

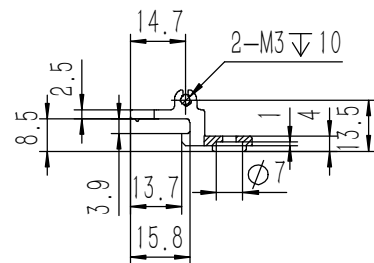
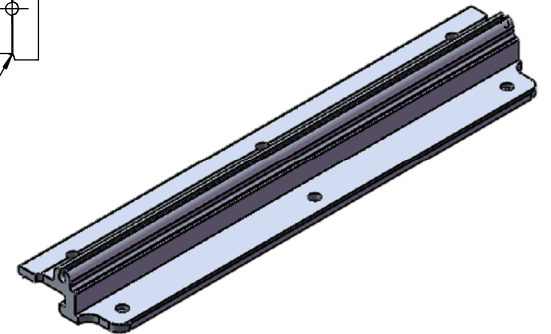
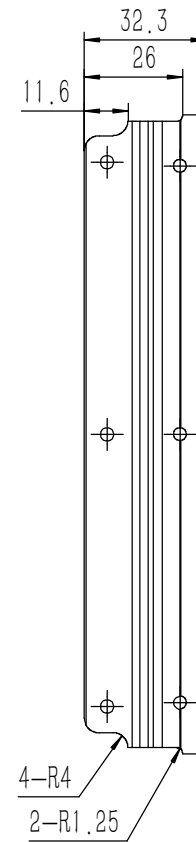
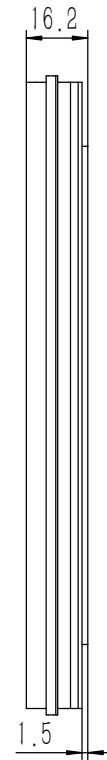
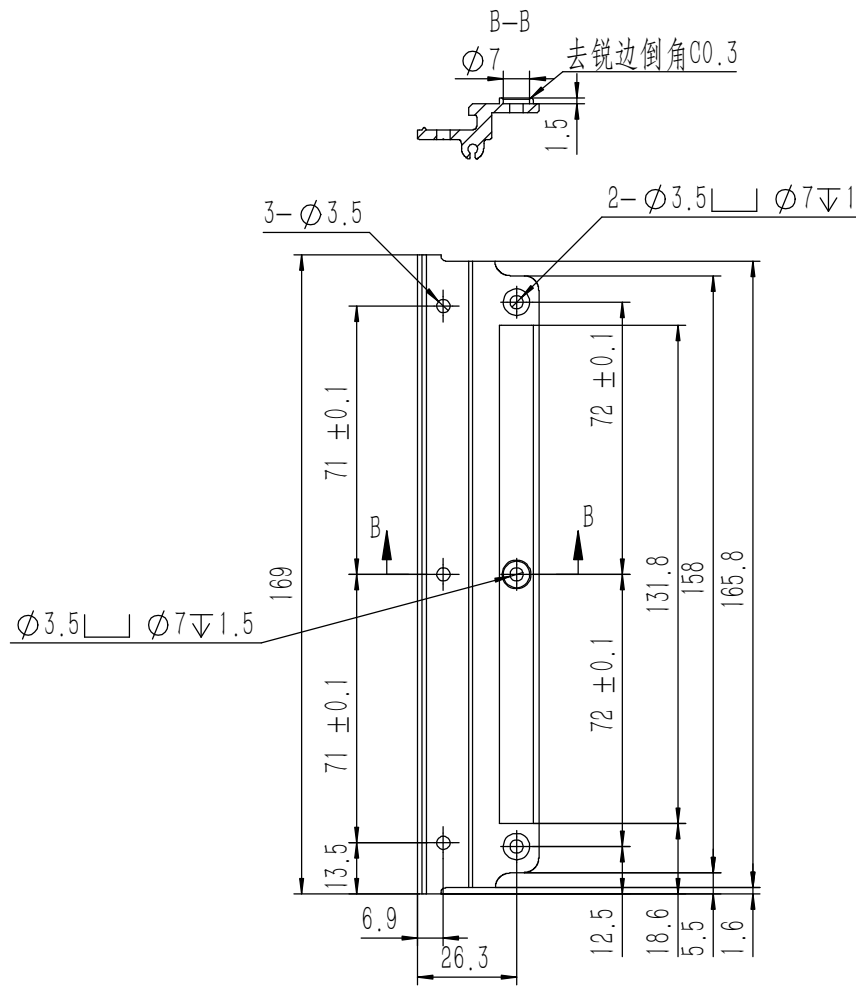
22	DIN-9250-S-NL-M3	不锈钢防松垫圈	SUS 304	12	0.000	
21	YG-TY-A13-011	A垫板	5052-H32	1	0.594	
20	YG-TY-A05-001	A包角1	6063-T5	4	0.043	
19	GB-T-70.3-2000-C-NI-M3X6	芳生镀白镍内六角沉头螺丝M3X6	普通碳钢	16	0.0004	
18	YG-TY-A07-004	后防护条-4U	5052-H32	2	0.072	
17	YG-TY-A11-003	面板下固定件3	电解板	2	0.067	
16	YG-TY-XJD-001	橡胶垫11X35	硅橡胶	8	0.0013	
15	GB-T-973-1976-C-NI-M3X12	碳钢镀镍十字大扁头螺丝M3X12	普通碳钢	16	0.001	
14	YG-TY-A09-004	侧板连接件	电解板	6	0.044	
13	YG-TY-A03-004	组合侧板	6063-T5	6	0.369	
12	BSO-M3-5-ZI-D5.4	压铆螺母 M3X5	普通碳钢	10	0.001	
11	YG-TY-A04-004	组合侧板	6063-T5	2	0.193	
10	YG-TY-A05-002	A包角2	6063-T5	4	0.043	
9	YG-TY-A01-011	上下盖板	5052-H32	1	1.081	
8	YG-TY-A12-012	前后面板-4U	5052-H32	2	1.156	
7	YG-TY-A06-004	拉手-4U	6063-T5	2	0.145	
6	YG-TY-A10-003	面板上固定件3	电解板	2	0.061	
5	YG-TY-A02-011	上盖板	5052-H32	1	1.043	
4	S-M3-1-ZI	压铆螺母镀白锌M3X1	普通碳钢	8	0.3750	
3	GB-T-973-1976-C-NI-M3X4	碳钢镀镍十字大扁头螺丝M3X4	普通碳钢	54	0.0005	
2	YG-TY-A08-004	A侧板固定件 4U	6063-T5	4	0.065	
1	GB-T-973-1976-C-NI-M3X6	碳钢镀镍十字大扁头螺丝M3X6	普通碳钢	24	0.0006	
序号	图号	名称	材料	数量	单重	备注

#### 技术要求:

- 1、必须按照设计、工艺要求及本规定和有关标准进行装配;
- 2、所有零部件(包括外购、外协件)必须具有检验合格证方能进行装配;
- 3、零件在装配前必须清理和清洗干净,不得有毛刺、飞边、氧化皮、锈蚀、切屑、砂粒、灰尘和油污等,并应符合相应清洁度要求;
- 4、装配过程中零件不得磕碰、划伤和锈蚀;
- 5、油漆未干的零件不得进行装配;
- 6、相对运动的零件,装配时接触面间应加润滑油脂;
- 7、各零、部件装配后相对位置应准确。

Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°
Position tolerances (未注位置公差): ± 0.05	

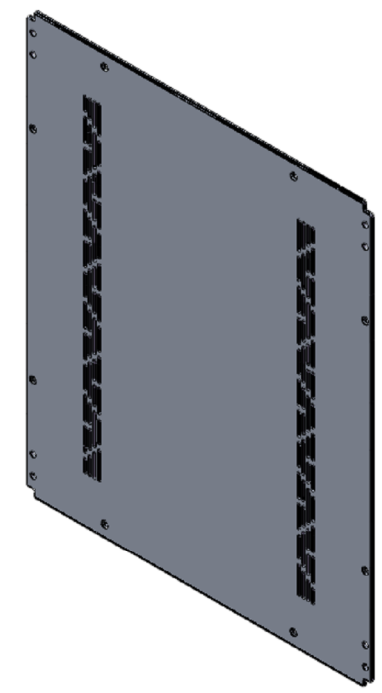
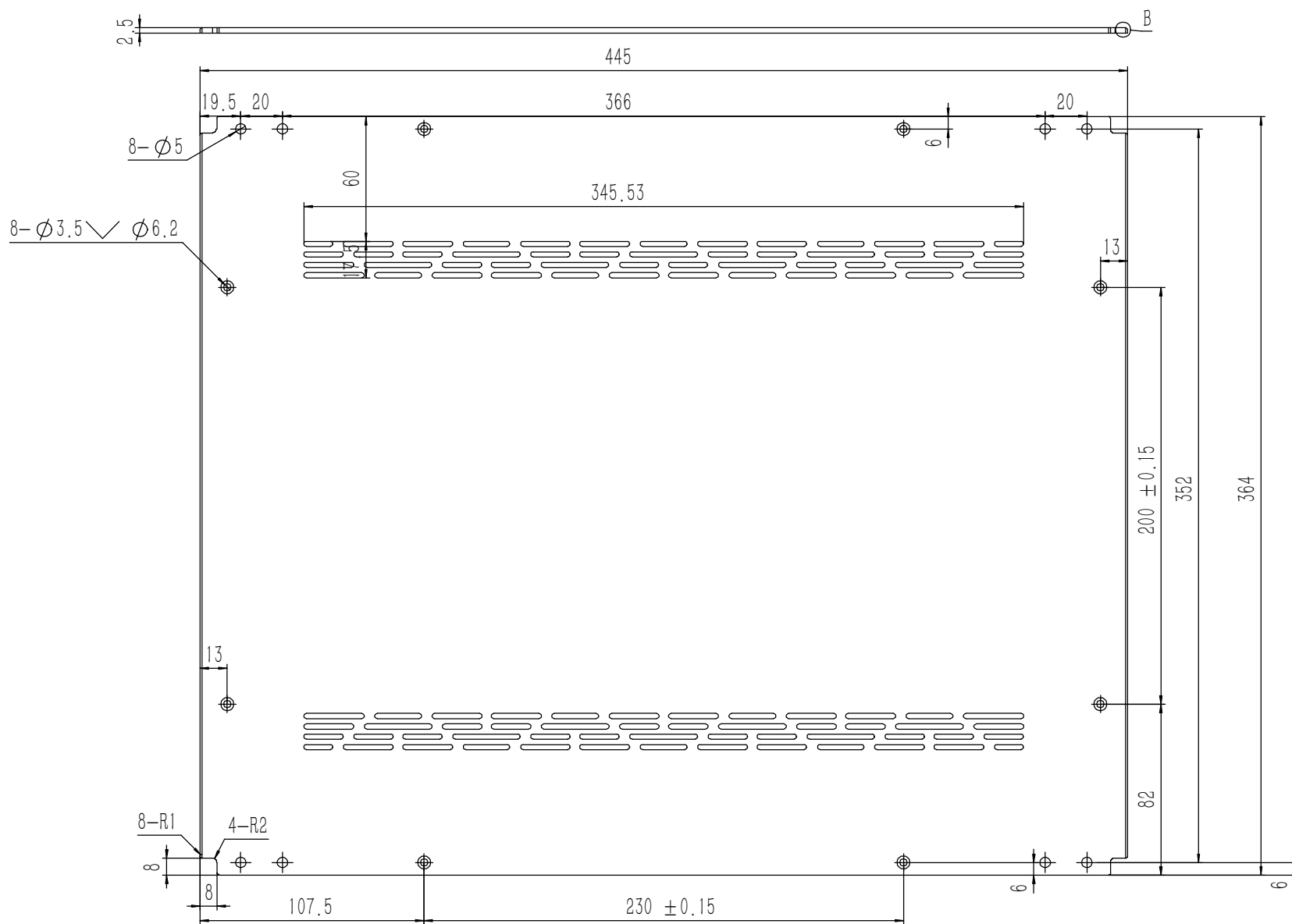
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): (装配图)	
Weight: (重量) (Kg): 9.275	Weight: (重量) (Kg): 9.275	
Protection: (表面处理):	Protection: (表面处理):	
Part Name (零/部件名称):	Part Name (零/部件名称): A12机箱	Drawing Number (图号): YG-A12-1000-000
Drawn by (绘图): 邓展锋	Date (日期): 2020.05.22	Size (图幅): A0
Check by (校对):	Date (日期):	Scale (比例): 1:1.5
Signature by (批准):	Date (日期):	Revision (版本): A1
		Sheet (页数): 1 / 1



