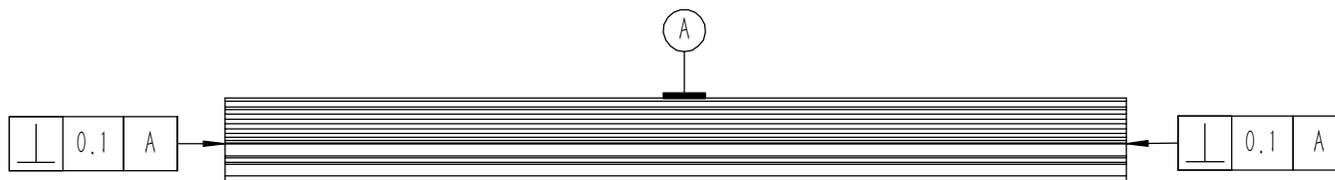
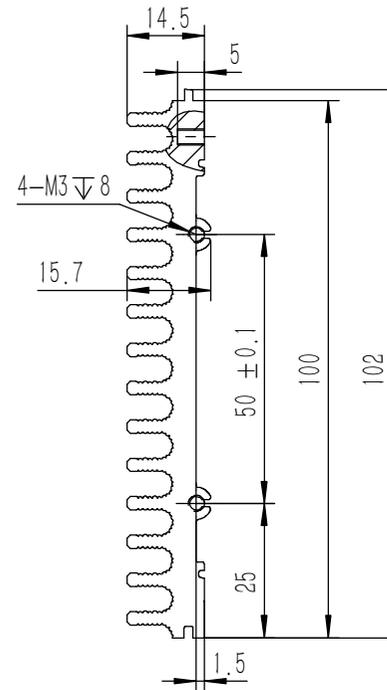
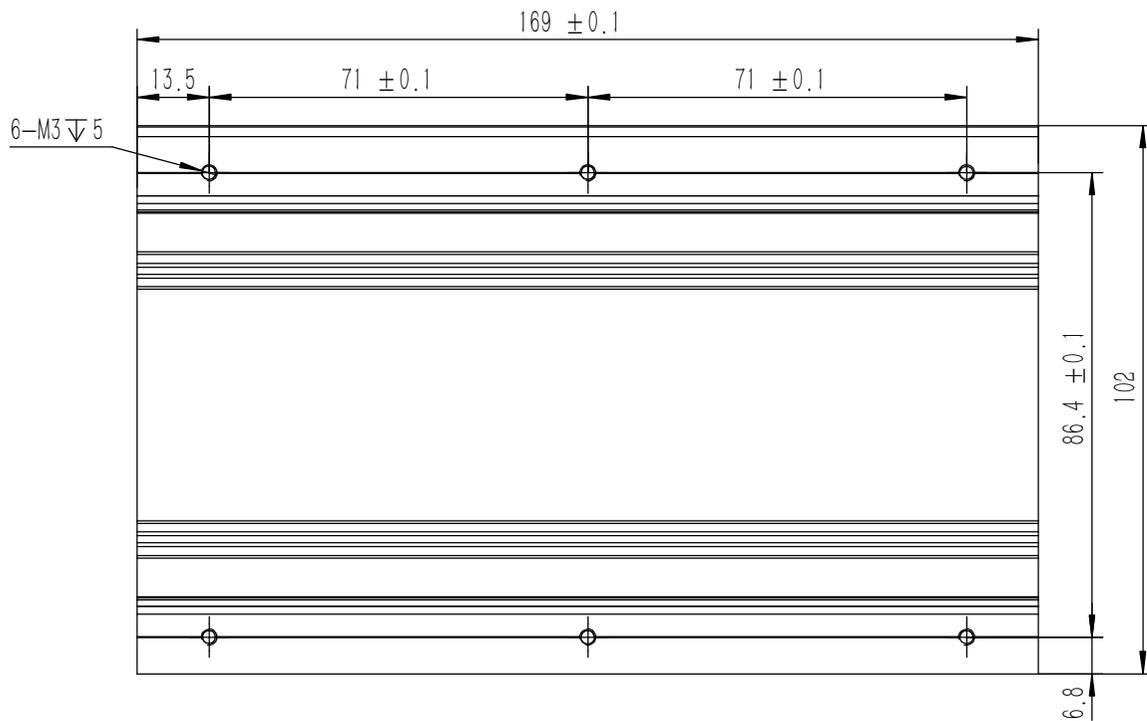


技术要求:

- 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。

序号	图号	名称	材料	数量	单重	备注
21	GB-T-973-1976-C-NI-M3X6	碳钢镀锌十字大扁头螺丝M3X6	普通碳钢	12	0.0006	
20	DIN-9250-S-NL-M3	不锈钢防松垫圈	SUS 304	12	0.000	
19	YG-TY-A13-007	A垫板	5052-H32	1	0.410	
18	YG-TY-XJD-001	自粘胶垫35X11X3	硅橡胶	8	0.0013	
17	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	8	0.0004	
16	YG-TY-A12-008	前后面板-4U	5052-H32	2	0.933	
15	YG-TY-A07-004	后防护条-4U	5052-H32	2	0.072	
14	YG-TY-A11-002	面板下固定件2	电解板	2	0.056	
13	GB-T-973-1976-C-NI-M3X12	碳钢镀锌十字大扁头螺丝M3X12	普通碳钢	16	0.001	
12	S-M3-1-ZI	压铆螺母镀锌M3X1	普通碳钢	8	0.3750	
11	BSO-M3-5-ZI-D5_4	压铆螺母柱 M3X5	普通碳钢	8	0.001	
10	YG-TY-A05-002	A包角2	6063-T5	4	0.043	
9	YG-TY-A01-007	上下盖板	5052-H32	1	0.764	
8	GB-T-973-1976-C-NI-M3X4	碳钢镀锌十字大扁头螺丝M3X4	普通碳钢	54	0.0005	
7	YG-TY-A06-004	拉手-4U	6063-T5	2	0.145	
6	YG-TY-A10-002	面板上固定件2	电解板	2	0.049	
5	YG-TY-A05-001	A包角1	6063-T5	4	0.043	
4	YG-TY-A08-004	A侧板固定件 4U	6063-T5	4	0.065	
3	YG-TY-A02-007	上盖板	5052-H32	1	0.736	
2	YG-TY-A09-004	侧板连接件	电解板	4	0.044	
1	YG-TY-A03-004	组合侧板	6063-T5	6	0.369	

