

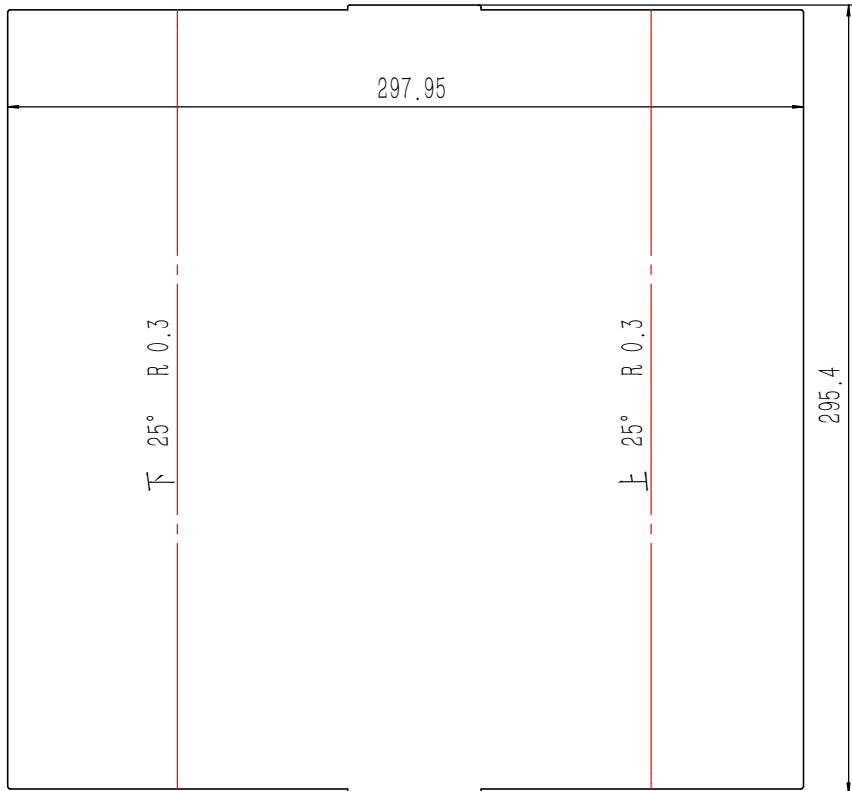
技术要求:

