

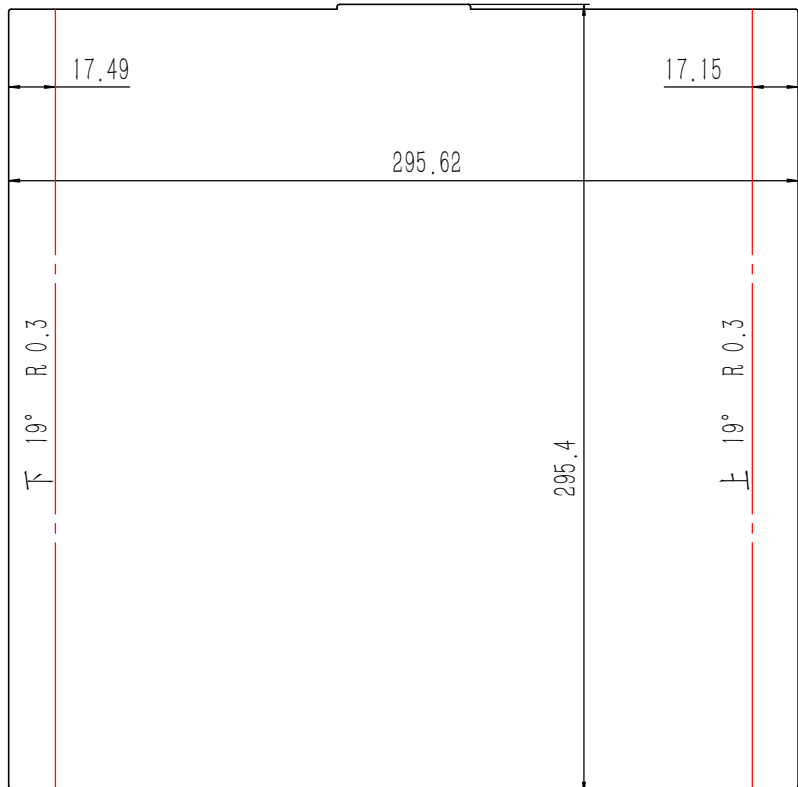
技术要求:

