHAR
SANDHAR

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