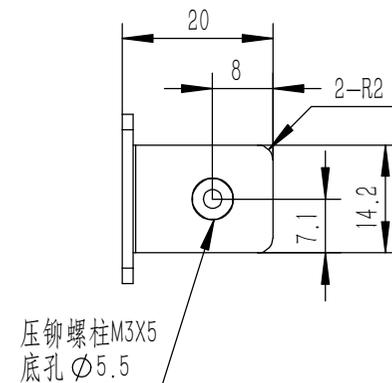
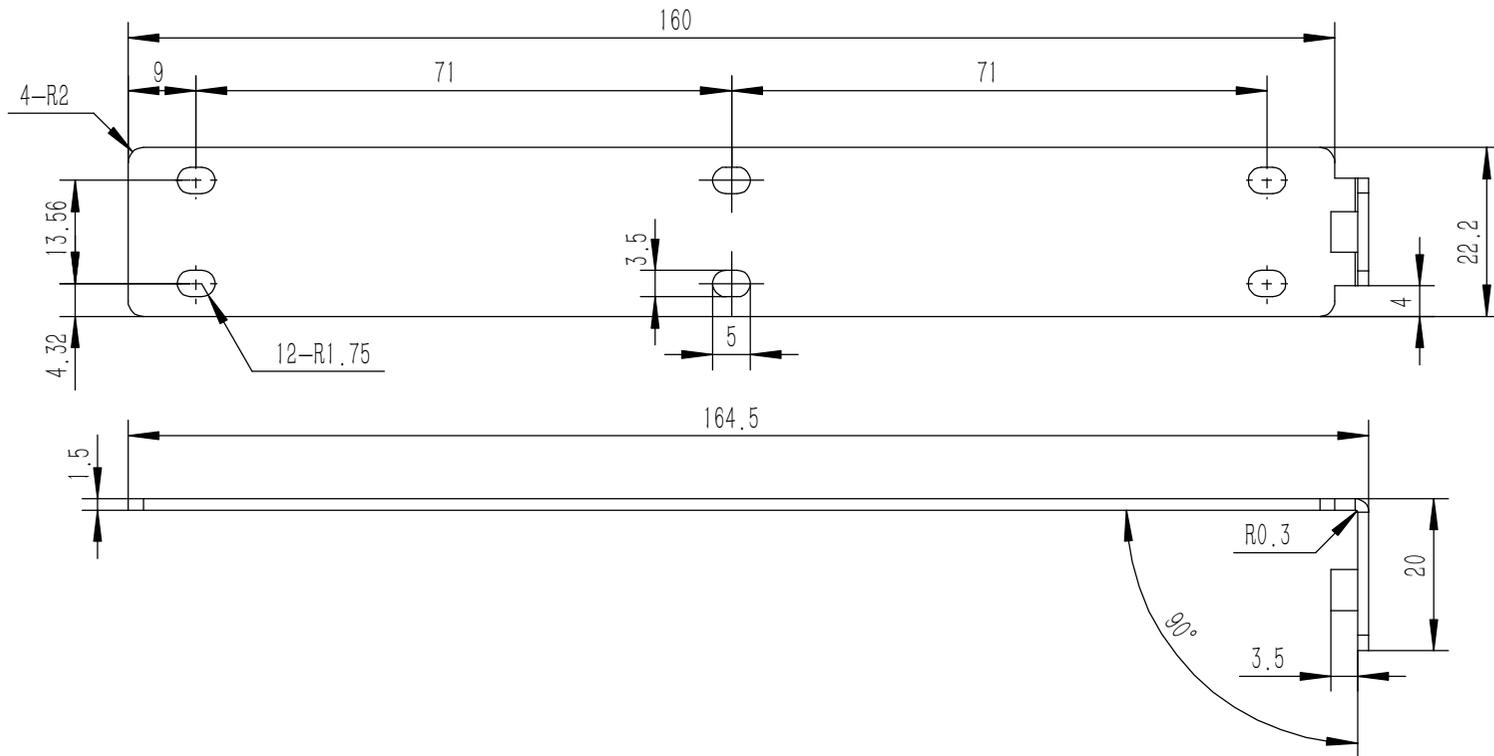
Tolerances (未注公差):		Material (材料):	(装配图)	
0.5 to 6	± 0.1	Weight: (重量) (Kg):	7.488	
6 to 30	± 0.2	Protection: (表面处理):		
30 to 120	± 0.3	Part Name (零/部件名称):	A08机箱	
120 to 400	± 0.4	Signature by (批准):	Date (日期): 2020.05.22	
Break sharp edges (未注锐边倒角):	Ch 0.05 to 0.25 x45°	Angular tolerances (未注角度公差):	<6° ± 10'	
Position tolerances (未注位置公差):	± 0.05	Angular tolerances (未注角度公差):	<30° ± 20'	
		Angular tolerances (未注角度公差):	<120° ± 30'	
		Angular tolerances (未注角度公差):	>120° ± 1°	
		Material (材料):	(装配图)	
		Weight: (重量) (Kg):	7.488	
		Protection: (表面处理):		
		Part Name (零/部件名称):	A08机箱	
		Signature by (批准):	Date (日期): 2020.05.22	
		Position tolerances (未注位置公差):	± 0.05	
		Angular tolerances (未注角度公差):	<6° ± 10'	
		Angular tolerances (未注角度公差):	<30° ± 20'	
		Angular tolerances (未注角度公差):	<120° ± 30'	
		Angular tolerances (未注角度公差):	>120° ± 1°	
		Material (材料):	(装配图)	
		Weight: (重量) (Kg):	7.488	
		Protection: (表面处理):		
		Part Name (零/部件名称):	A08机箱	
		Signature by (批准):	Date (日期): 2020.05.22	
		Position tolerances (未注位置公差):	± 0.05	
		Angular tolerances (未注角度公差):	<6° ± 10'	
		Angular tolerances (未注角度公差):	<30° ± 20'	
		Angular tolerances (未注角度公差):	<120° ± 30'	
		Angular tolerances (未注角度公差):	>120° ± 1°	
		Material (材料):	(装配图)	
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		Signature by (批准):	Date (日期): 2020.05.22	
		Position tolerances (未注位置公差):	± 0.05	
		Angular tolerances (未注角度公差):	<6° ± 10'	
		Angular tolerances (未注角度公差):	<30° ± 20'	
		Angular tolerances (未注角度公差):	<120° ± 30'	
		Angular tolerances (未注角度公差):	>120° ± 1°	
		Material (材料):	(装配图)	
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		Angular tolerances (未注角度公差):	<30° ± 20'	
		Angular tolerances (未注角度公差):	<120° ± 30'	
		Angular tolerances (未注角度公差):	>120° ± 1°	
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		Angular tolerances (未注角度公差):	<30° ± 20'	
		Angular tolerances (未注角度公差):	<120° ± 30'	
		Angular tolerances (未注角度公差):	>120° ± 1°	
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		Angular tolerances (未注角度公差):	<30° ± 20'	
		Angular tolerances (未注角度公差):	<120° ± 30'	
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		Angular tolerances (未注角度公差):	<30° ± 20'	
		Angular tolerances (未注角度公差):	<120° ± 30'	
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		Material (材料):	(装配图)	
		Weight: (重量) (Kg):	7.488	
		Protection: (表面处理):		
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		Signature by (批准):	Date (日期): 2020.05.22	
		Position tolerances (未注位置公差):	± 0.05	
		Angular tolerances (未注角度公差):	<6° ± 10'	
		Angular tolerances (未注角度公差):	<30° ± 20'	
		Angular tolerances (未注角度公差):	<120° ± 30'	
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		Material (材料):	(装配图)	
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		Angular tolerances (未注角度公差):	<6° ± 10'	
		Angular tolerances (未注角度公差):	<30° ± 20'	
		Angular tolerances (未注角度公差):	<120° ± 30'	
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		Angular tolerances (未注角度公差):	<6° ± 10'	
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		Angular tolerances (未注角度公差):	<120° ± 30'	
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		Material (材料):	(装配图)	
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		Signature by (批准):	Date (日期): 2020.05.22	
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		Material (材料):	(装配图)	
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		Material (材料):	(装配图)	
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		Position tolerances (未注位置公差):	± 0.05	
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		Material (材料):	(装配图)	
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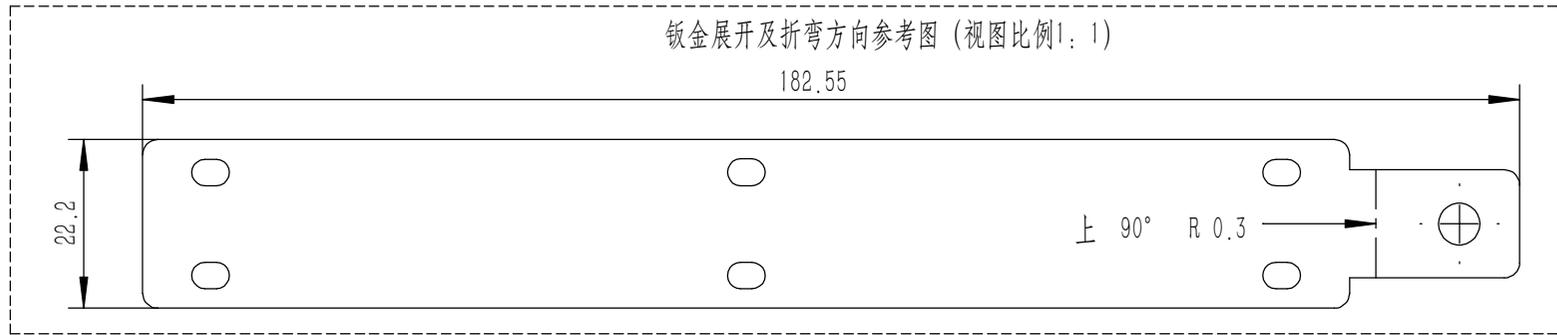
技术要求:

- 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):	6063-T5		YONGU 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	

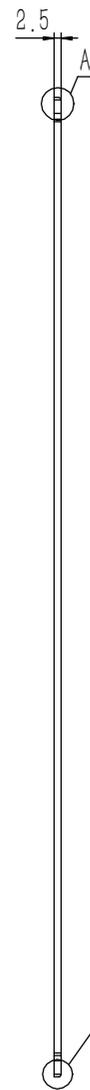
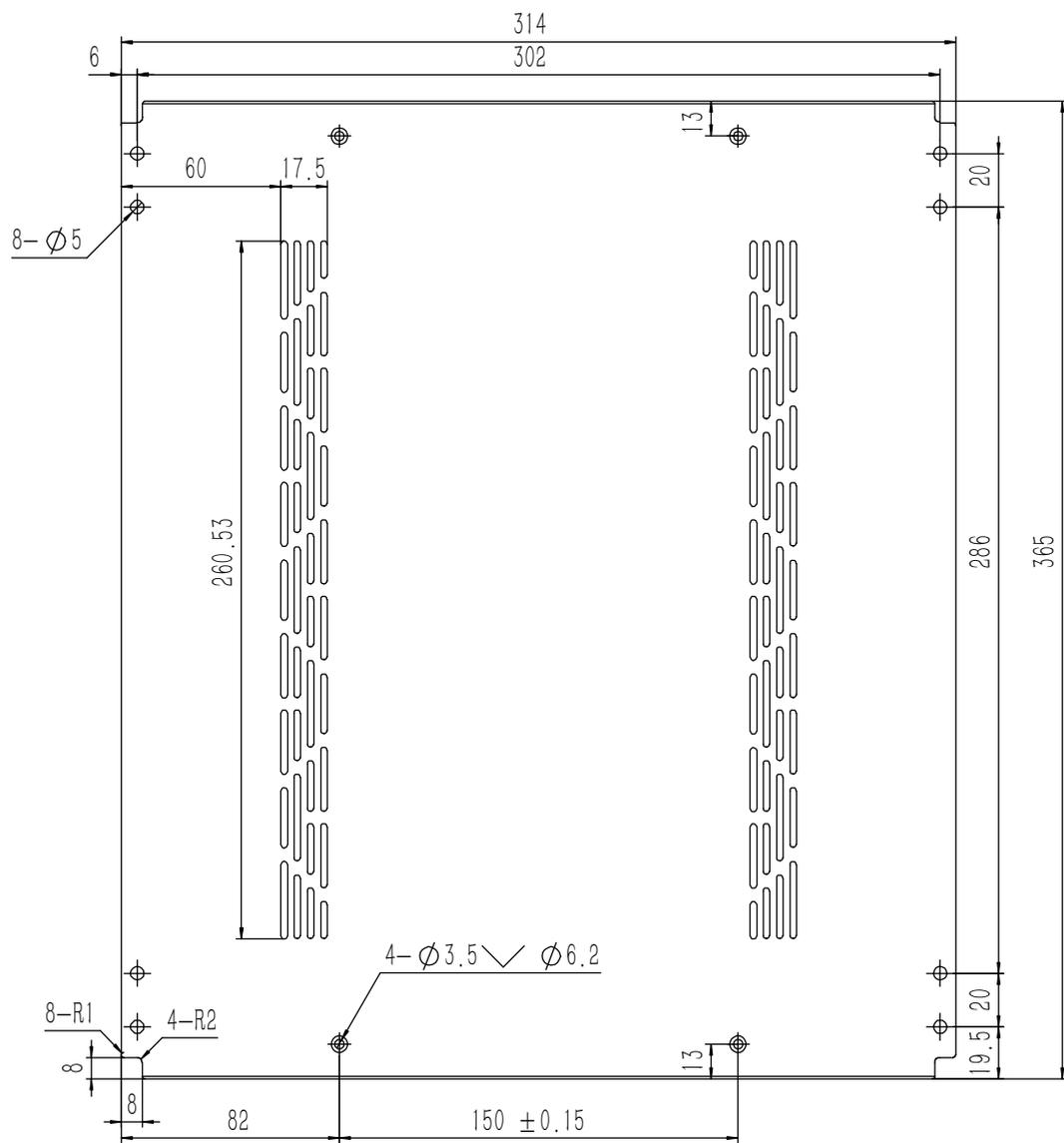


钣金展开及折弯方向参考图 (视图比例1:1)



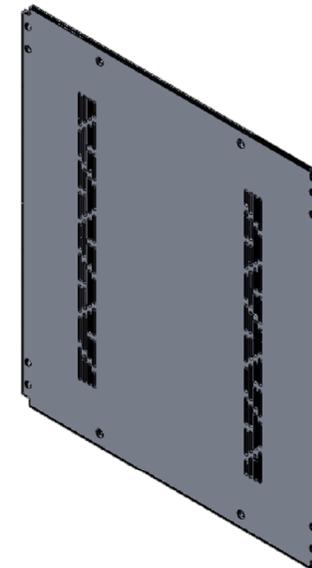
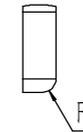
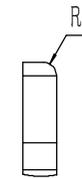
技术要求:
1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
2、去除毛刺飞边,锐角倒钝;
3、未标注尺寸见3D数模。

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°	Date (日期): 2020.05.19	Drawing Number (图号): YG-TY-A09-004
	Material (材料): 电解板	Weight: (重量) (Kg) 0.045	Part Name (零/部件名称): 侧板连接件 4U	Scale (图幅): A4
	Protection: (表面处理):	Date (日期): 2020.05.19	Part Name (零/部件名称): 侧板连接件 4U	Scale (比例): 1:1
	Part Name (零/部件名称): 侧板连接件 4U	Date (日期):	Part Name (零/部件名称): 侧板连接件 4U	Revision (版本): A1
	Part Name (零/部件名称): 侧板连接件 4U	Date (日期):	Part Name (零/部件名称): 侧板连接件 4U	Sheet (页数): 1 / 1