- 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。

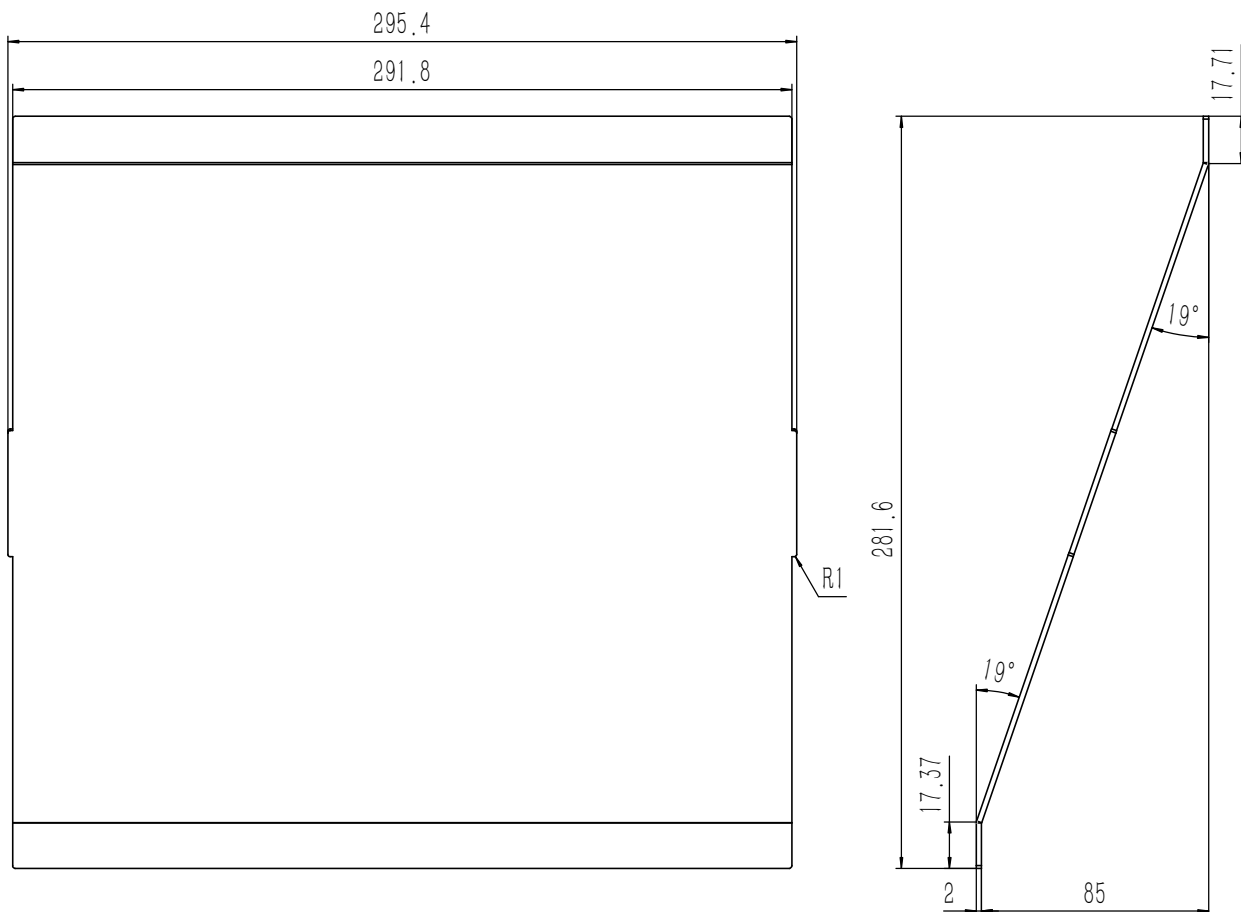
业务代码: _____

| 10 | YG-N102-0000-009 | 支柱B | 6063-T5 | 2 | 0.152 | |
|--------------|----------------------------|-------------------|------------------|-------------|----------------|--------------|
| 9 | YG-N102-0000-006 | 左侧板 | 5052-H32 | 1 | 0.340 | |
| 8 | YG-N102-0000-002 | 前挡板 | 5052-H32 | 1 | 0.073 | |
| 7 | YG-N102-0000-003 | 下盖板 | 5052-H32 | 1 | 0.442 | |
| 6 | YG-N102-0000-008 | 支柱A | 6063-T5 | 2 | 0.153 | |
| 5 | GB-T-819.1-2000-C-BE-M4X10 | 碳钢发黑十字沉头螺丝M4X10 | 普通碳钢 | 8 | 0.001 | |
| 4 | YG-N102-0000-005 | 右侧板 | 5052-H32 | 1 | 0.339 | |
| 3 | GB-T-819.1-2000-C-BE-M3X6 | 碳钢发黑十字沉头螺丝M3X6 | 普通碳钢 | 6 | 0.0004 | |
| 2 | YG-N102-0000-004 | 后挡板 | 5052-H32 | 1 | 0.192 | |
| 1 | YG-N102-0000-001 | 上盖板 | 5052-H32 | 1 | 0.464 | |
| 序号 (Item) | 图号 (Drawing Number) | 名称 (Part Name) | 材料 (Material) | 数量 (QTY) | 单重 (Weight) | 备注 (Note) |

| | | | | | |
|--|------------------|-------------------------------|--|---------------------------------------|--|
| Tolerances (未注公差): | | Material (材料): (装配图) | | YONGU 永固 | |
| 0.5 to 6 ± 0.1 | 6 to 30 ± 0.2 | Weight: (重量) (Kg): 2.471 | | | |
| 30 to 120 ± 0.3 | 120 to 400 ± 0.4 | Protection: (表面处理): | | Drawing Number (图号): YG-N102-0000-000 | |
| Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45° | | Part Name (零/部件名称): N102控制台机箱 | | Size (图幅): A0 | |
| Angular tolerances (未注角度公差): | | Drawn by (绘图): 邓展锋 | | Date (日期): 2022.10.24 | |
| <6° ± 10' | <30° ± 20' | Check by (校对): | | Date (日期): | |
| <120° ± 30' | >120° ± 1° | Signature by (批准): | | Date (日期): | |
| Position tolerances (未注位置公差): ± 0.05 | | Revision (版本): A1 | | Sheet (页数): 1 / 1 | |



钣金展开及折弯方向参考图 (视图比例x: 1)

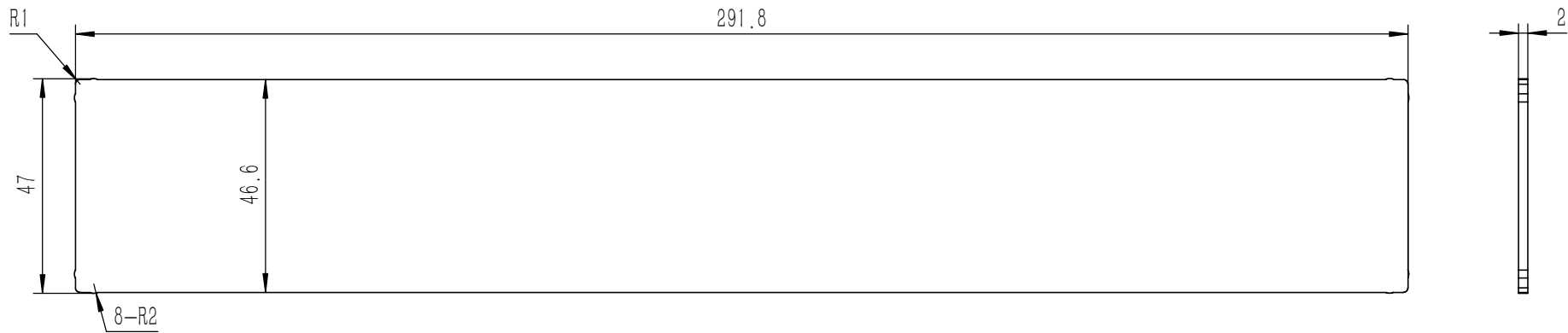


技术要求:

- 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。

业务代码:

| | | | | |
|---|---|-----------------------|-------------------|-------------------|
| 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 | | YONGU 永固 |
| | Weight: (重量) (Kg): | 0.464 | | |
| Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45° | Protection: (表面处理): | | | |
| | Position tolerances (未注位置公差): ±0.05 | Part Name (零/部件名称): | 上盖板 | |
| Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1° | Drawing Number (图号): | YG-N102-0000-001 | | |
| | Drawn by (绘图): 邓展锋 | Date (日期): 2022.10.24 | Size: (图幅): A1 | Sheet (页数): 1 / 1 |
| Check by (校对): | Date (日期): | Scale (比例): 1:1 | Revision (版本): A1 | |
| | Signature by (批准): | Date (日期): | | |