技术要求:

- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
- 2、去除毛刺飞边,锐角倒钝;
- 3、未标注尺寸见3D数模。

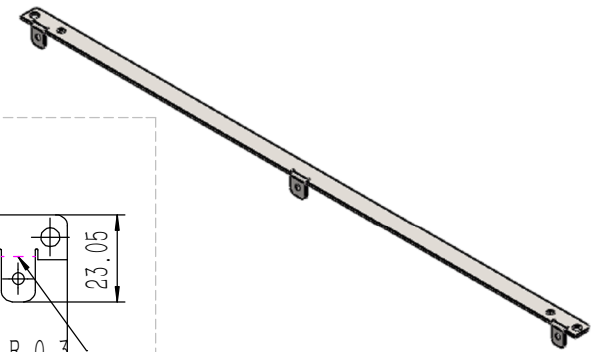
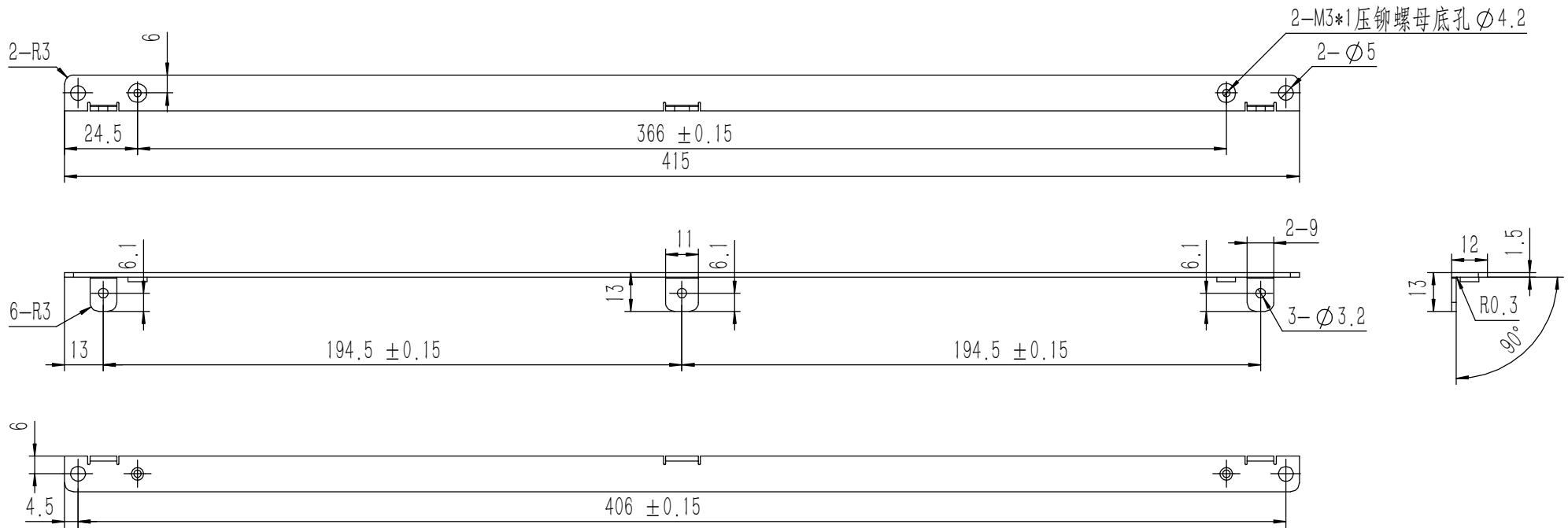
Tolerances (未注公差): 0.5 to 6 $\pm 0.1$ 6 to 30 $\pm 0.2$ 30 to 120 $\pm 0.3$ 120 to 400 $\pm 0.4$	Material (材料):	6063-T5	<b>YONGU</b> 永固
	Weight: (重量) (Kg):	0.065	
	Protection: (表面处理):		
	Part Name (零/部件名称):	A侧板固定件 4U	
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Angular tolerances (未注角度公差): $<6^\circ$ $\pm 10'$ $<30^\circ$ $\pm 20'$ $<120^\circ$ $\pm 30'$ $>120^\circ$ $\pm 1^\circ$	Drawing Number (图号): YG-TY-A08-004	Size: (图幅): A2
Position tolerances (未注位置公差): $\pm 0.05$	Drawn by (绘图): 邓展锋	Date (日期): 2020.05.18	Scale (比例): 1:1
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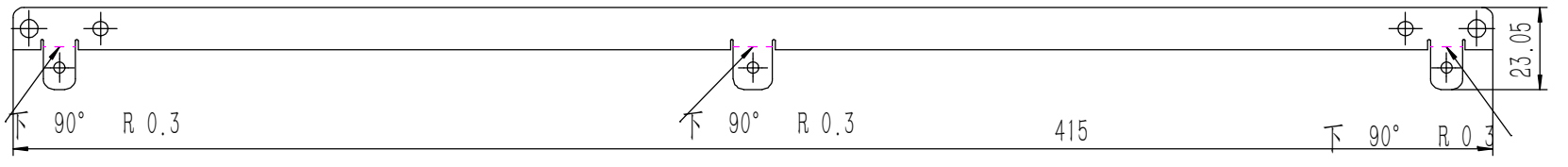
- 技术要求:
- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
  - 2、去除毛刺飞边, 锐角倒钝;
  - 3、未标注尺寸见3D数模。

Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料):	5052-H32	
	Weight: (重量) (Kg):	1.043	
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):		
	Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Part Name (零/部件名称):	上盖板
Position tolerances (未注位置公差): ± 0.05	Part Name (零/部件名称):	上盖板	
	Position tolerances (未注位置公差): ± 0.05	Signature by (绘图): 莫永康	Date (日期): 2020.05.18
		Signature by (校对):	Date (日期):
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**YONGU** 永固



钣金展开及折弯方向参考图 (视图比例1:1)