- 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。

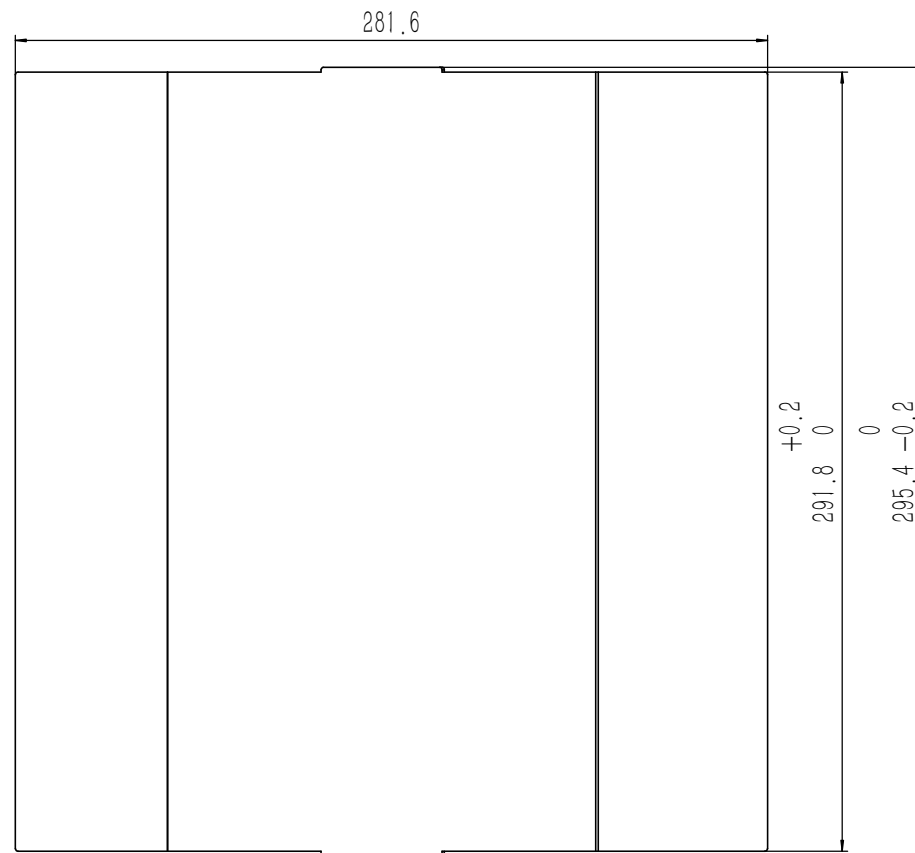
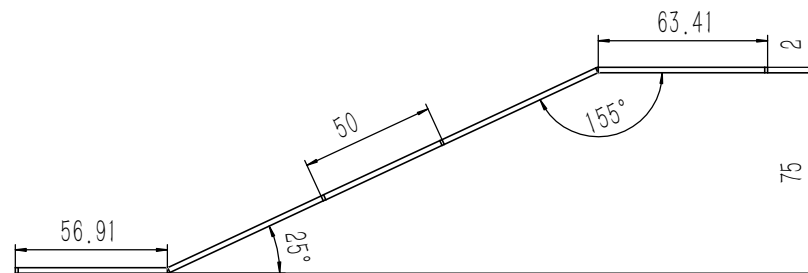
10	YG-N101-0000-006	左侧板	5052-H32	1	0.327	
9	YG-N101-0000-001	上盖板	5052-H32	1	0.467	
8	YG-N101-0000-009	支柱B	6063-T5	2	0.152	
7	GB-T-819.1-2000-C-NI-M3X6	碳钢镀镍十字沉头螺丝M3X6	普通碳钢	6	0.0004	
6	YG-N101-0000-004	后挡板	5052-H32	1	0.176	
5	YG-N101-0000-008	支柱A	6063-T5	2	0.153	
4	YG-N101-0000-005	右侧板	5052-H32	1	0.327	
3	GB-T-819.1-2000-C-NI-M4X10	碳钢镀镍十字沉头螺丝M4X10	普通碳钢	8	0.001	
2	YG-N101-0000-002	前挡板	5052-H32	1	0.073	
1	YG-N101-0000-003	下盖板	5052-H32	1	0.442	

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)		<b>YONGU</b> 永固		
0.5 to 6 ± 0.1		Weight: (重量) (Kg): 2.433				
6 to 30 ± 0.2		Protection: (表面处理):		Drawing Number (图号):		
30 to 120 ± 0.3		Part Name (零/部件名称):		YG-N101-0000-000		
120 to 400 ± 0.4		N101控制台机箱		Size (图幅): A0		
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°		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				Scale (比例): 1:1		Sheet (页数):
				Revision (版本): A1		1 / 1

业务代码:



钣金展开及折弯方向参考图 (视图比例1: 1)