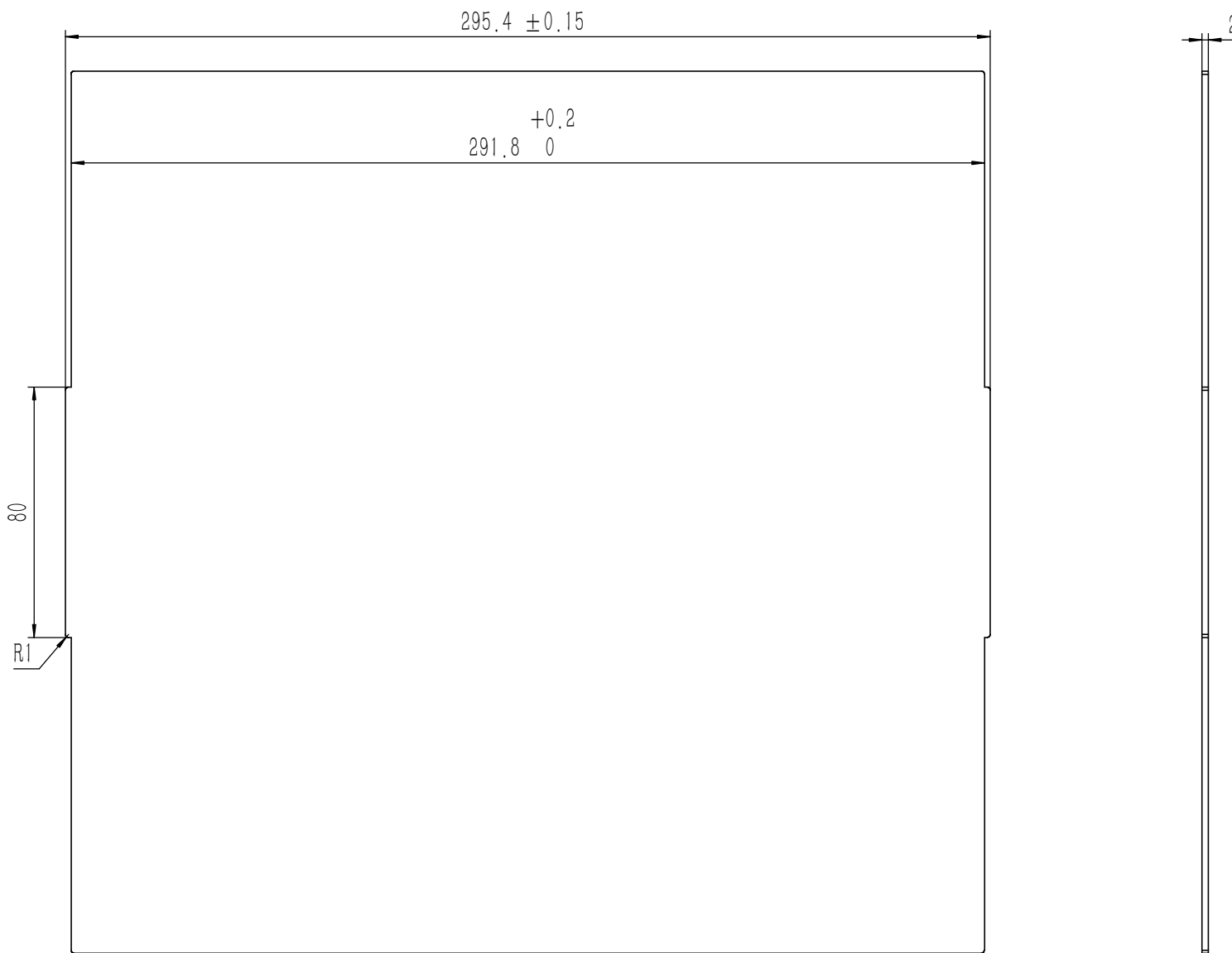


技术要求:

- 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。

业务代码:



| | | | |
|--|---|-------------------------|---------------------------------------|
| Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45° | 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 | YONGU 永固 |
| | Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1° | Weight: (重量) (Kg) 0.073 | |
| Position tolerances (未注位置公差): ±0.05 | Part Name (零/部件名称): 前挡板 | Part Name (零/部件名称): | Drawing Number (图号): YG-N102-0000-002 |
| | Drawn by (绘图): 邓展锋 | Date (日期): 2022.10.24 | Size: (图幅): A3 |
| | Check by (校对): | Date (日期): | Scale (比例): 1:1 |
| | Signature by (批准): | Date (日期): | Revision (版本): A1 |
| | | | Sheet (页数): 1 / 1 |