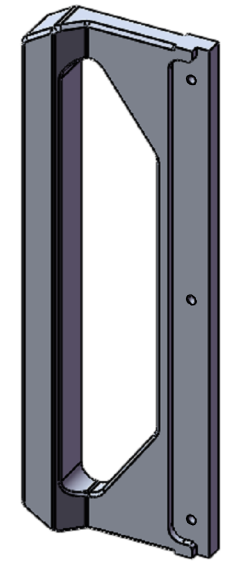
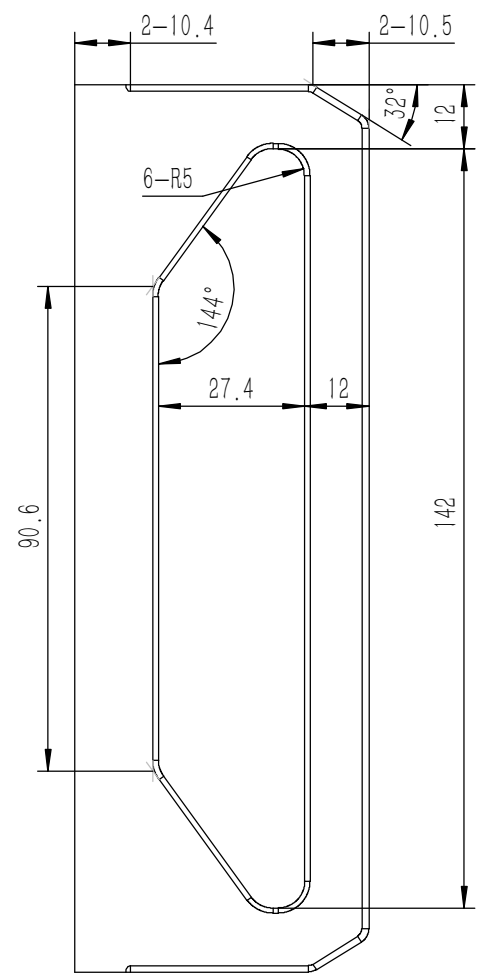
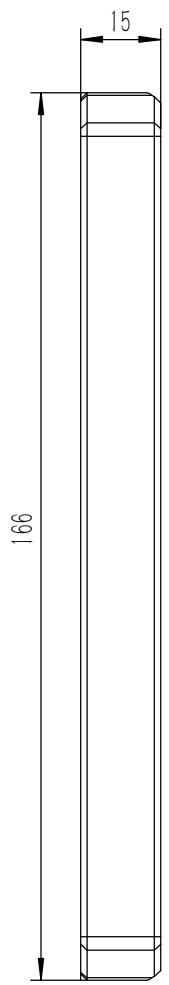
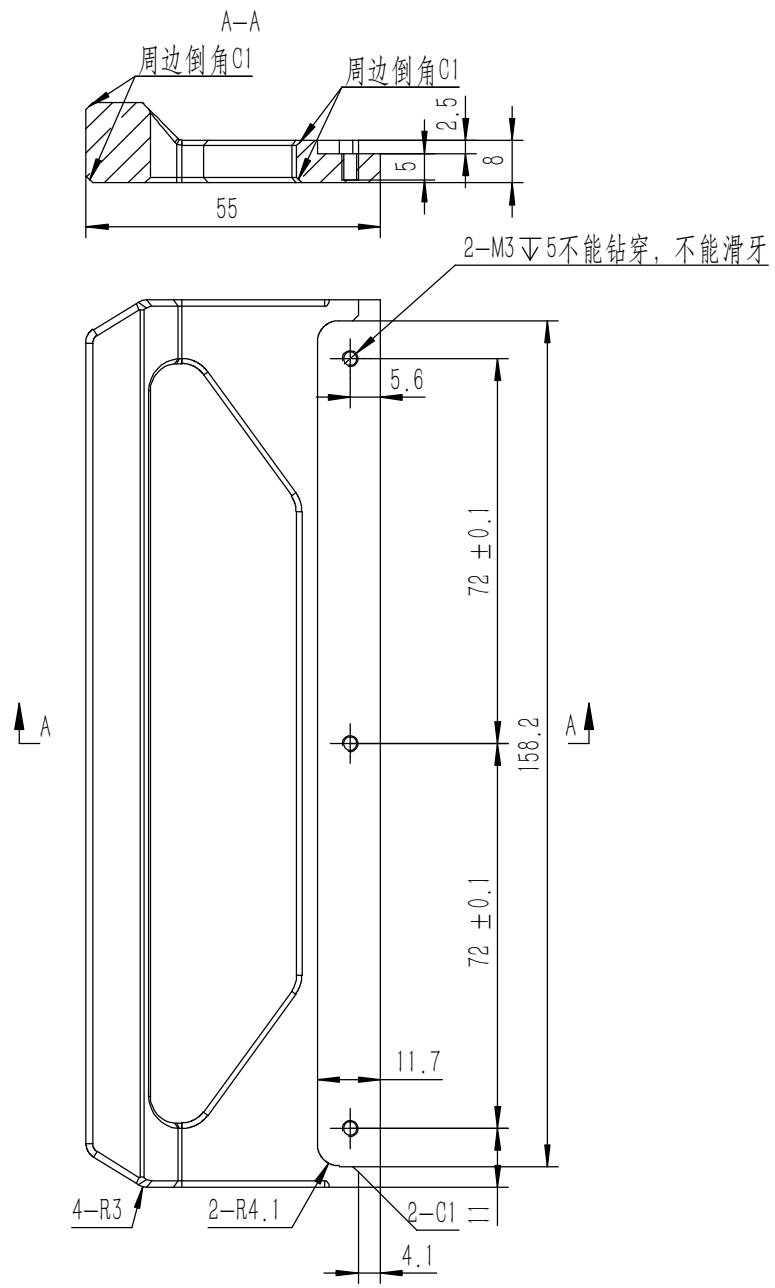


业务代码:

技术要求:

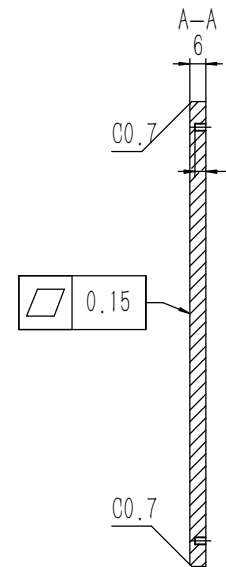
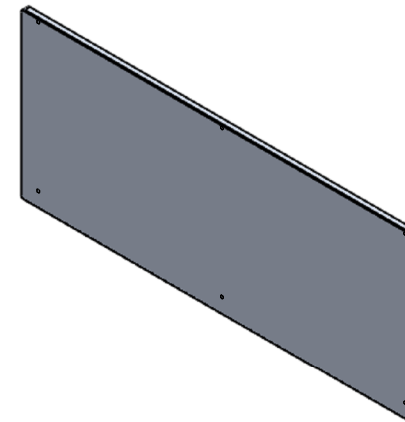
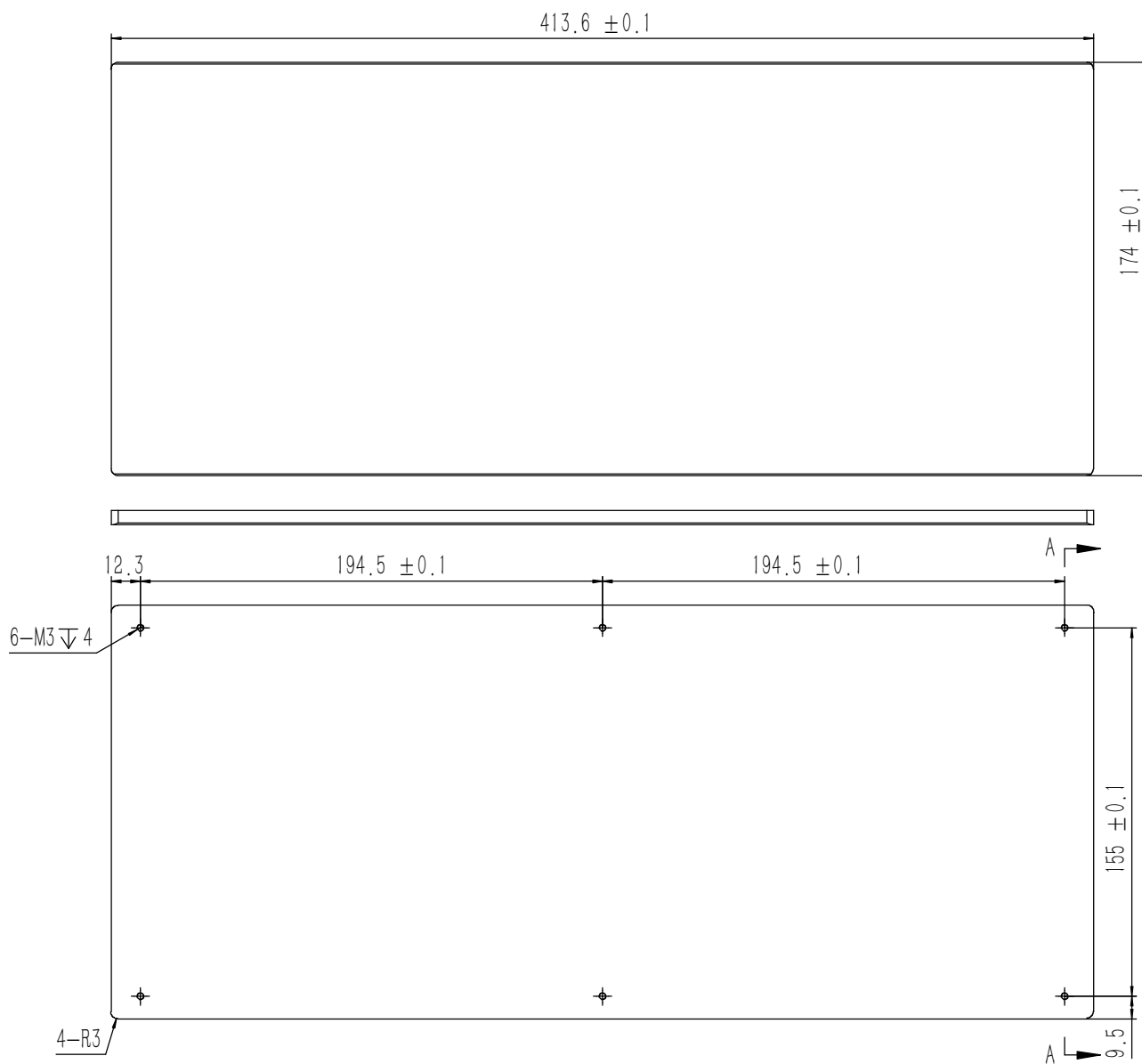
- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
- 2、去除毛刺飞边,锐角倒钝;
- 3、未标注尺寸见3D数模。

Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): 电解板	YONGU 永固	Drawing Number (图号): YG-TY-A10-003	
	Weight: (重量) (Kg): 0.061		Size: (图幅): A2	
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理): 毛坯	面板上固定件3	Sheet (页数): 1 / 1	
	Part Name (零/部件名称):		Revision (版本): A1	
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Drawn by (绘图): 许宏彬	Date (日期): 2020.09.18	Signature by (批准):	
Position tolerances (未注位置公差): ±0.05	Check by (校对):	Date (日期):	Date (日期):	



技术要求:  
 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;  
 2、去除毛刺飞边,锐角倒钝;  
 3、未标注尺寸见3D数模。

Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料):	6063-T5	<b>YONGU</b> 永固
	Weight: (重量) (Kg)	0.145	
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):		Part Name (零/部件名称): <b>拉手-4U</b>
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Part Name (零/部件名称):		
Position tolerances (未注位置公差): ±0.05	Drawn by (绘图): 邓展锋	Date (日期): 2020.05.18	Size (图幅): A3
	Check by (校对):	Date (日期):	Scale (比例): 1:1
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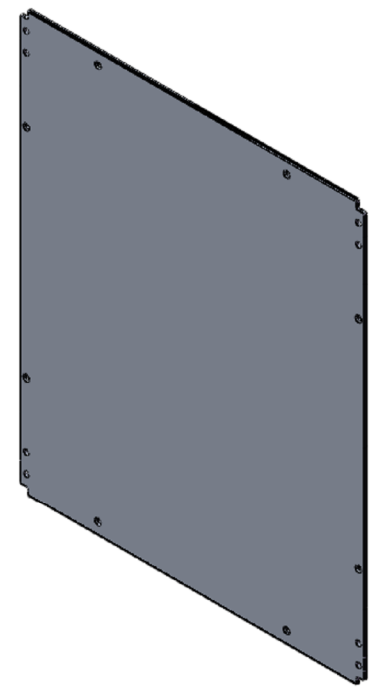
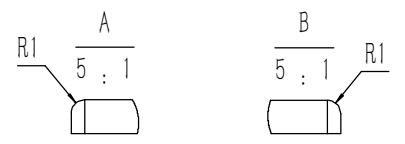
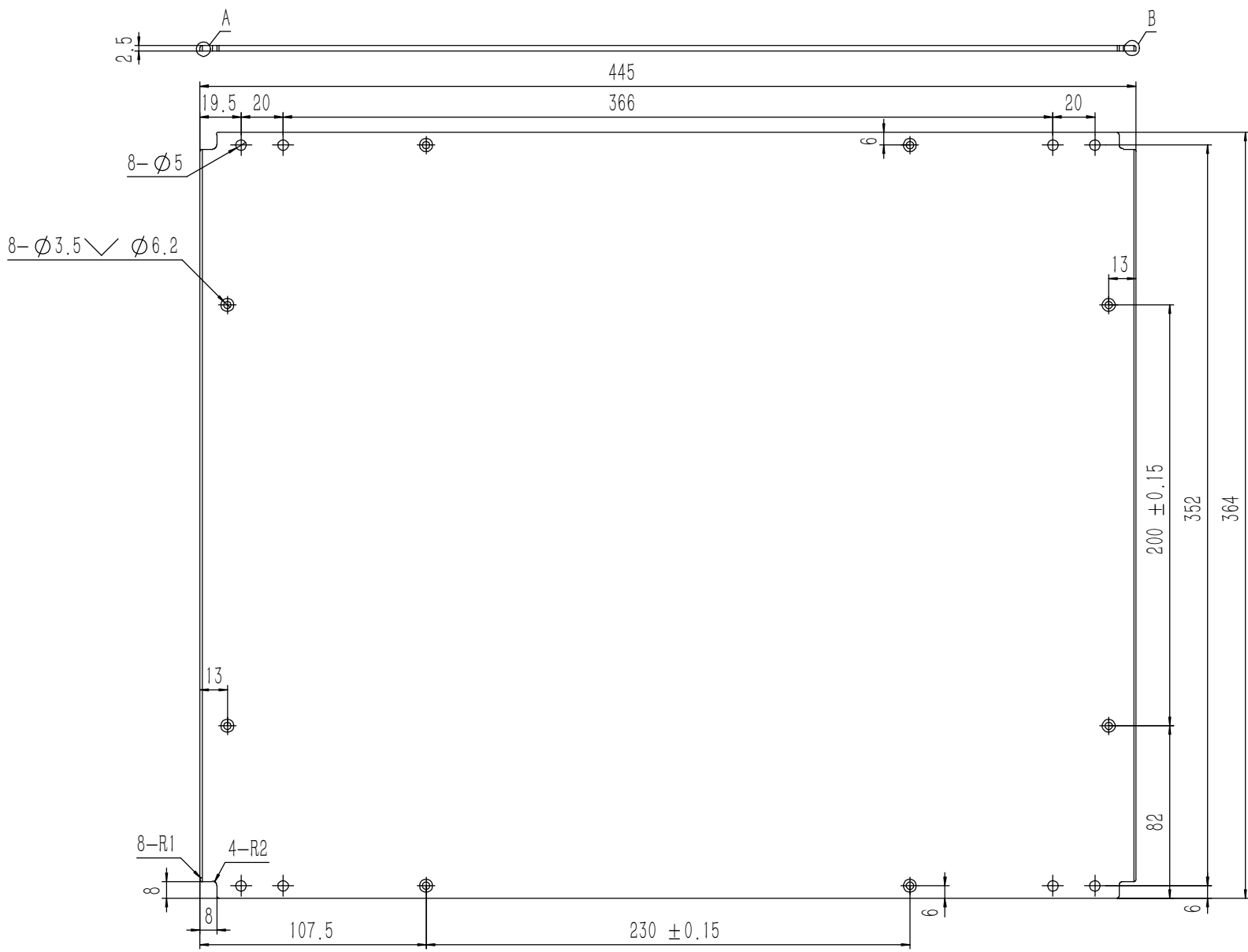


技术要求:

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- 3、未标注尺寸见3D数模。

Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): 5052-H32	Weight: (重量) (Kg): 1.156	Protection: (表面处理):	Part Name (零/部件名称): 前后面板-4U		Drawing Number (图号): YG-TY-A12-012	
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Drawn by (绘图): 莫永康		Date (日期): 2020.05.18		Size: (图幅): A1		Sheet (页数): 1 / 1	
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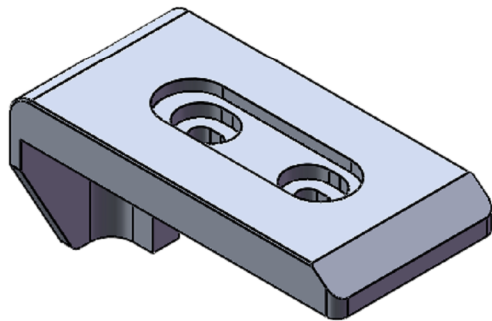
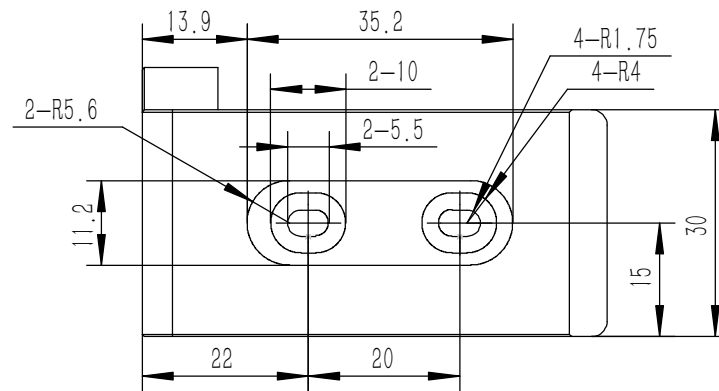
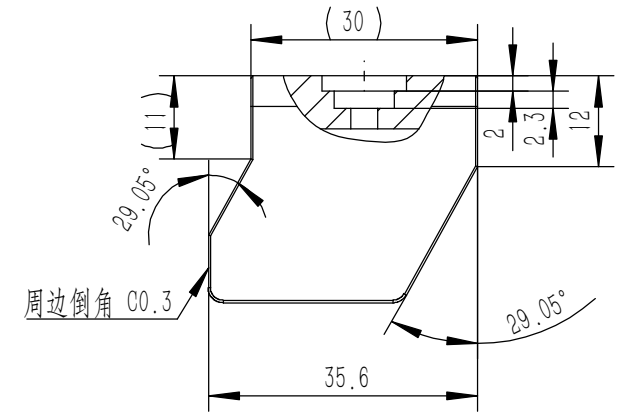
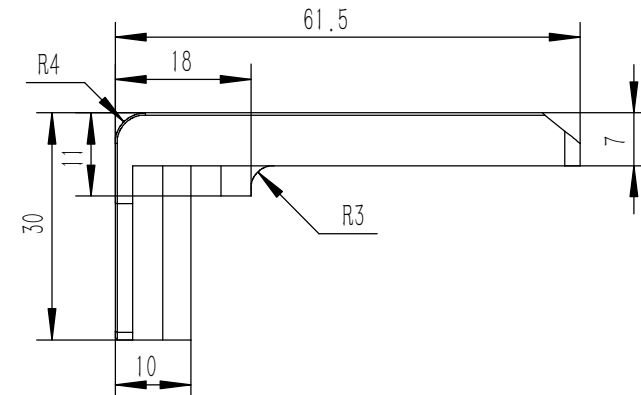
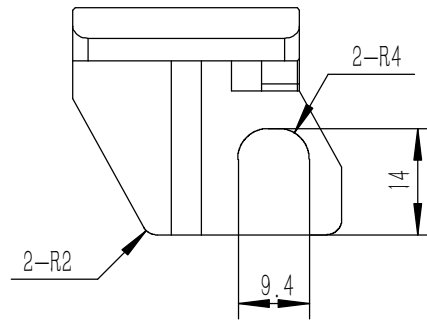
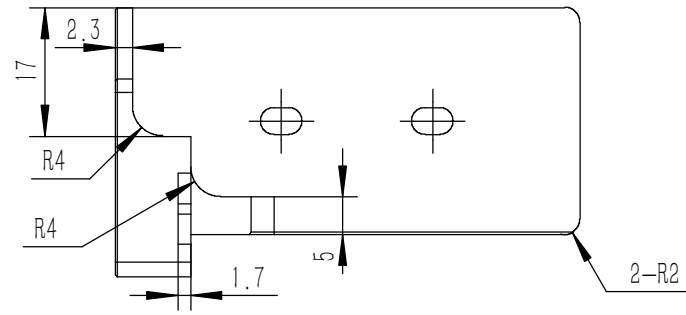




技术要求:  
 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;  
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 3、未标注尺寸见3D数模。

Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料):	5052-H32	
	Weight: (重量) (Kg):	1.081	
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):		
	Part Name (零/部件名称):	上下盖板	
Position tolerances (未注位置公差): ±0.05	Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Part Name (零/部件名称):	Drawing Number (图号):
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		Revision (版本): A1	