A
5 : 1

B
5 : 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

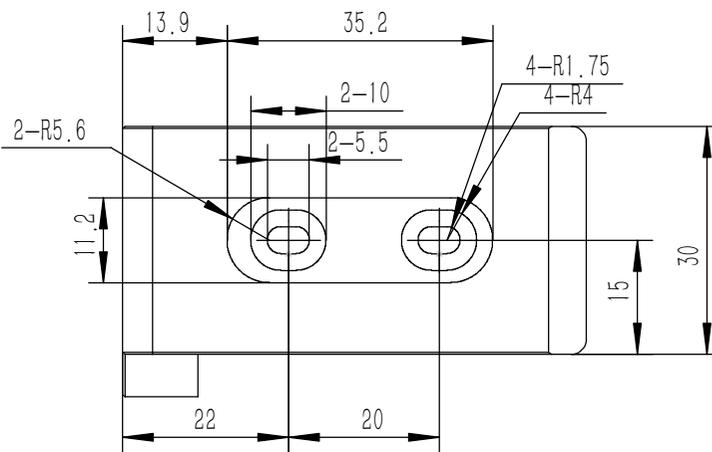
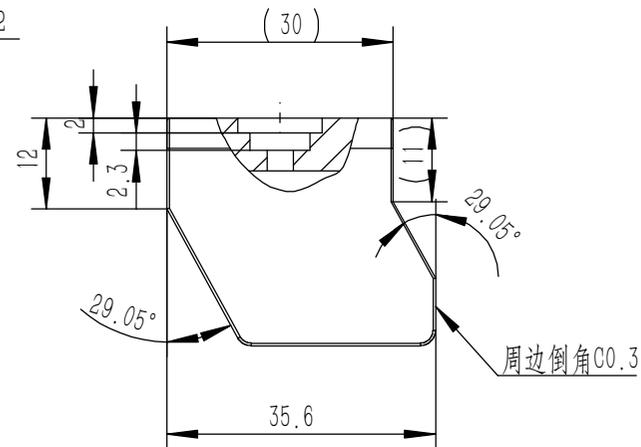
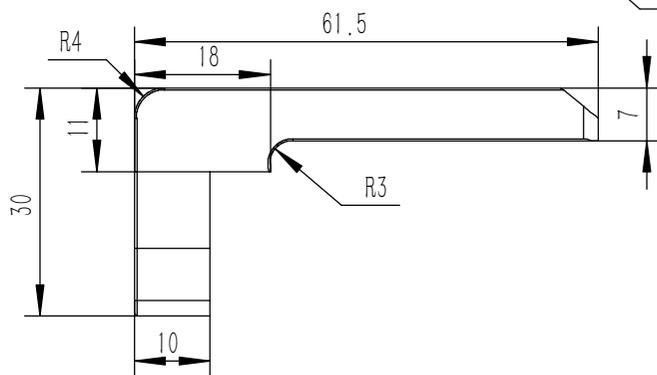
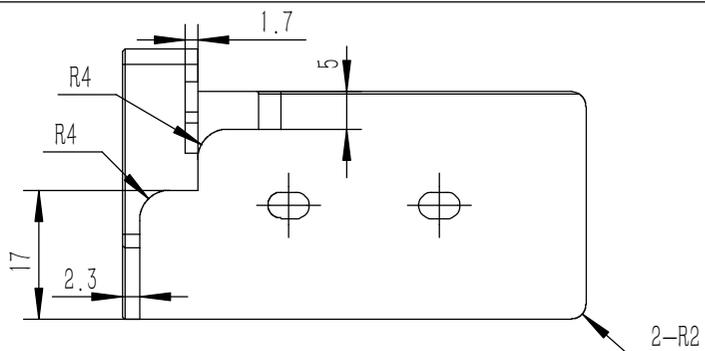
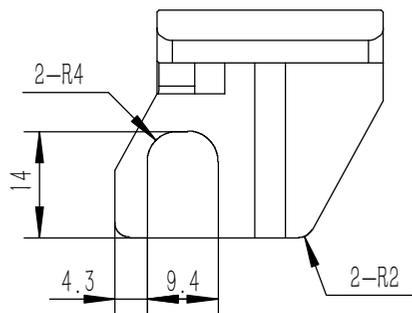
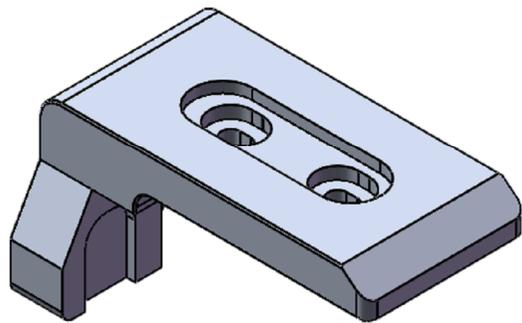
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Angular tolerances (未注角度公差):
	<6° ± 10'
	<30° ± 20'
	<120° ± 30'
	>120° ± 1°

Material (材料):	5052-H32
Weight: (重量) (Kg):	0.736
Protection: (表面处理):	
Part Name (零/部件名称):	上盖板

YONGU 永固

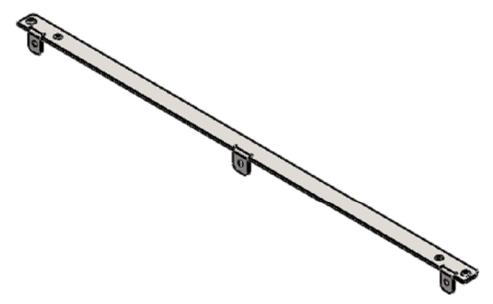
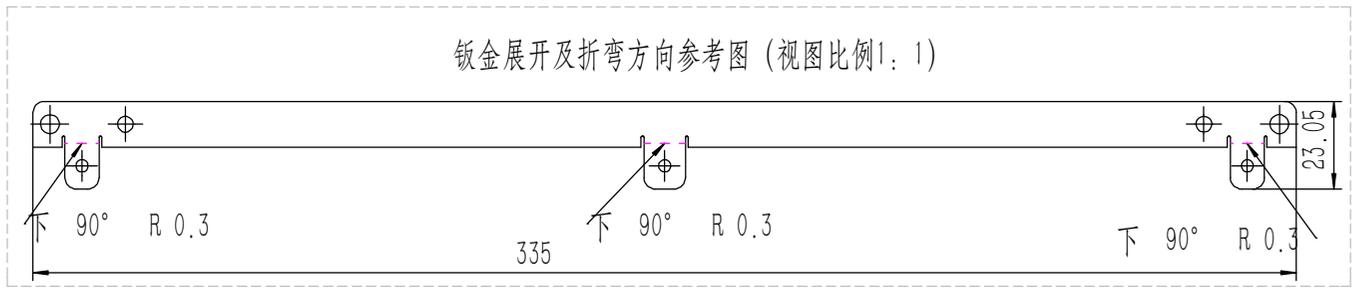
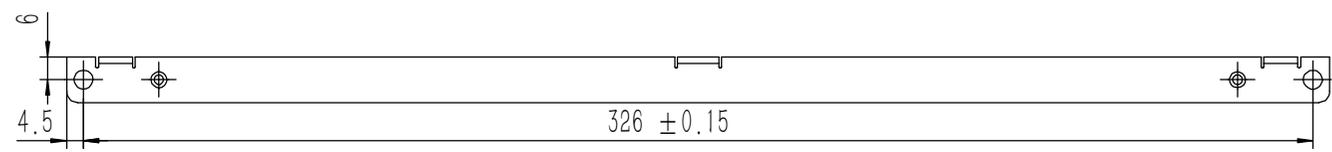
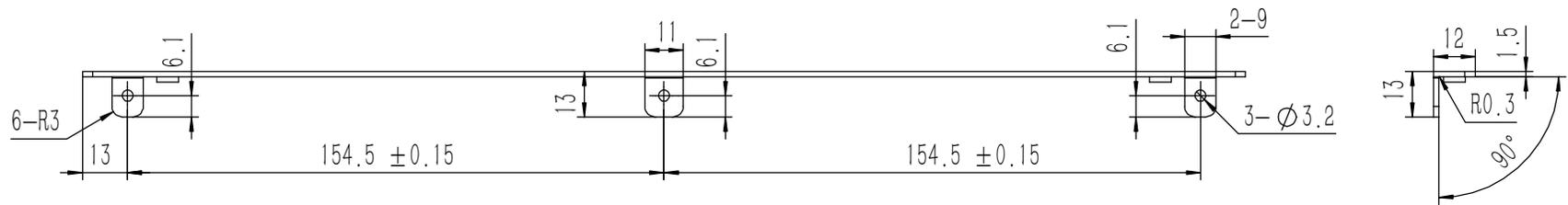
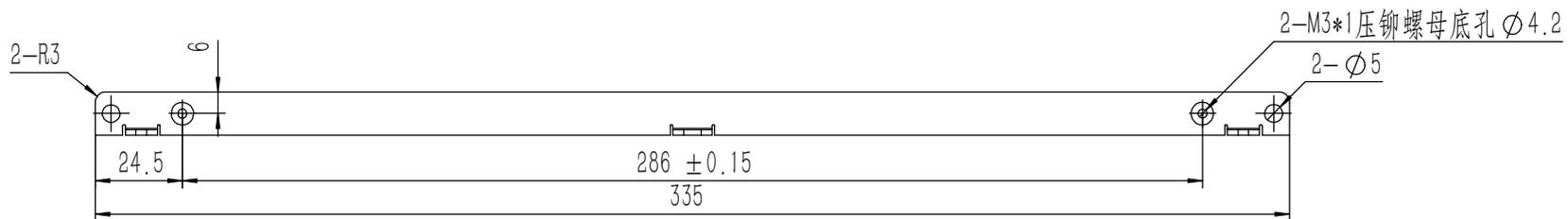
Drawn by (绘图): 莫永康	Date (日期): 2020.05.18	Size: (图幅): A1	
Check by (校对):	Date (日期):	Scale (比例): 1:1	
Signature by (批准):	Date (日期):	Revision (版本): A1	Sheet (页数): 1 / 1