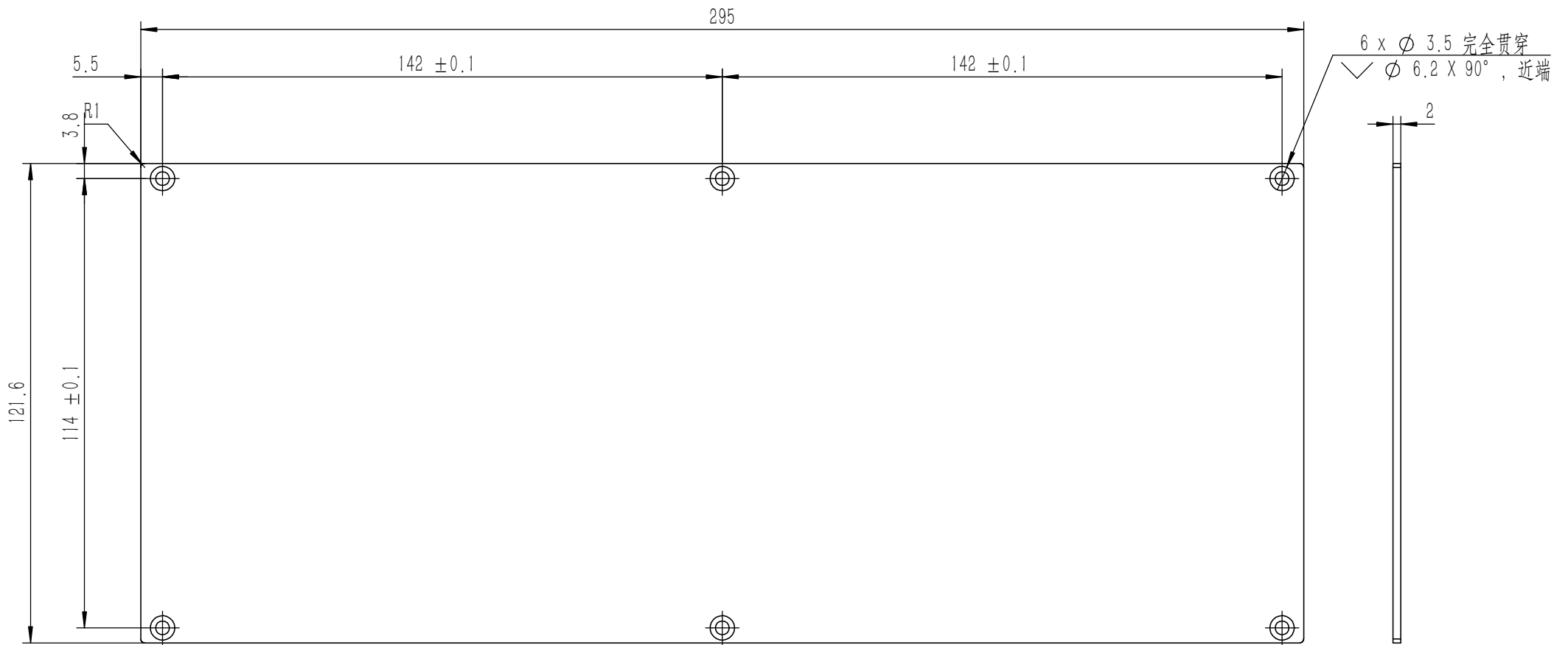


技术要求:

- 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。

业务代码:

| | | | | | | | | | | |
|--|---------------------------------|-------|---------------------|----------------|-----|---|------------|----------------|-----|---|
| Tolerances (未注公差): | 0.5 to 6 | ± 0.1 | Material (材料): | 5052-H32 | | YONGU  | | | | |
| | 6 to 30 | ± 0.2 | Weight: (重量) (Kg): | 0.442 | | | | | | |
| Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45° | 30 to 120 | ± 0.3 | Protection: (表面处理): | | | | | | | |
| | 120 to 400 | ± 0.4 | Part Name (零/部件名称): | 下盖板 | | Drawing Number (图号): YG-N102-0000-003 | | | | |
| Position tolerances (未注位置公差): ±0.05 | Angular tolerances (未注角度公差): | <6° | ± 10' | Drawn by (绘图): | 邓展锋 | Date (日期): | 2022.10.24 | Size: (图幅): | A2 |  |
| | <30° | ± 20' | Check by (校对): | | | Date (日期): | | Scale (比例): | 1:1 | |
| | <120° | ± 30' | Signature by (批准): | | | Date (日期): | | Revision (版本): | A1 | Sheet (页数): 1 / 1 |
| | >120° | ± 1° | | | | | | | | |