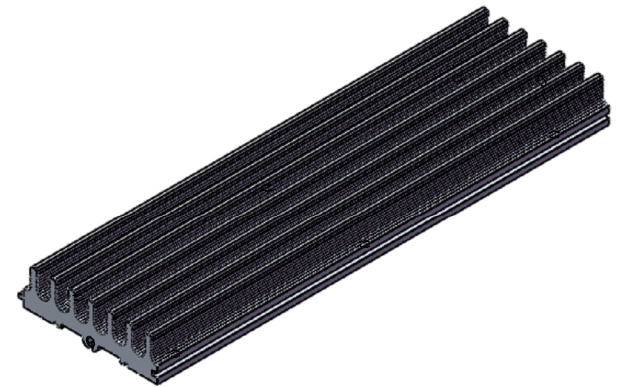
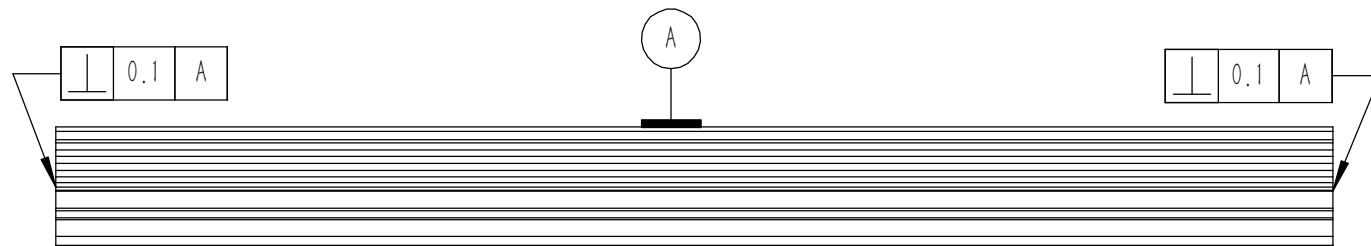
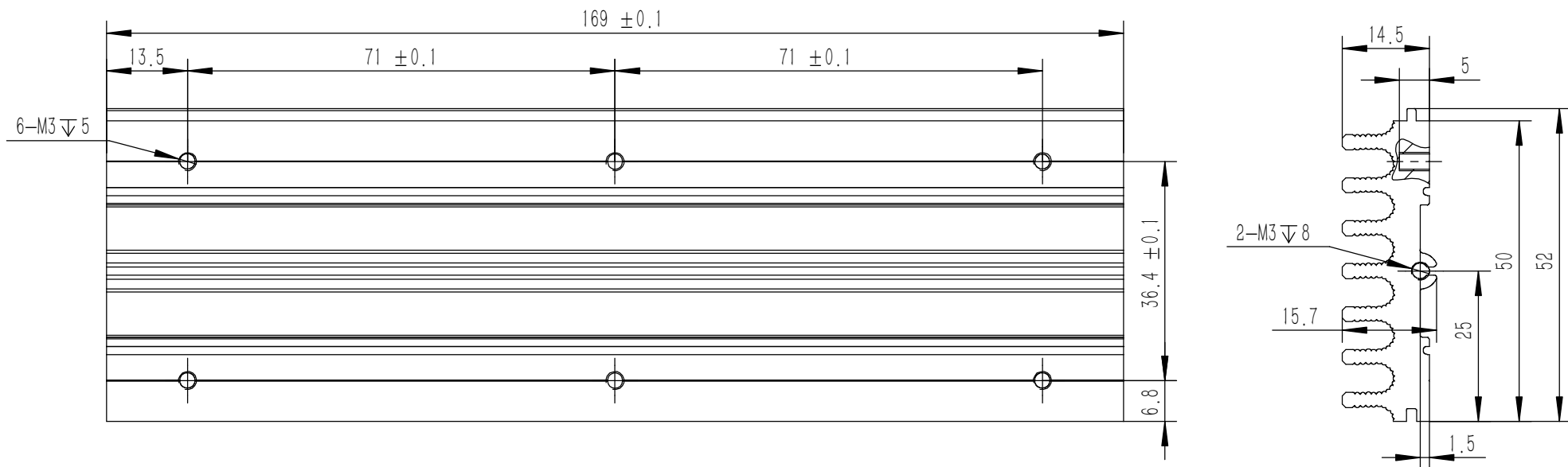


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  - 3、未标注尺寸见3D数模。

Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料):	6063-T5	
	Weight: (重量) (Kg)	0.043	
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45° Position tolerances (未注位置公差): ±0.05	Protection: (表面处理):		
	Part Name (零/部件名称):	A包角2	
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Part Name (零/部件名称):	A包角2	
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	Check by (校对):	Date (日期):	Scale (比例): 1:1
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**YONGU** 永固

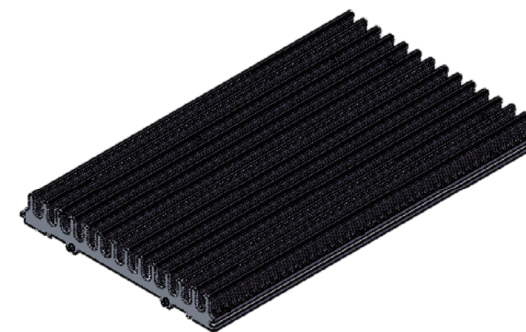
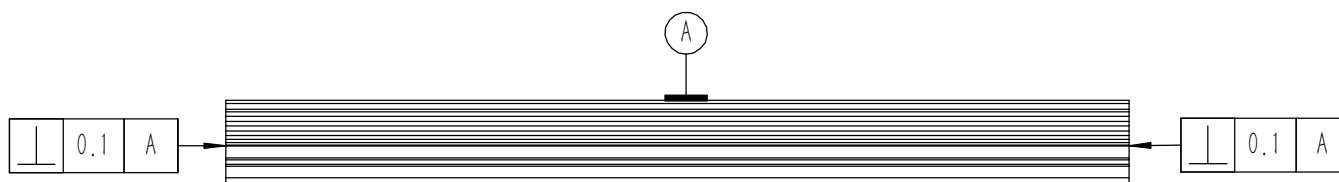
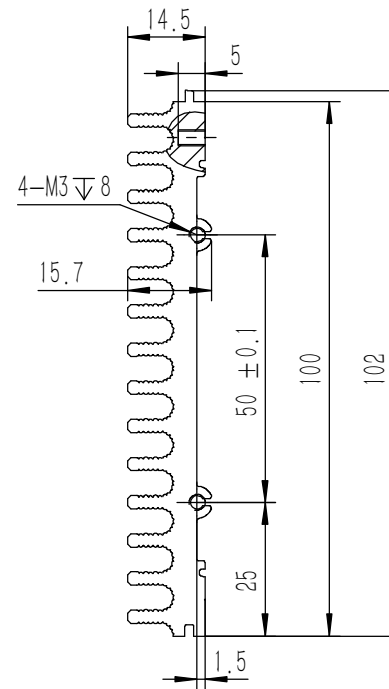
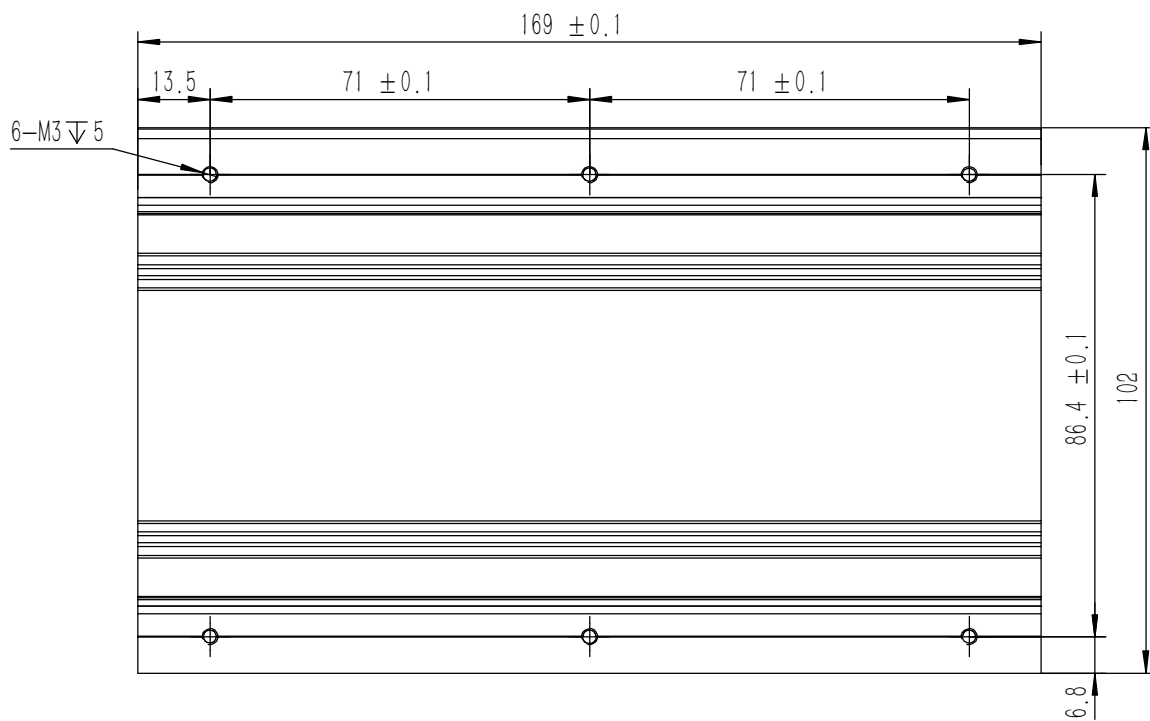




技术要求:

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- 3、未标注尺寸见3D数模。

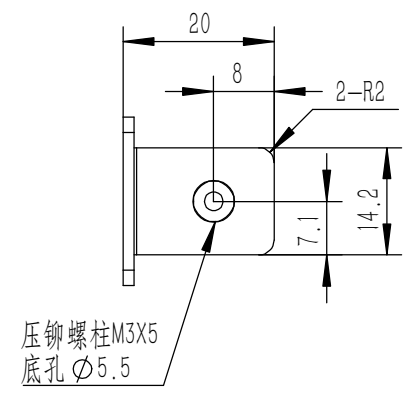
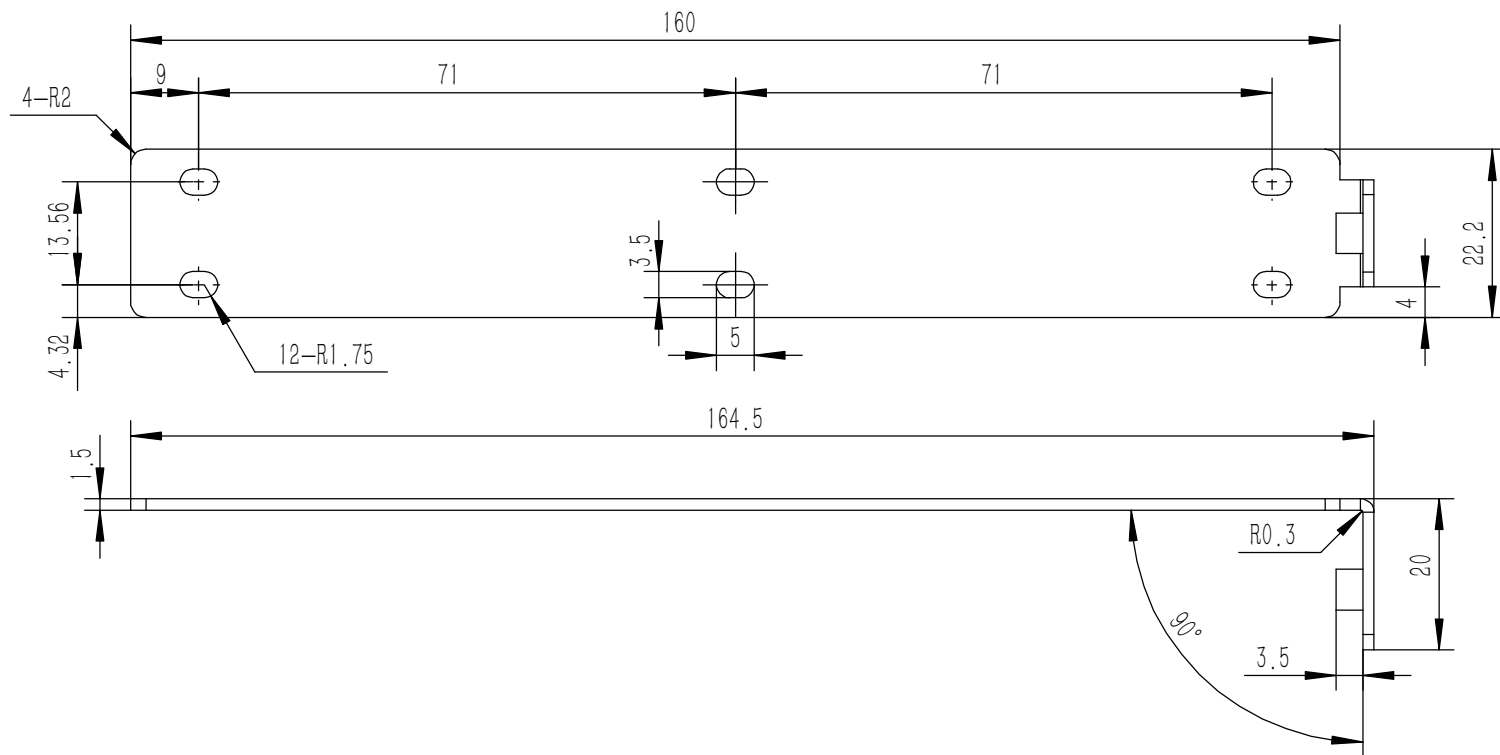
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): 6063-T5	<b>YONGU</b> 永固		
	Weight: (重量) (Kg) 0.193			
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):	Part Name (零/部件名称): 组合侧板		
	Position tolerances (未注位置公差): ±0.05	Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Signature by (批准):	Drawing Number (图号): YG-TY-A04-004
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	Weight: (重量) (Kg) 0.193	Check by (校对):	Date (日期):	Scale (比例): 1:1
	Protection: (表面处理):	Signature by (批准):	Date (日期):	Revision (版本): A1
	Part Name (零/部件名称): 组合侧板	Drawing Number (图号): YG-TY-A04-004		Sheet (页数): 1 / 1



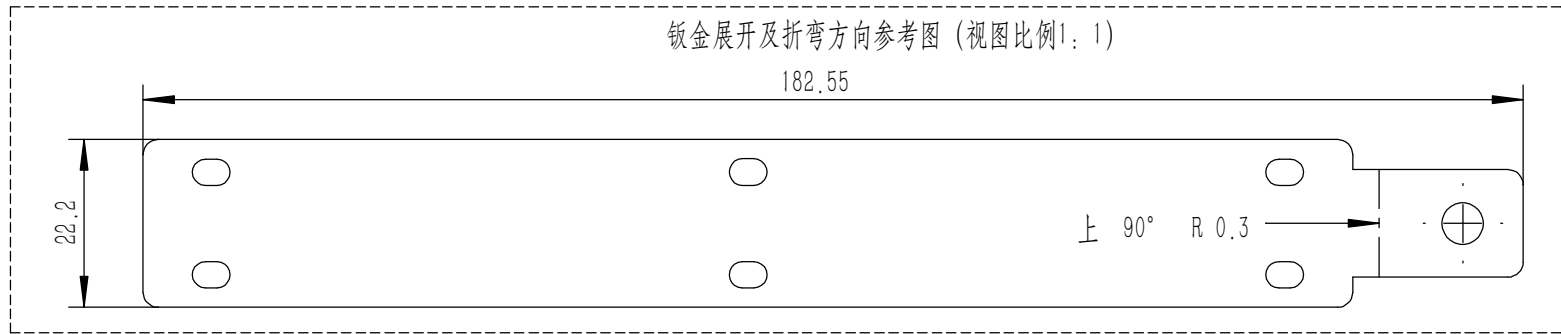
技术要求:

- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
- 2、去除毛刺飞边,锐角倒钝;
- 3、未标注尺寸见3D数模。


Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料):	6063-T5		<b>YONGU</b> 永固
	Weight: (重量) (Kg)	0.369		
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):	Part Name (零/部件名称):		Drawing Number (图号):
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	组合侧板		YG-TY-A03-004	
Position tolerances (未注位置公差): ±0.05	Drawn by (绘图): 莫永康	Date (日期): 2020.05.15	Size (图幅): A3	Sheet (页数): 1 / 1
	Check by (校对):	Date (日期):	Scale (比例): 1:1	
	Signature by (批准):	Date (日期):	Revision (版本): A1	

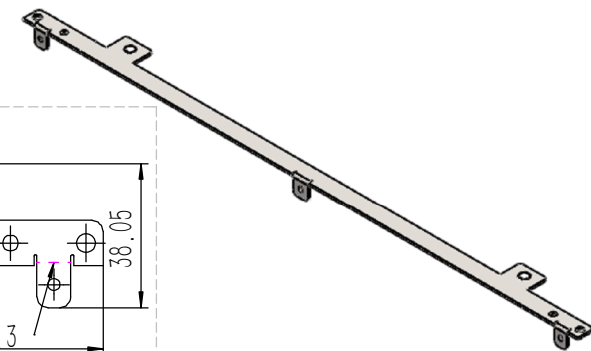
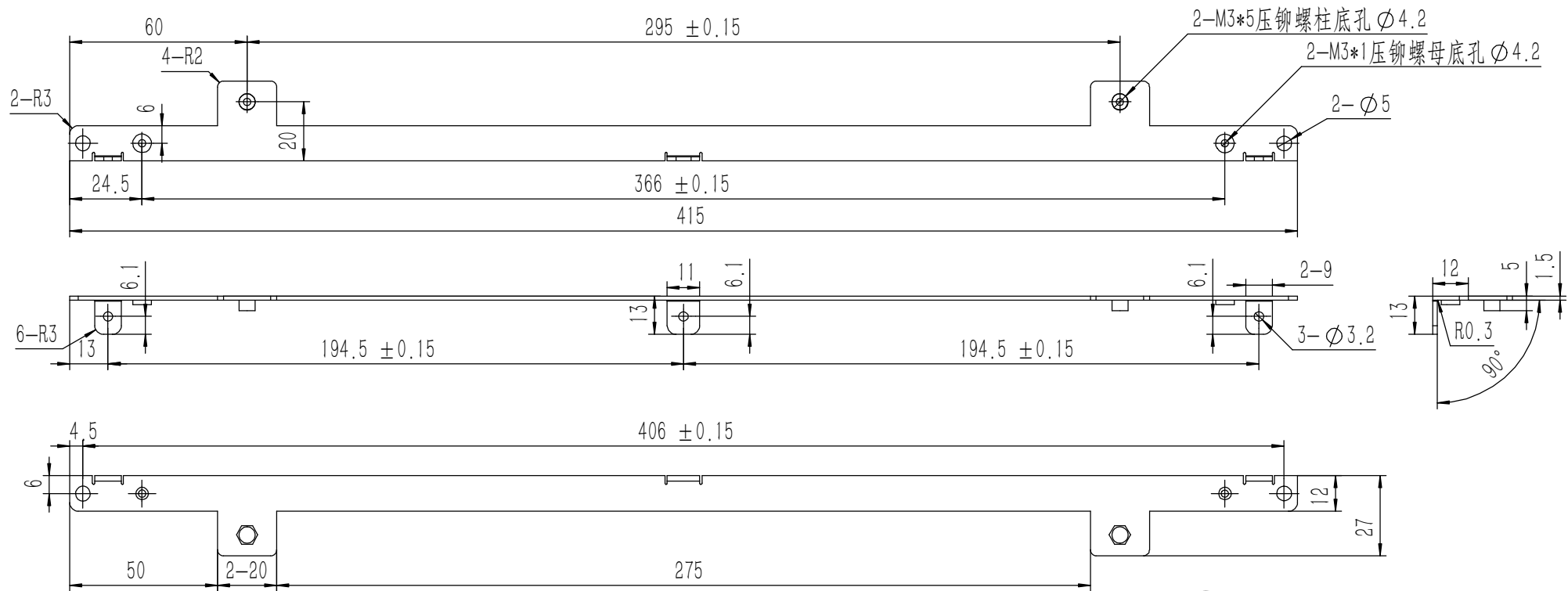


钣金展开及折弯方向参考图 (视图比例1:1)

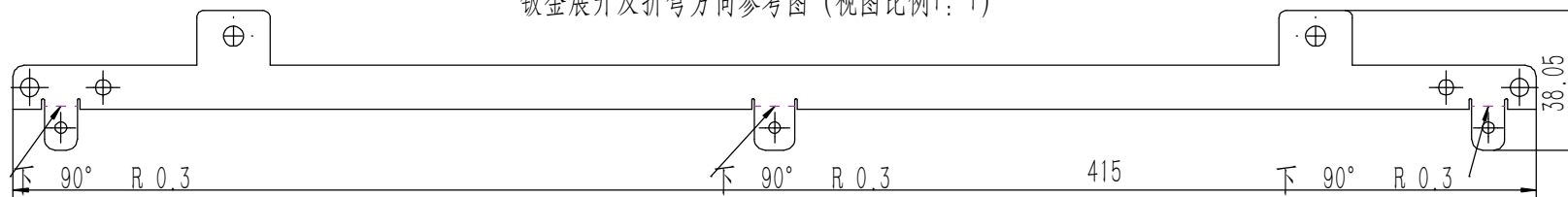


技术要求:  
 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;  
 2、去除毛刺飞边,锐角倒钝;  
 3、未标注尺寸见3D数模。

Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): 电解板		
	Weight: (重量) (Kg) 0.045		
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):	Part Name (零/部件名称): 侧板连接件 4U	
	Position tolerances (未注位置公差): ±0.05	Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Part Name (零/部件名称): 侧板连接件 4U
	Material (材料): 电解板	Drawing Number (图号): YG-TY-A09-004	
	Weight: (重量) (Kg) 0.045	Scale (图幅): A4	
	Protection: (表面处理):	Scale (比例): 1:1	
	Part Name (零/部件名称): 侧板连接件 4U	Revision (版本): A1	
	Drawn by (绘图): 莫永康	Date (日期): 2020.05.19	
	Check by (校对):	Date (日期):	
	Signature by (批准):	Date (日期):	
		Sheet (页数): 1 / 1	



钣金展开及折弯方向参考图 (视图比例1:1)

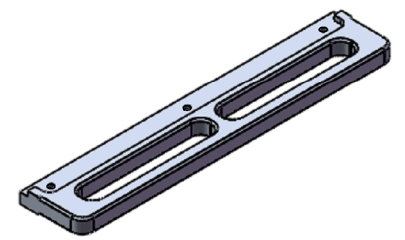
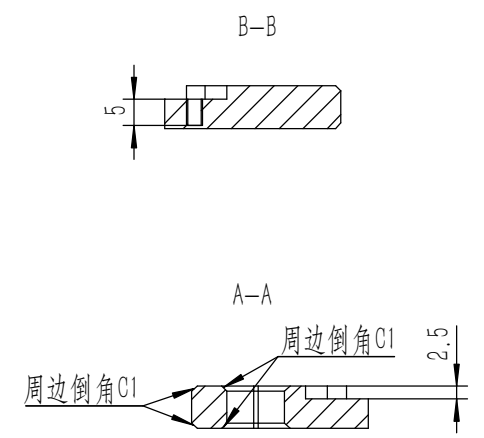
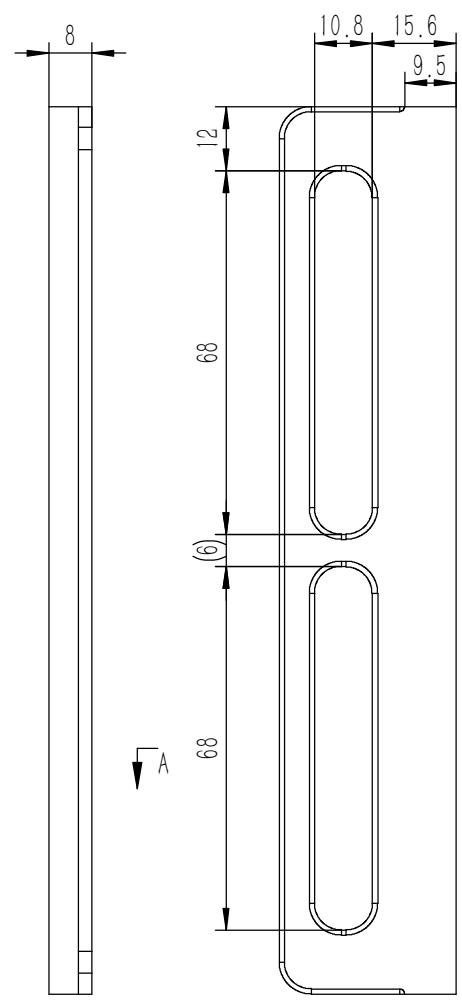
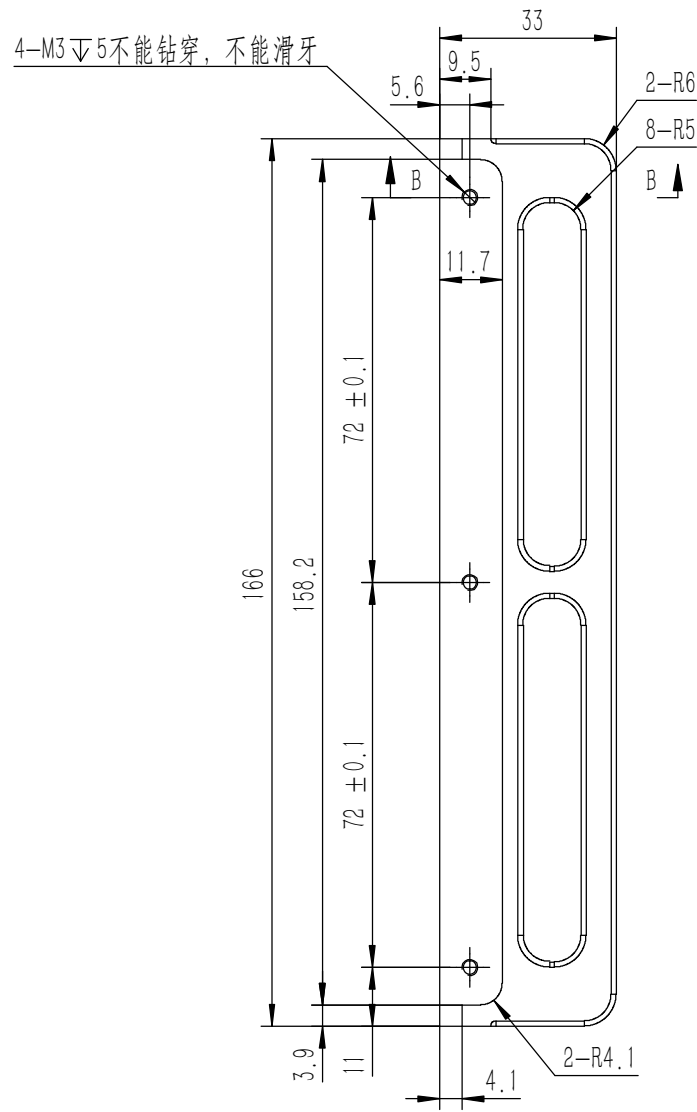


业务代码:

技术要求:

- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
- 2、去除毛刺飞边, 锐角倒钝;
- 3、未标注尺寸见3D数模。

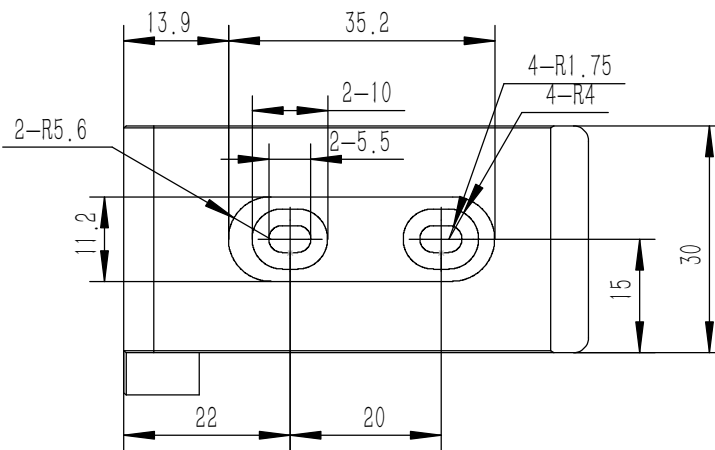
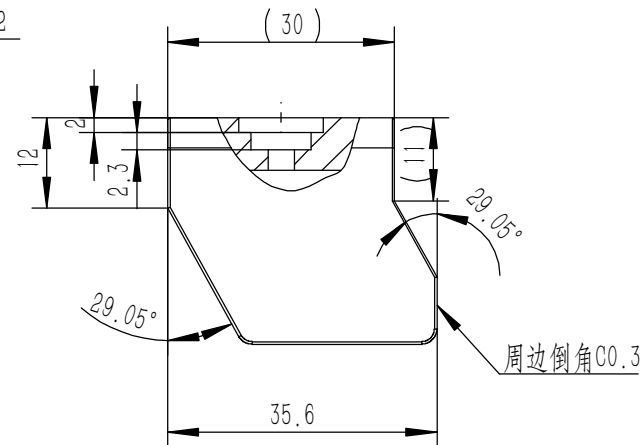
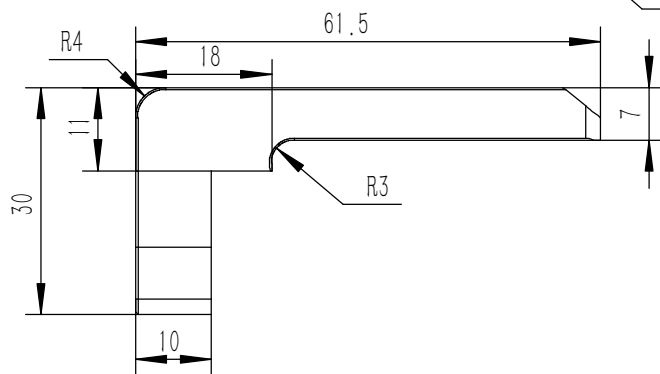
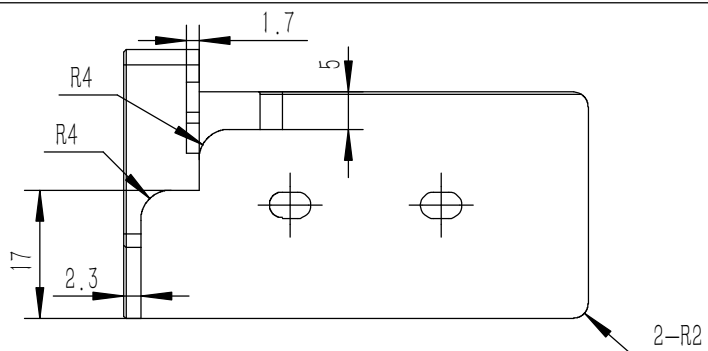
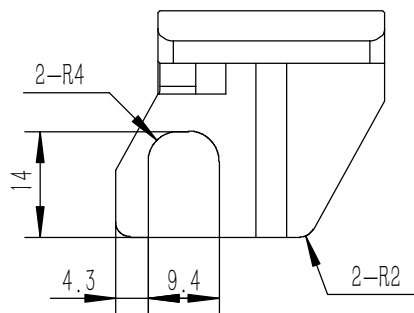
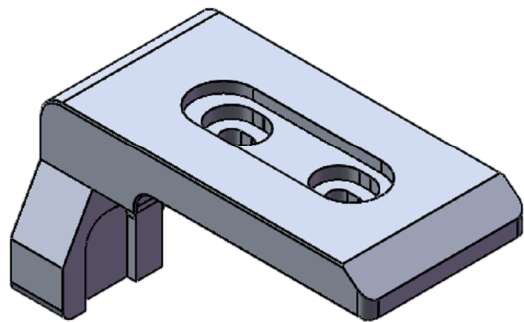
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): (装配图)	YONGU 永固	Drawing Number (图号): YG-TY-A11-003		
	Weight: (重量) (Kg): 0.069				
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理): 毛坯	Part Name (零/部件名称): 面板下固定件3	Size: (图幅): A2		
Position tolerances (未注位置公差): ±0.05	Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°			Drawn by (绘图): 许宏彬	Date (日期): 2020.09.18
		Check by (校对):	Date (日期):	Scale (比例): 1:1	Sheet (页数): 1 / 1
		Signature by (批准):	Date (日期):	Revision (版本): A1	