Drawing Number (图号):
YG-TY-A02-007



- 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。

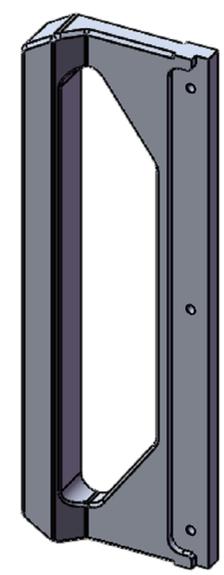
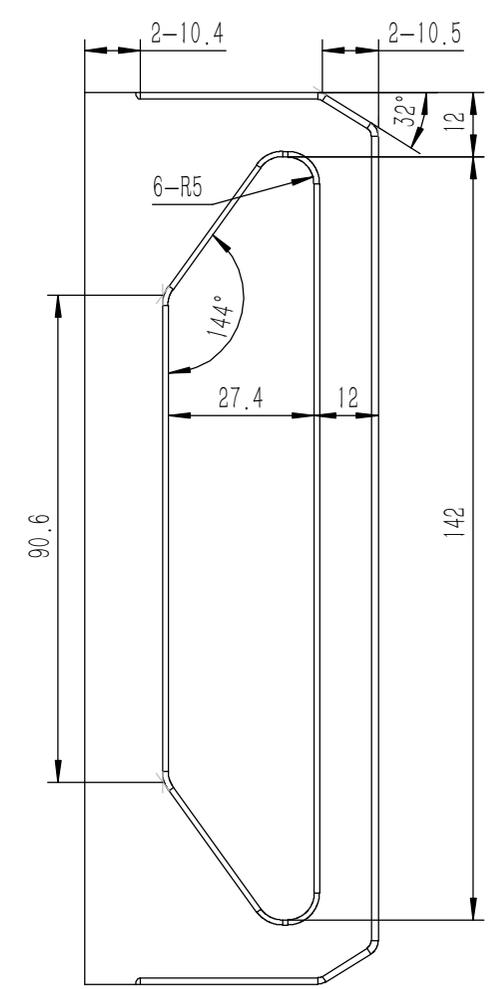
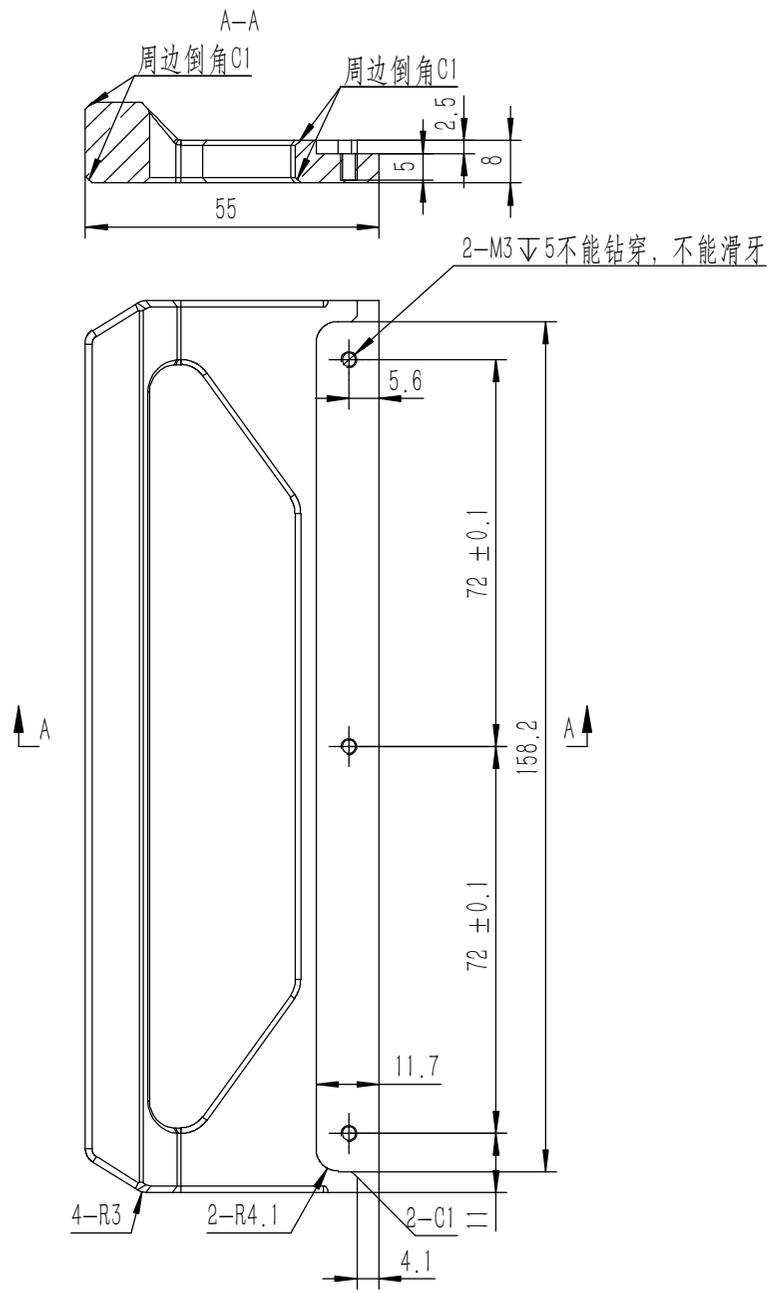
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): 6063-T5	YONGU 永固	
	Weight: (重量) (Kg) 0.043		
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):	Part Name (零/部件名称): A包角1	
	Position tolerances (未注位置公差): ±0.05	Angular tolerances (未注角度公差):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