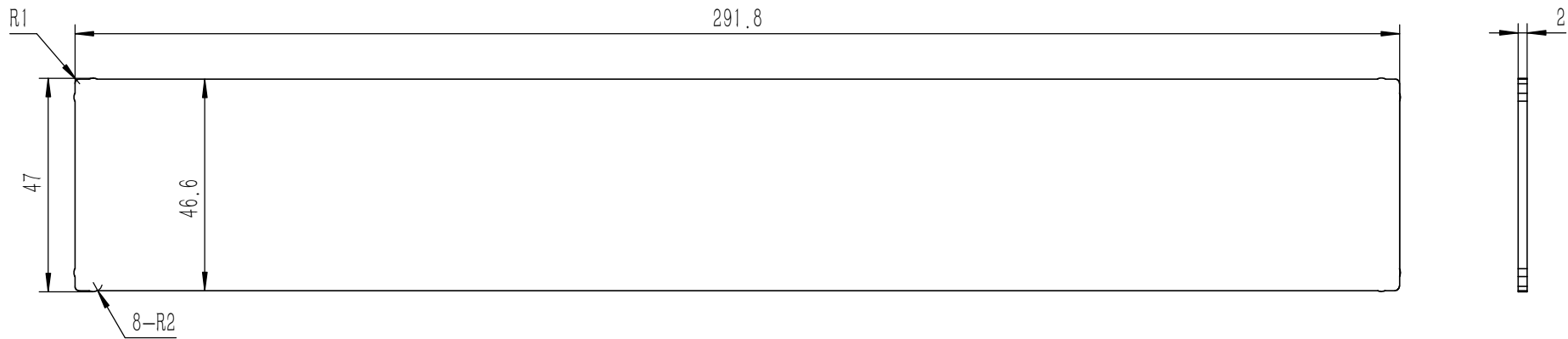
技术要求:

- 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:

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
	Weight: (重量) (Kg): 0.467	
Protection: (表面处理):	Part Name (零/部件名称): 上盖板	Drawing Number (图号): YG-N101-0000-001
Drawn by (绘图): 邓展锋	Date (日期): 2022.10.17	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