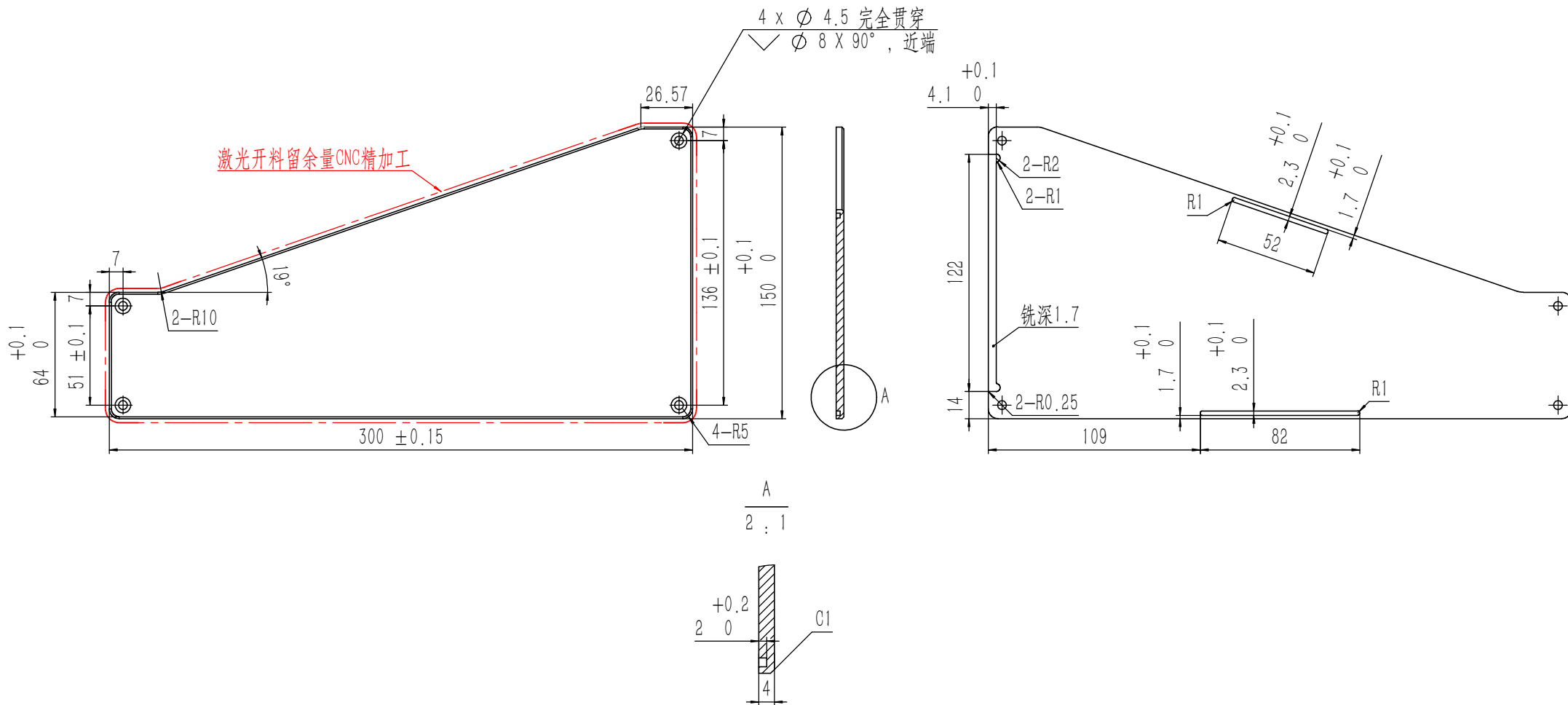


技术要求:

- 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。

业务代码:

| | | | | |
|---|---|---------------------|-----------------------|--|
| 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 | | YONGU 永固 |
| | Weight: (重量) (Kg) | 0.192 | | |
| Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45° | Protection: (表面处理): | | | Drawing Number (图号): YG-N102-0000-004 |
| | Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1° | Part Name (零/部件名称): | 后挡板 | |
| Position tolerances (未注位置公差): ±0.05 | Drawn by (绘图): | 邓展锋 | Date (日期): 2022.10.24 | Size: (图幅): A3 |
| | Check by (校对): | | Date (日期): | Scale (比例): 1:1 |
| | Signature by (批准): | | Date (日期): | Revision (版本): A1 |
| | | | | Sheet (页数): 1 / 1 |

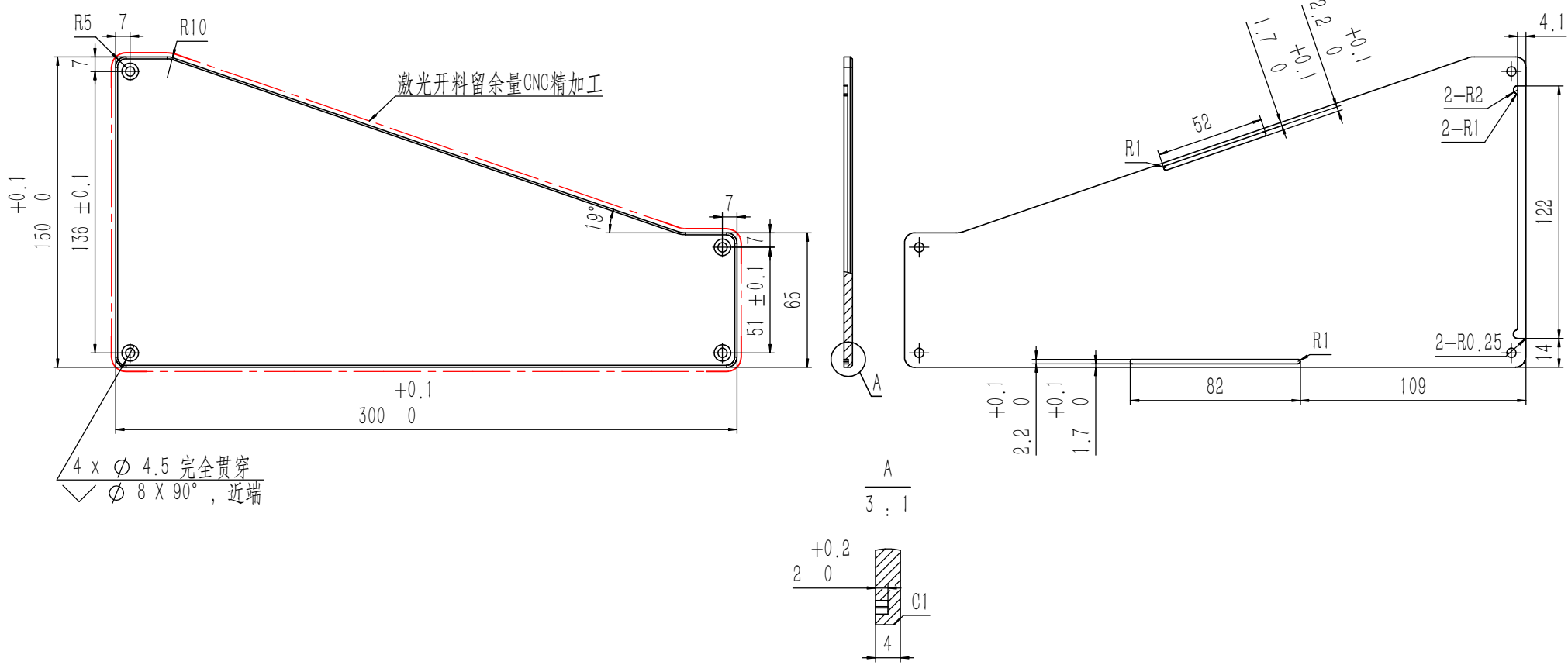


技术要求:

- 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。

业务代码:

| | | |
|---|--|--|
| 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 | YONGU 永固 |
| | Weight: (重量) (Kg): 0.339 | |
| Protection: (表面处理): | Part Name (零/部件名称): 右侧板 | Drawing Number (图号): YG-N102-0000-005 |
| Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45° | Angular tolerances (未注角度公差): $<6^\circ \pm 10'$ $<30^\circ \pm 20'$ $<120^\circ \pm 30'$ $>120^\circ \pm 1^\circ$ | Position tolerances (未注位置公差): ± 0.05 |
| Drawn by (绘图): 邓展锋 | | Date (日期): 2022.10.24 |
| Check by (校对): | | Date (日期): |
| Signature by (批准): | | Date (日期): |
| Size: (图幅): A1 | | Scale (比例): 1:1 |
| Revision (版本): A1 | | Sheet (页数): 1 / 1 |

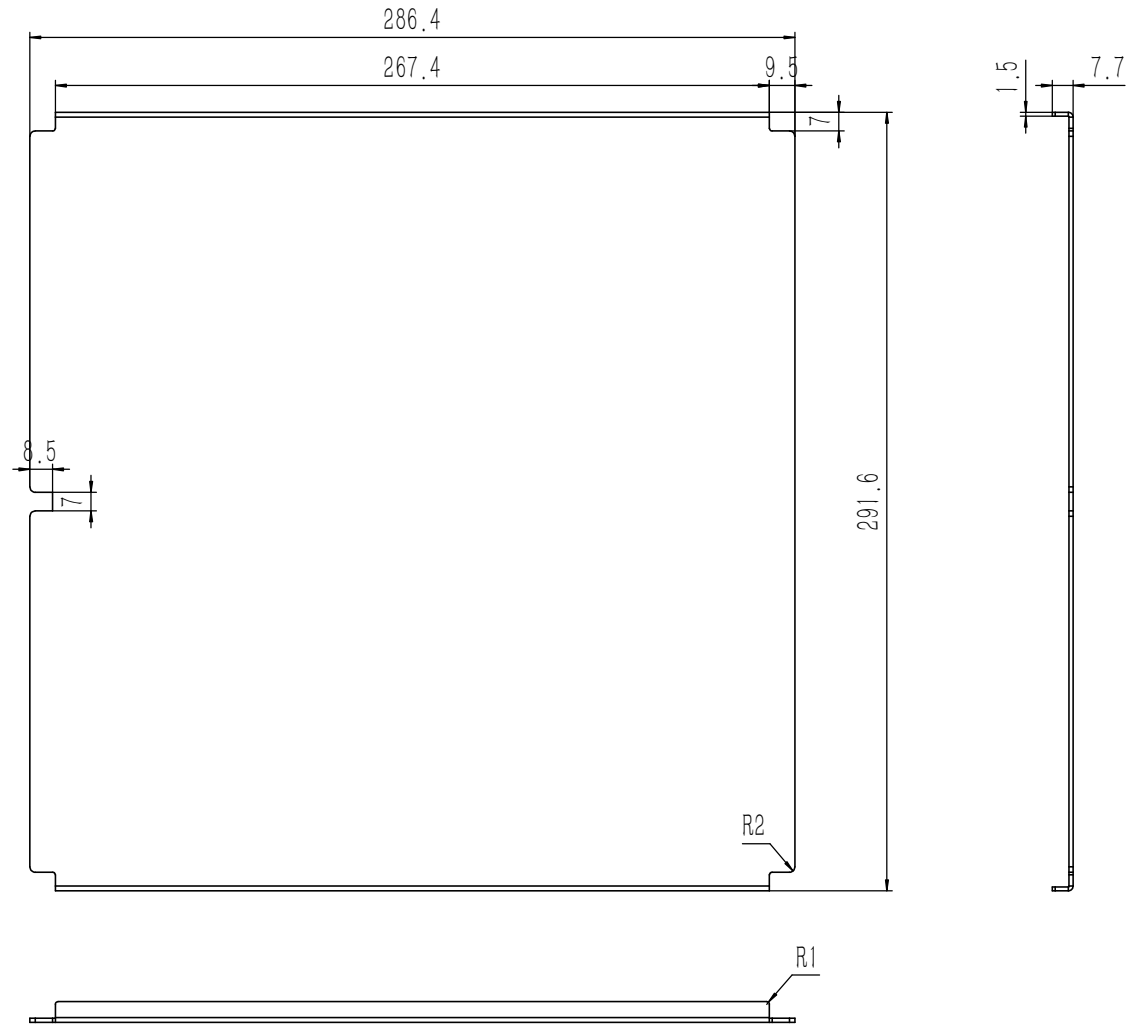
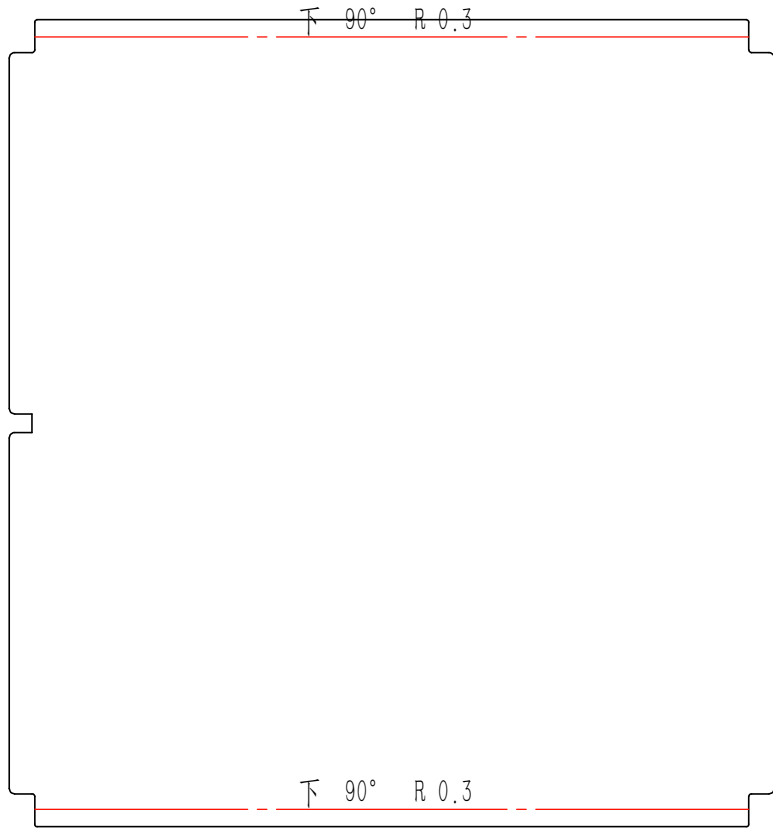