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。

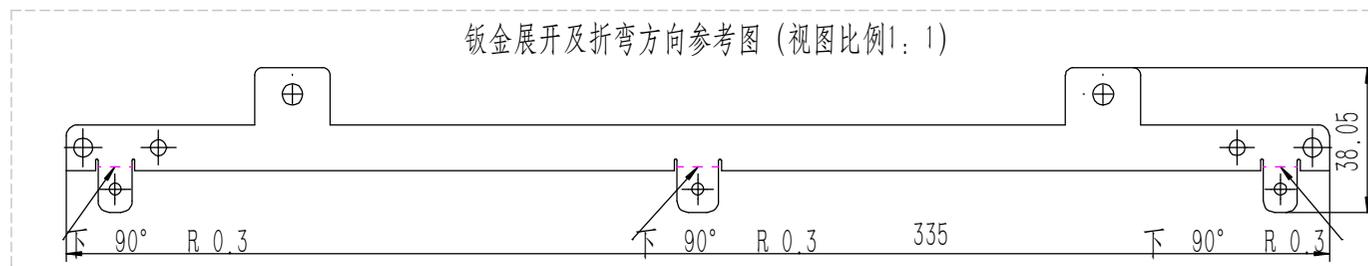
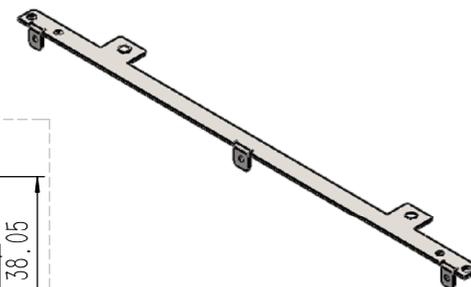
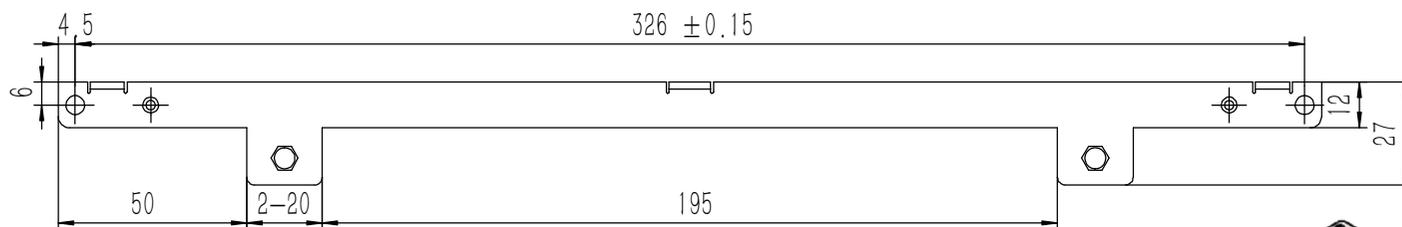
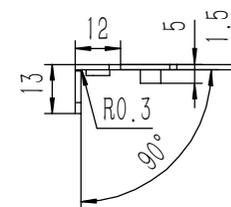
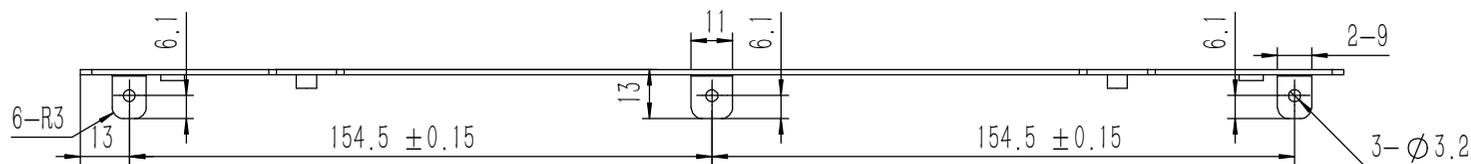
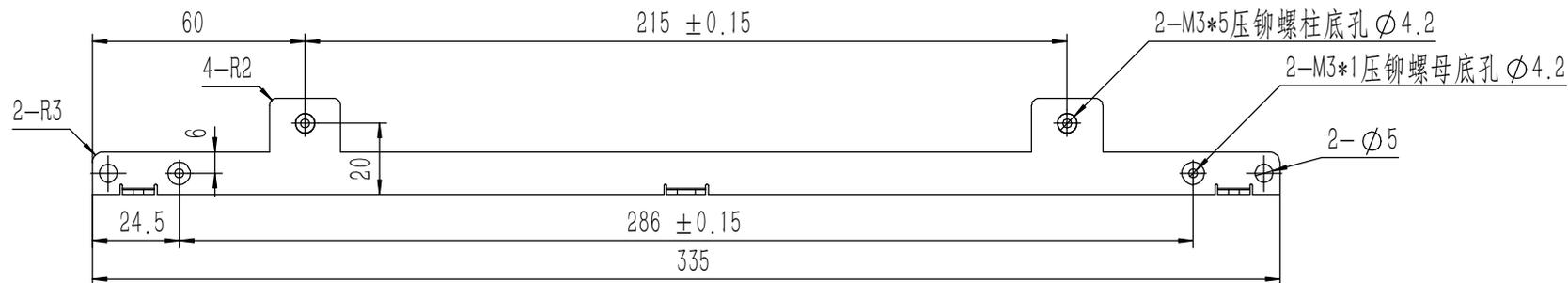
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料):	电解板	YONGU 永固
	Weight: (重量) (Kg):	0.050	
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):	毛坯	Drawing Number (图号): YG-TY-A10-002
	Position tolerances (未注位置公差): ±0.05	Part Name (零/部件名称):	
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):
	Signature by (批准):		Date (日期):
			Size (图幅): A2
			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。

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)	0.145	
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):	拉手-4U	
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Part Name (零/部件名称):	拉手-4U	
	Position tolerances (未注位置公差): ±0.05	Part Name (零/部件名称):	Part Name (零/部件名称):
Drawing Number (图号):		YG-TY-A06-004	
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
Signature by (批准):		Date (日期):	Revision (版本): A1





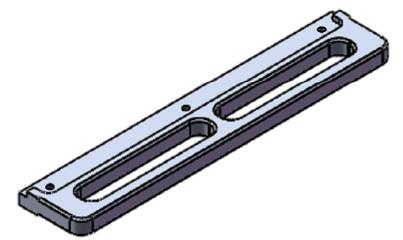
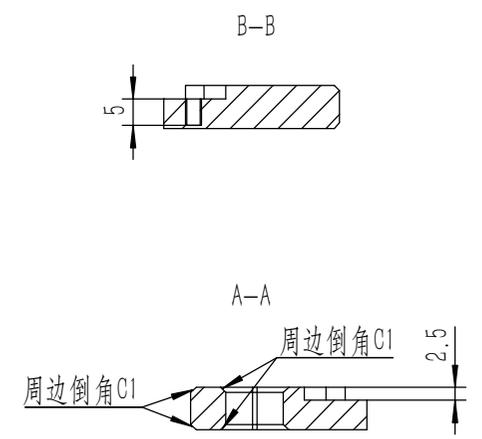
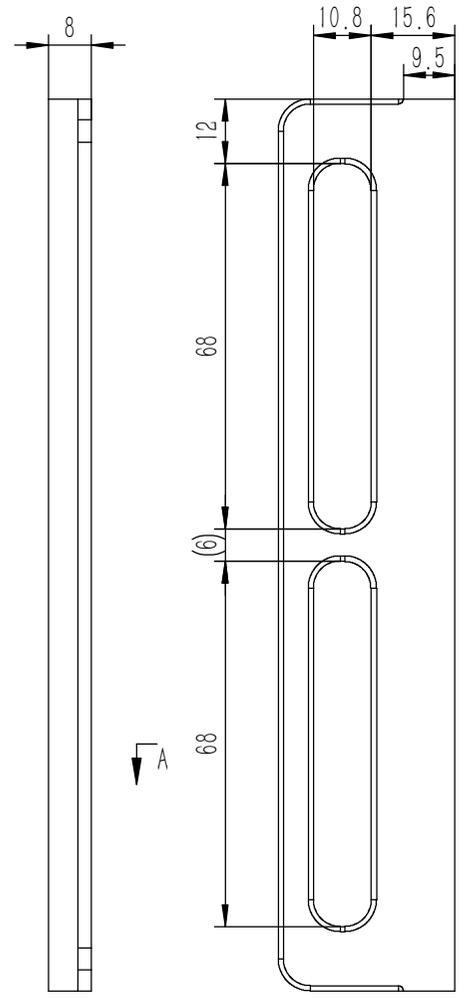
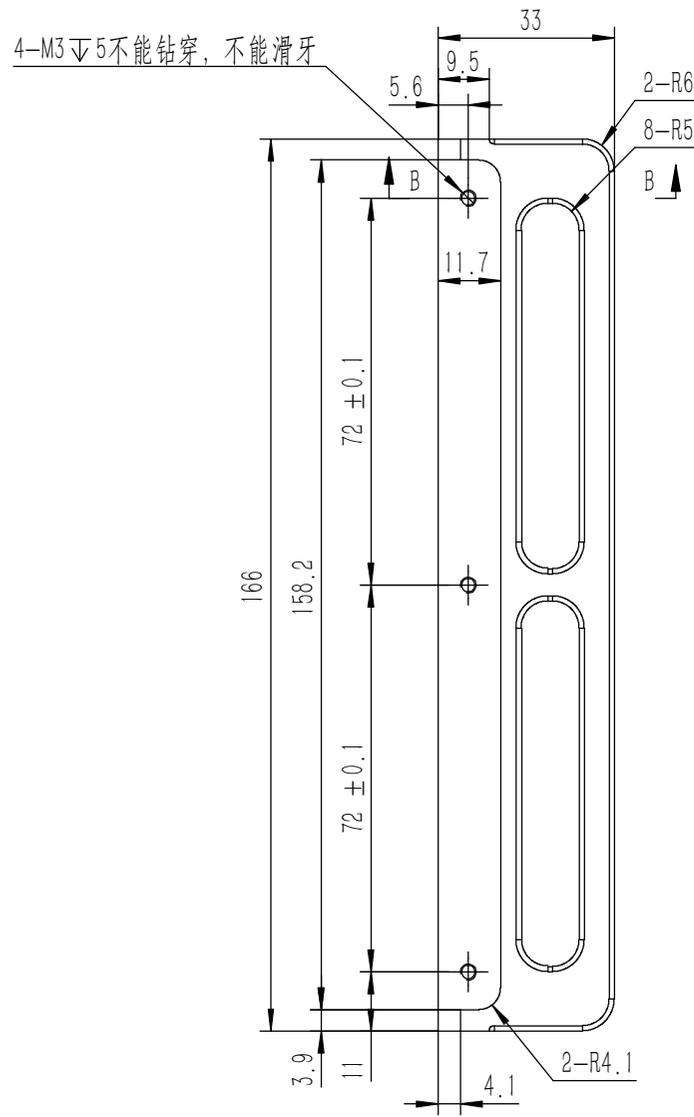
钣金展开及折弯方向参考图 (视图比例1: 1)