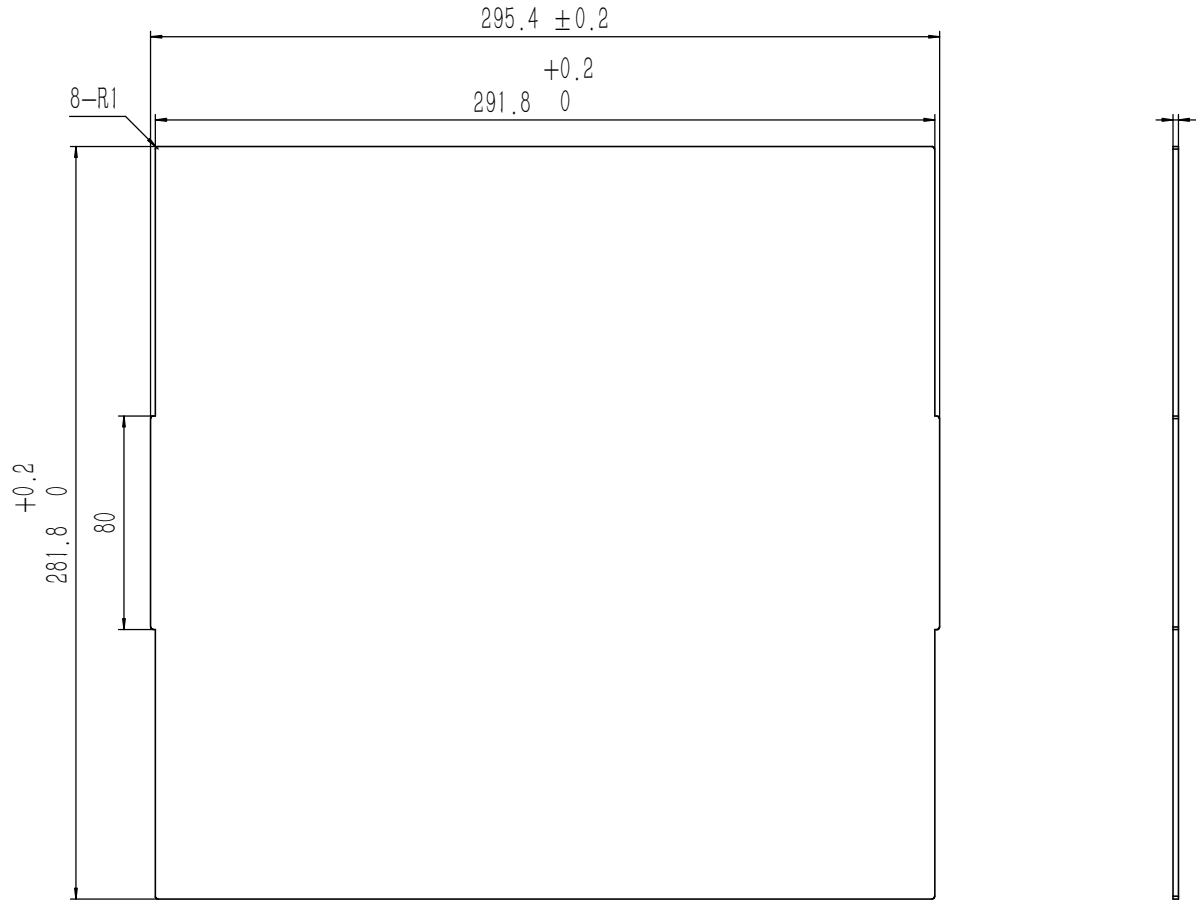


技术要求:

- 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°	Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	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
		Weight: (重量) (Kg) 0.073	Protection: (表面处理):	
Position tolerances (未注位置公差): ±0.05		Part Name (零/部件名称): 前挡板	Drawing Number (图号): YG-N101-0000-002	
		Drawn by (绘图): 邓展锋	Date (日期): 2022.10.17	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



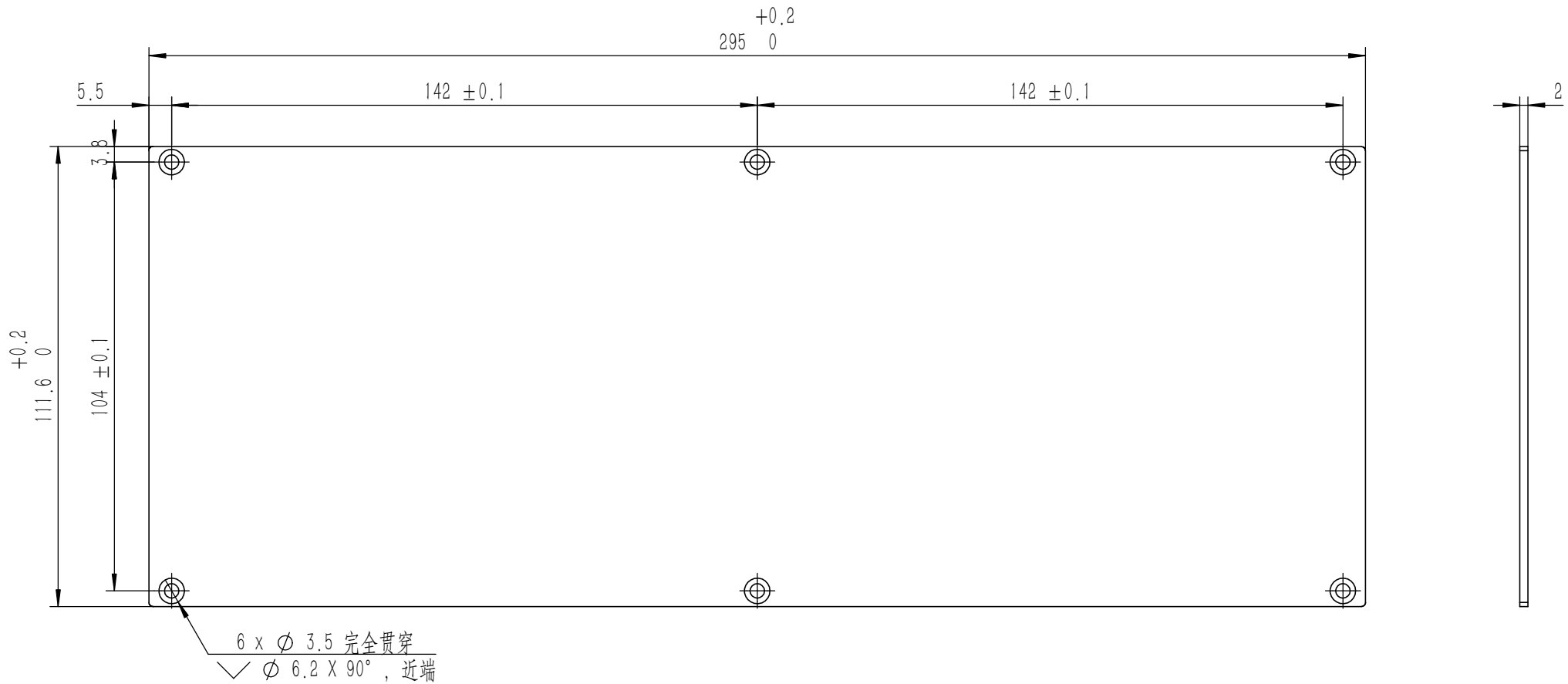
技术要求:

- 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:

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	

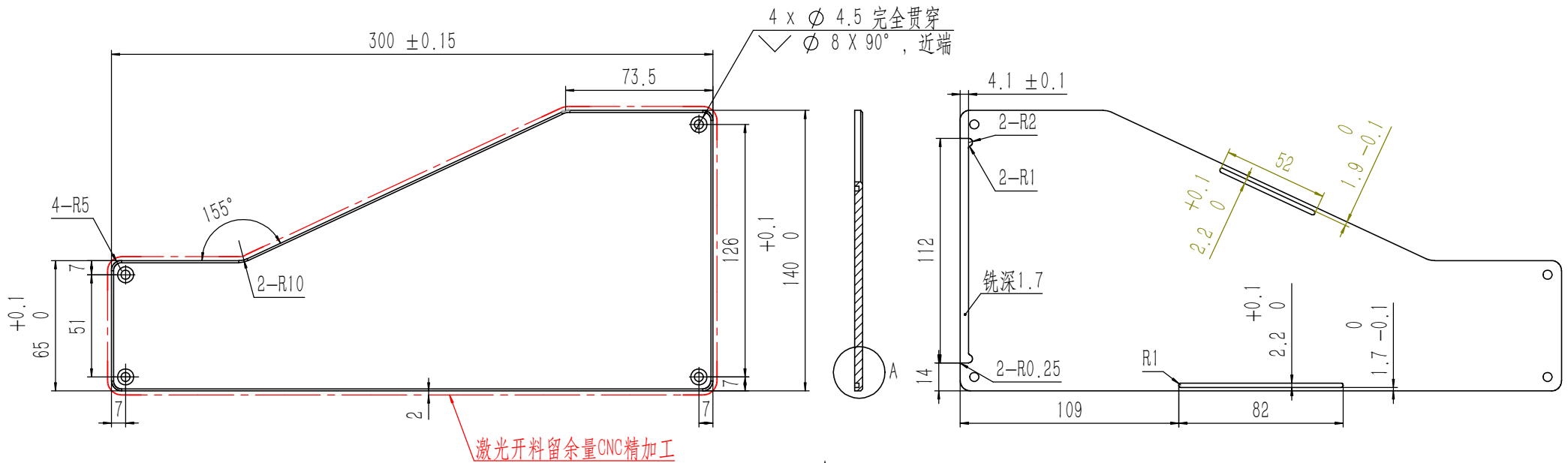
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): 5052-H32	<b>YONGU</b> 永固
	Weight: (重量) (Kg): 0.442	
Protection: (表面处理):	Part Name (零/部件名称): 下盖板	
	Drawing Number (图号): YG-N101-0000-003	
Drawn by (绘图): 邓展锋	Date (日期): 2022.10.17	Size: (图幅): A1
Check by (校对):	Date (日期):	Scale (比例): 1:1
Signature by (批准):	Date (日期):	Revision (版本): A1
		Sheet (页数): 1 / 1



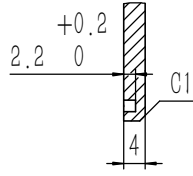
- 技术要求:
- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
  - 2、去除毛刺飞边, 锐角倒钝;
  - 3、未标注尺寸见3D数模。