技术要求:
 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
 2、去除毛刺飞边,锐角倒钝;
 3、未标注尺寸见3D数模。

业务代码:

| | | | | | | | |
|---|--|---------------------|--|------------|----------------|-----|----------------------|
| 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 | YONGU 永固 | | | | |
| | Weight: (重量) (Kg): | 0.340 | | | | | |
| Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45° | Protection: (表面处理): | | Drawing Number (图号): YG-N102-0000-006 | | | | |
| | Position tolerances (未注位置公差): ± 0.05 | Part Name (零/部件名称): | | 左侧板 | | | |
| Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1° | Drawn by (绘图): | 邓展锋 | Date (日期): | 2022.10.24 | Size: (图幅): | A1 | 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)

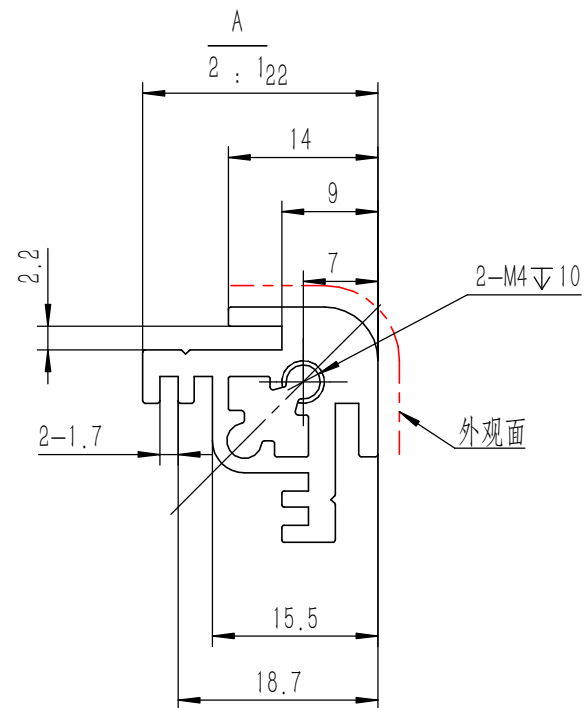
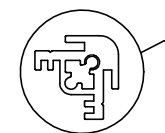
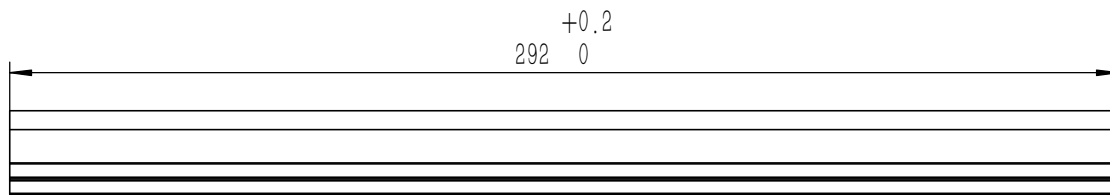


技术要求:

- 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。

业务代码:

| | | | | |
|---|---------------------------------|----------------|------------|----------------------|
| 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 | | YONGU 永固 |
| | Weight: (重量) (Kg): | 0.347 | | |
| 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): | 附件-安装衬板 | | Drawing Number (图号): |
| Position tolerances (未注位置公差): ±0.05 | Drawn by (绘图): | 邓展锋 | Date (日期): | 2022.10.24 |
| | Angular tolerances (未注角度公差): | <6° ± 10' | Date (日期): | |
| Angular tolerances (未注角度公差): <30° ± 20' <120° ± 30' >120° ± 1° | Check by (校对): | | Date (日期): | |
| | Signature by (批准): | | Date (日期): | |
| | | Size: (图幅): | A1 | Sheet (页数): |
| | | Scale (比例): | 1:1 | 1 / 1 |
| | | Revision (版本): | A1 | |