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。

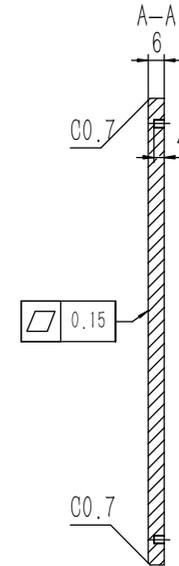
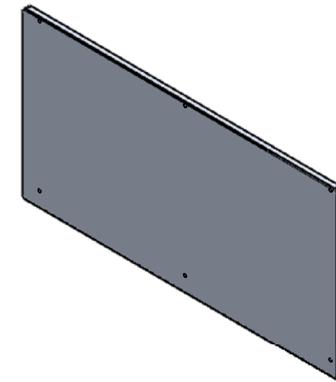
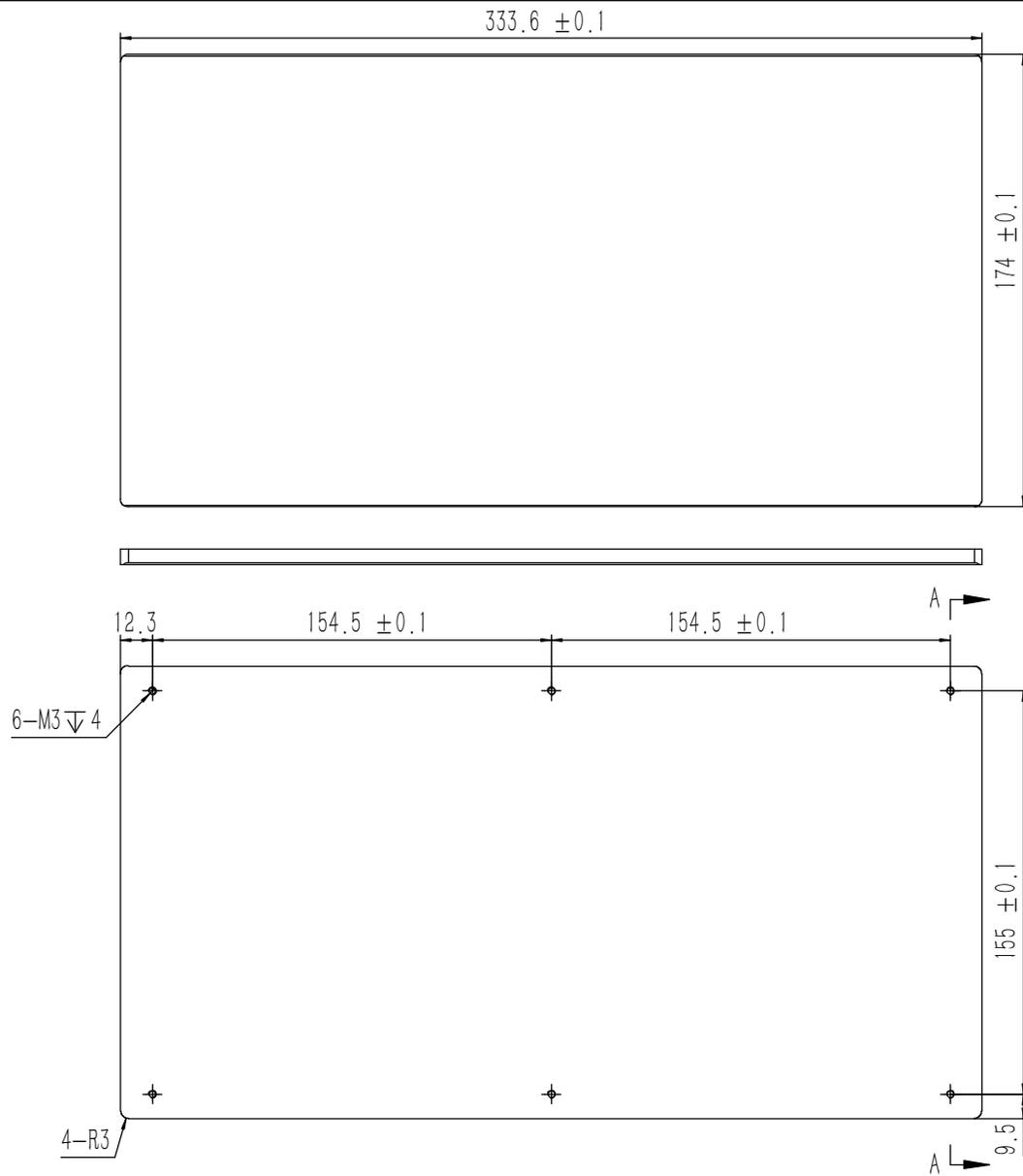
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): (装配图) Weight: (重量) (Kg): 0.058 Protection: (表面处理): 毛坯 Part Name (零/部件名称):	YONGU 永固	
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	面板下固定件2	
Position tolerances (未注位置公差): ±0.05	Drawn by (绘图): 许宏彬 Check by (校对): Signature by (批准):	Date (日期): 2020.09.18 Date (日期): Date (日期):	Size: (图幅): A2 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。

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)	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° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Part Name (零/部件名称):	后防护条-4U	
	Position tolerances (未注位置公差): ±0.05	Part Name (零/部件名称):	后防护条-4U
Drawn by (绘图): 邓展锋	Date (日期): 2020.05.18	Size (图幅): A3	YONGU 永固
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
Drawing Number (图号):		YG-TY-A07-004	