技术要求：  
 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷；  
 2、去除毛刺飞边，锐角倒钝；  
 3、未标注尺寸见3D数模。

Tolerances (未注公差): 0.5 to 6 $\pm$ 0.1 6 to 30 $\pm$ 0.2 30 to 120 $\pm$ 0.3 120 to 400 $\pm$ 0.4	Material (材料):	5052-H32	
	Weight: (重量) (Kg)	0.072	
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):		
	Part Name (零/部件名称):	后防护条-4U	
Angular tolerances (未注角度公差): <6° $\pm$ 10' <30° $\pm$ 20' <120° $\pm$ 30' >120° $\pm$ 1°	Position tolerances (未注位置公差): $\pm$ 0.05	Part Name (零/部件名称):	后防护条-4U
	Drawing Number (图号):	YG-TY-A07-004	
Drawn by (绘图): 邓展锋	Date (日期): 2020.05.18	Size (图幅): A3	Sheet (页数): 1 / 1
Check by (校对):	Date (日期):	Scale (比例): 1:1	
Signature by (批准):	Date (日期):	Revision (版本): A1	

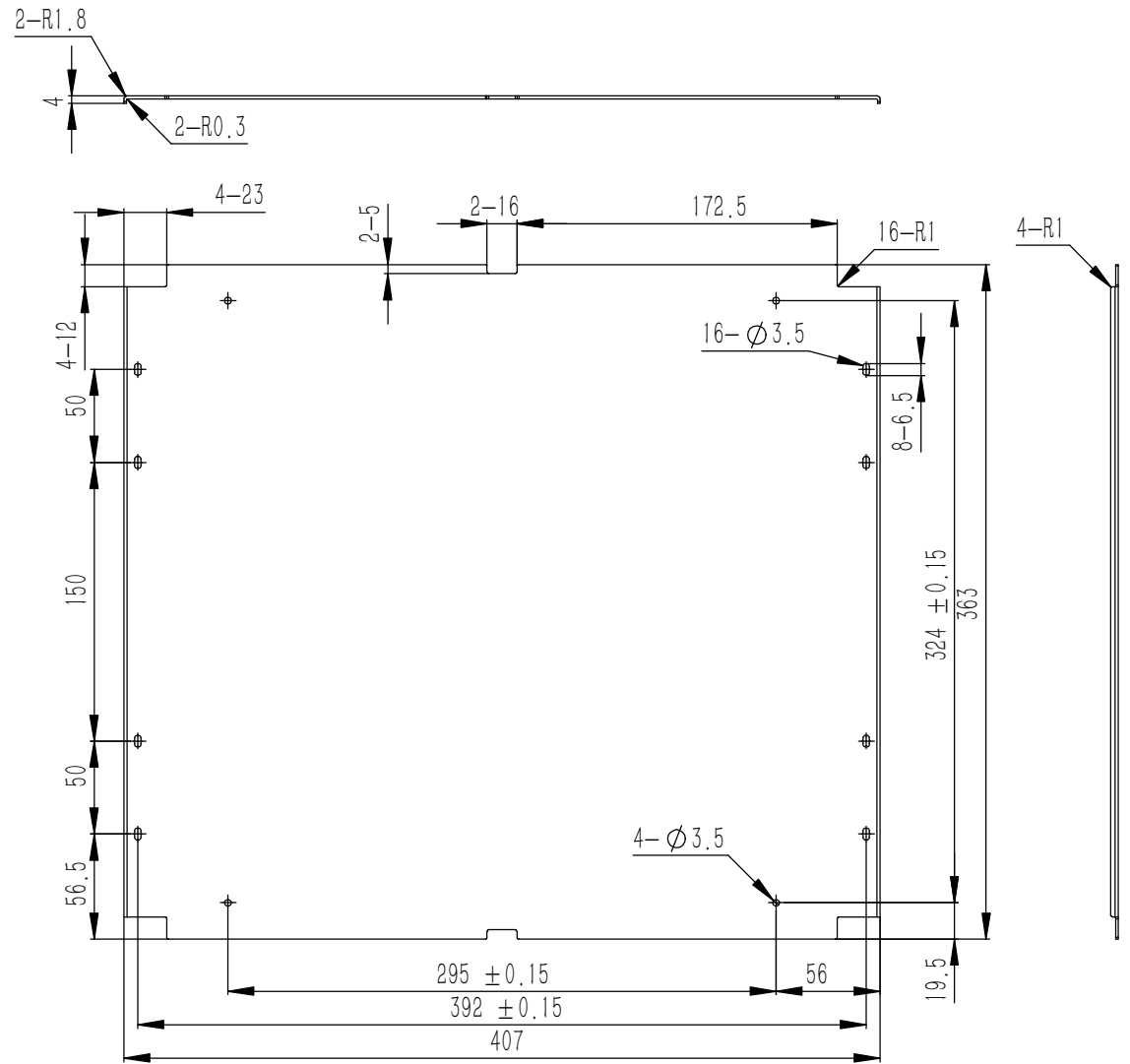
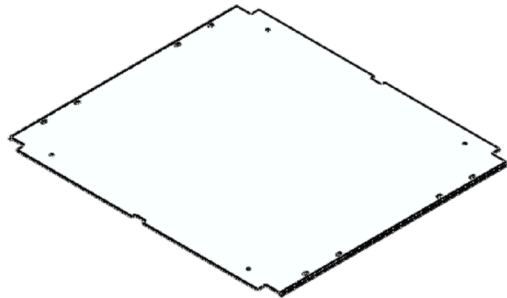
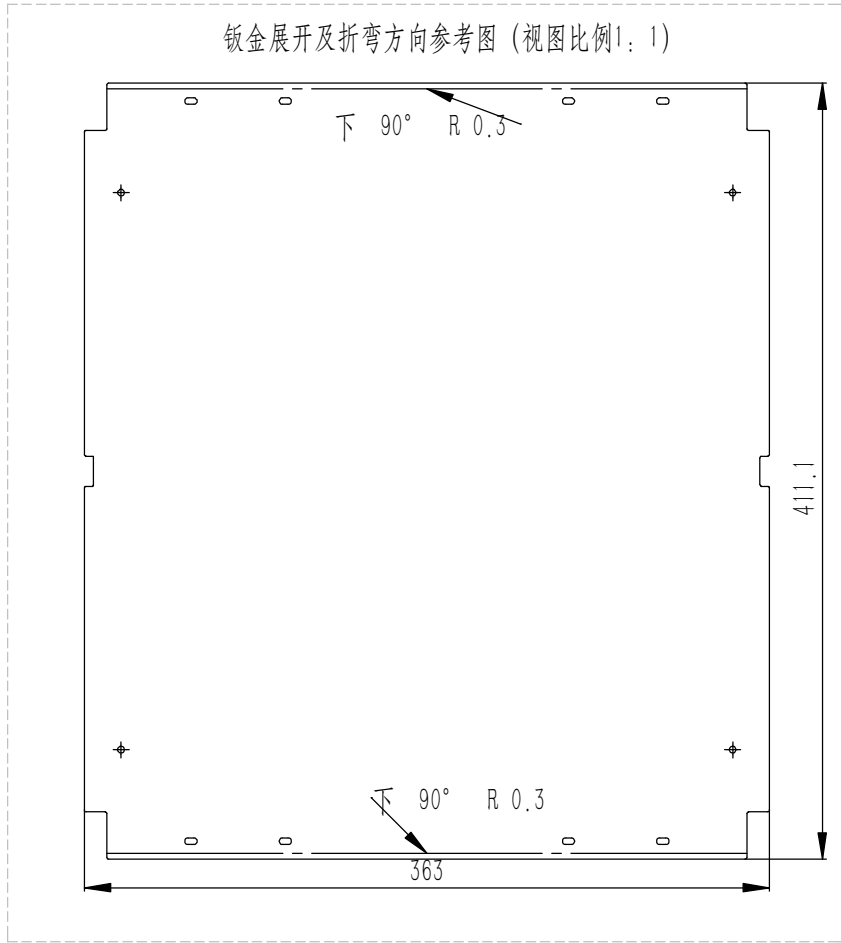




- 技术要求:
- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
  - 2、去除毛刺飞边, 锐角倒钝;
  - 3、未标注尺寸见3D数模。

Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): 6063-T5	<b>YONGU</b> 永固	
	Weight: (重量) (Kg) 0.043		
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):	Part Name (零/部件名称): A包角1	
	Position tolerances (未注位置公差): ±0.05	Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Part Name (零/部件名称): A包角1
	Material (材料): 6063-T5	Drawing Number (图号): YG-TY-A05-001	
	Weight: (重量) (Kg) 0.043	Drawn by (绘图): 莫永康	Date (日期): 2020.05.18
	Protection: (表面处理):	Check by (校对):	Date (日期):
	Part Name (零/部件名称): A包角1	Signature by (批准):	Date (日期):
		Scale (比例): 1:1	Sheet (页数): 1 / 1
		Revision (版本): A1	

钣金展开及折弯方向参考图 (视图比例1:1)



业务代码:

技术要求:

- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
- 2、去除毛刺飞边, 锐角倒钝;
- 3、未标注尺寸见3D数模。

Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°
Position tolerances (未注位置公差): ± 0.05	

Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): 5052-H32	<b>YONGU</b> 永固	Drawing Number (图号): YG-TY-A13-011		
Weight: (重量) (Kg): 0.594	Protection: (表面处理):		Size (图幅): A0	Sheet (页数): 1 / 1	
Part Name (零/部件名称): A垫板	Part Name (零/部件名称):		Scale (比例): 1:1	Revision (版本): A1	
Drawn by (绘图): 许宏彬	Date (日期): 2020.09.17	Check by (校对):	Date (日期):	Signature by (批准):	Date (日期):