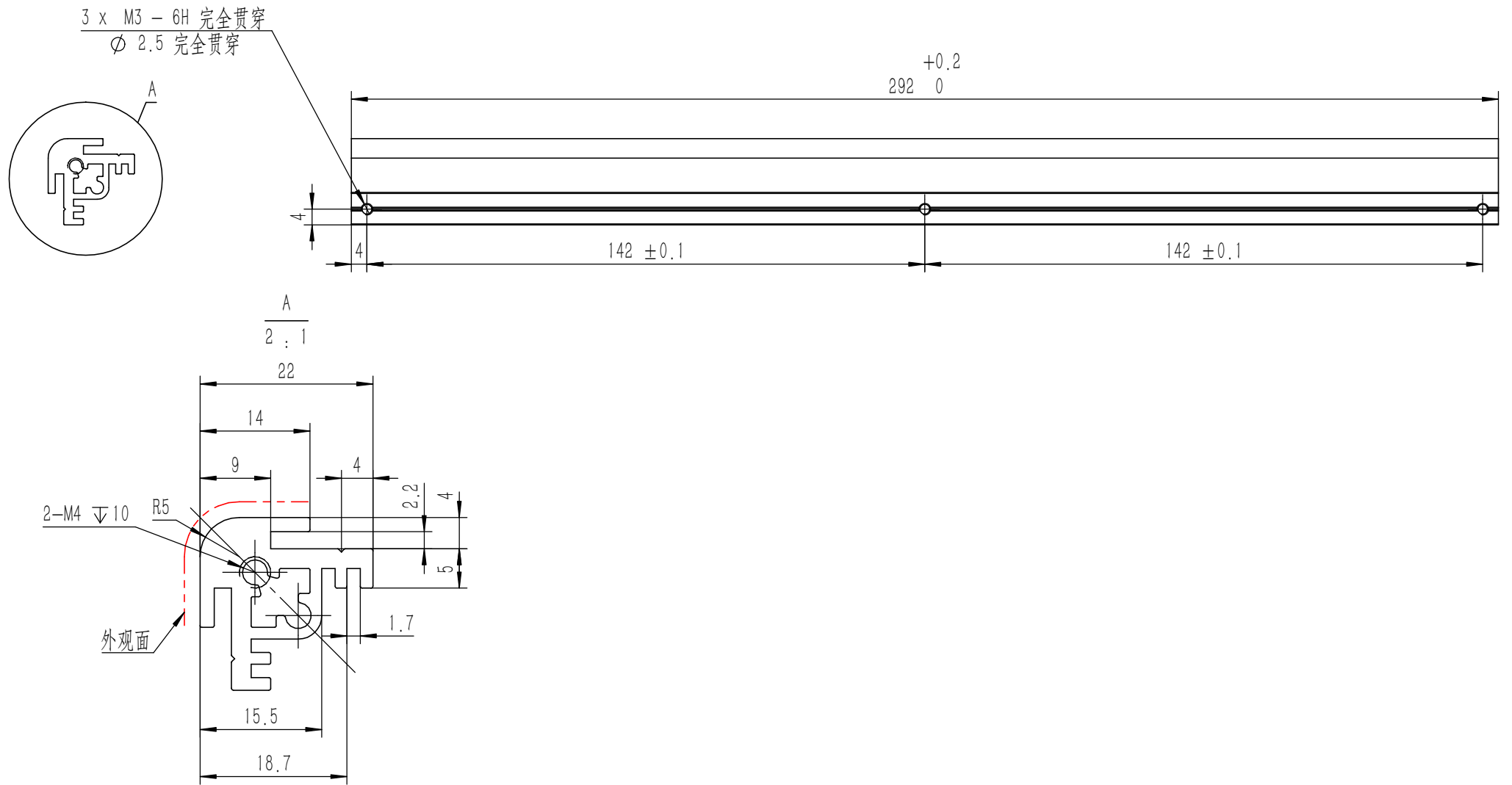


技术要求:

- 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。

业务代码:

| | | | |
|---|---|--|--------------------|
| 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 | YONGU 永固 | |
| | Weight: (重量) (Kg) 0.153 | | |
| Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45° | Protection: (表面处理): | Drawing Number (图号): YG-N102-0000-008 | |
| | 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 | Part Name (零/部件名称): 支柱A | Size: (图幅): A3 | |
| | Drawn by (绘图): 邓展锋 | Date (日期): 2022.10.24 | Sheet (页数): 1 / 1 |
| | Check by (校对): | Date (日期): | Scale (比例): 0.71:1 |
| | Signature by (批准): | Date (日期): | Revision (版本): A1 |



3 x M3 - 6H 完全贯穿
 \varnothing 2.5 完全贯穿

+0.2

292 0

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142 ±0.1

A
 2 : 1

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14

9

4

2.2

4

5

2-M4 ∇ 10

R5

外观面

15.5

18.7

1.7

- 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。

业务代码:

| | | | | | | | |
|---|---|---------------------|--|------------|----------------|-----|----------------------|
| 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 | YONGU 永固 | | | | |
| | Weight: (重量) (Kg) | 0.152 | | | | | |
| Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45° | Protection: (表面处理): | | Drawing Number (图号): YG-N102-0000-009 | | | | |
| | Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1° | Part Name (零/部件名称): | | 支柱B | | | |
| Position tolerances (未注位置公差): ±0.05 | Drawn by (绘图): | 邓展锋 | Date (日期): | 2022.10.24 | 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 | |