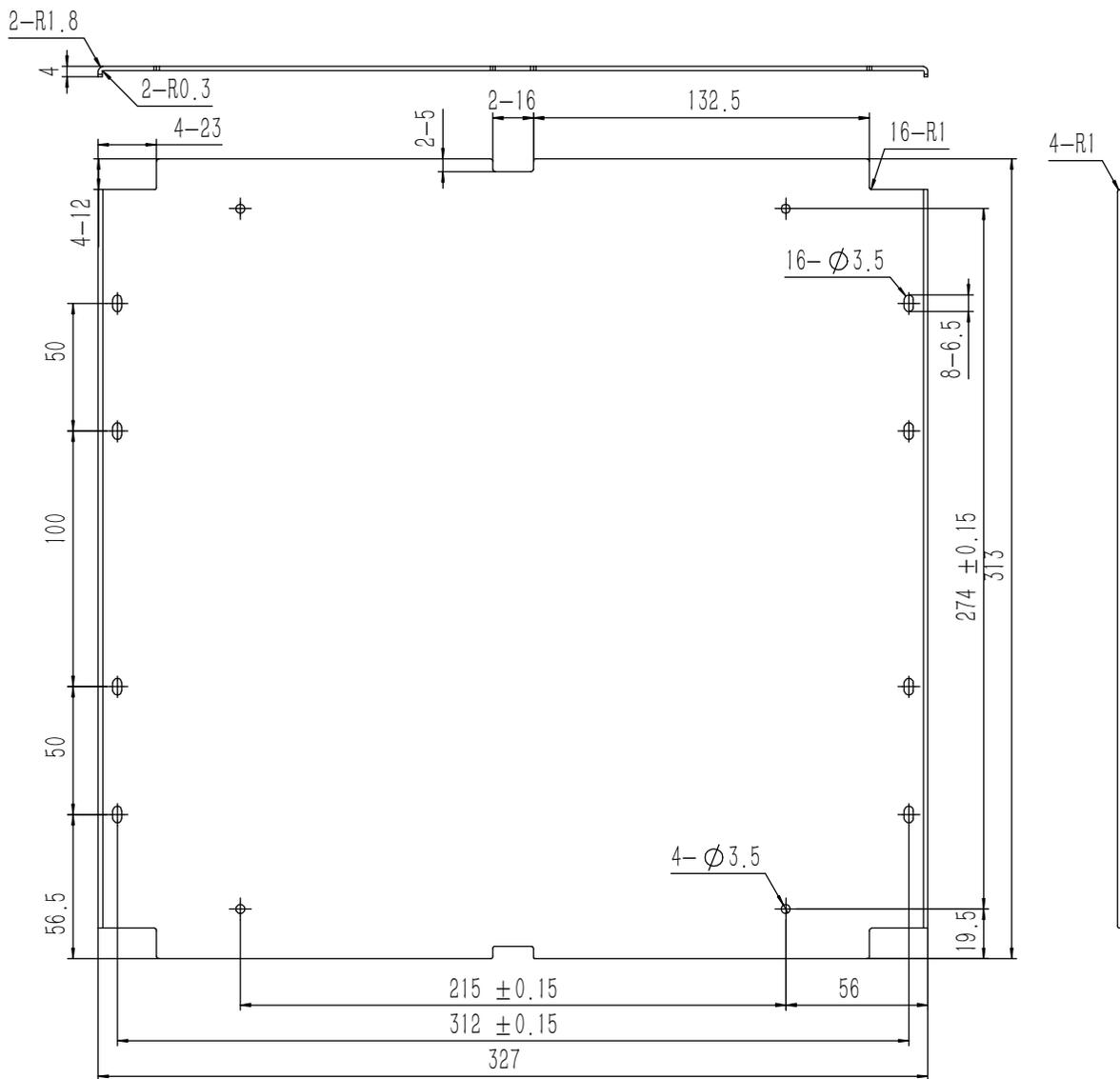
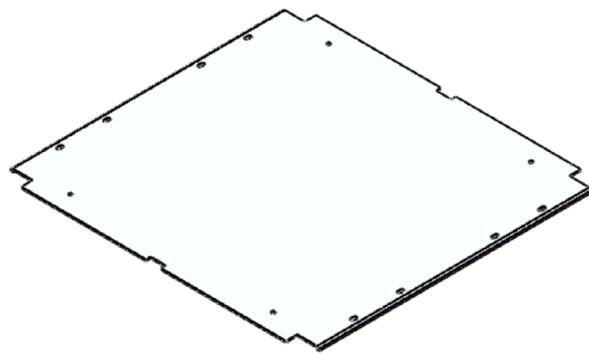
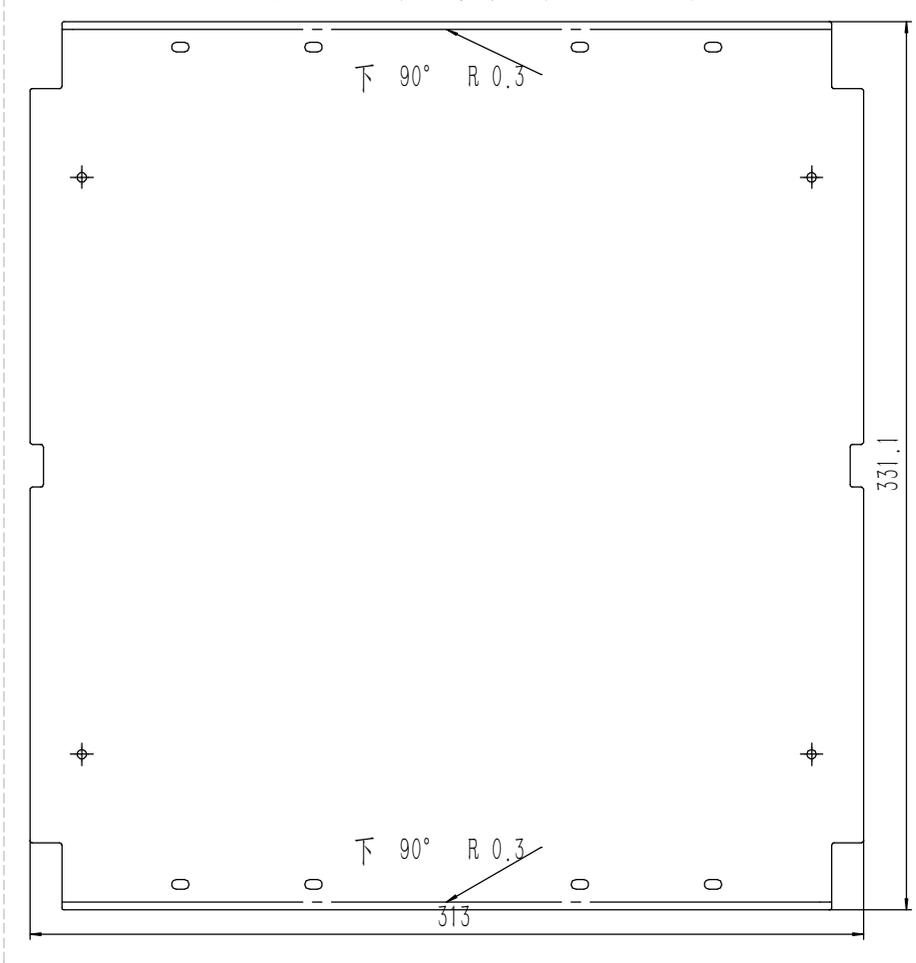
技术要求:

- 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):	0.933	
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):	Drawing Number (图号):
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	前后面板-4U		YG-TY-A12-008
	Drawn by (绘图): 莫永康	Date (日期): 2020.05.18	Size: (图幅): A1
	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

YONGU 永固

钣金展开及折弯方向参考图 (视图比例1:1)



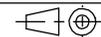
业务代码:

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。

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	YONGU 永固
	Weight: (重量) (Kg): 0.410	
	Protection: (表面处理):	
	Part Name (零/部件名称): A垫板	Drawing Number (图号): YG-TY-A13-007
Drawn by (绘图): 许宏彬	Date (日期): 2020.09.17	Size: (图幅): A1
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