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) 0.176	
Position tolerances (未注位置公差): ±0.05	Part Name (零/部件名称): 后挡板	Drawing Number (图号): YG-N101-0000-004	
	Drawn by (绘图): 邓展锋	Date (日期): 2022.10.17	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



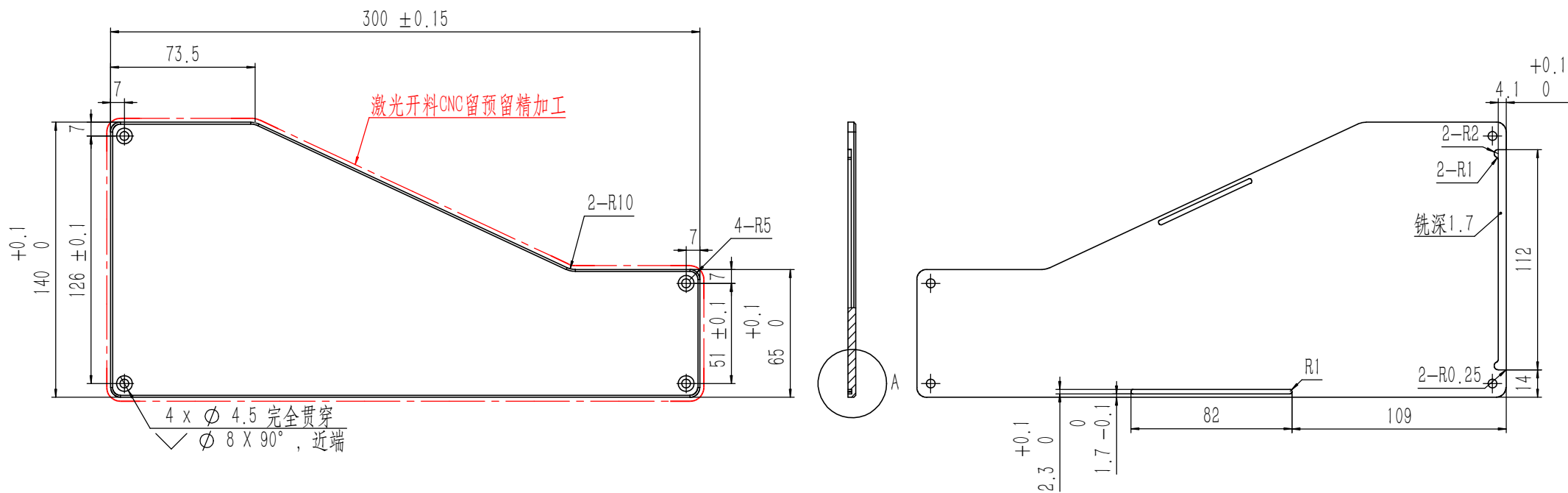
A  
2 : 1



- 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:

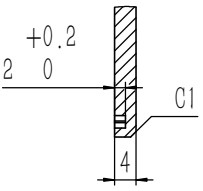
Tolerances (未注公差): 0.5 to 6 $\pm 0.1$ 6 to 30 $\pm 0.2$ 30 to 120 $\pm 0.3$ 120 to 400 $\pm 0.4$	Material (材料):	5052-H32	<b>YONGU</b> 永固
	Weight: (重量) (Kg):	0.327	
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):		Drawing Number (图号): YG-N101-0000-005
	Position tolerances (未注位置公差): $\pm 0.05$	Part Name (零/部件名称):	
Angular tolerances (未注角度公差): <6° $\pm 10'$ <30° $\pm 20'$ <120° $\pm 30'$ >120° $\pm 1^\circ$	Drawn by (绘图): 邓展锋	Date (日期): 2022.10.17	Size: (图幅): A1
	Signature by (批准):	Date (日期):	Scale (比例): 1:1
		Date (日期):	Revision (版本): A1
			Sheet (页数): 1 / 1



4 x  $\phi 4.5$  完全贯穿  
 $\phi 8 \times 90^\circ$ , 近端

激光开料CNC留预留精加工

A  
2 : 1

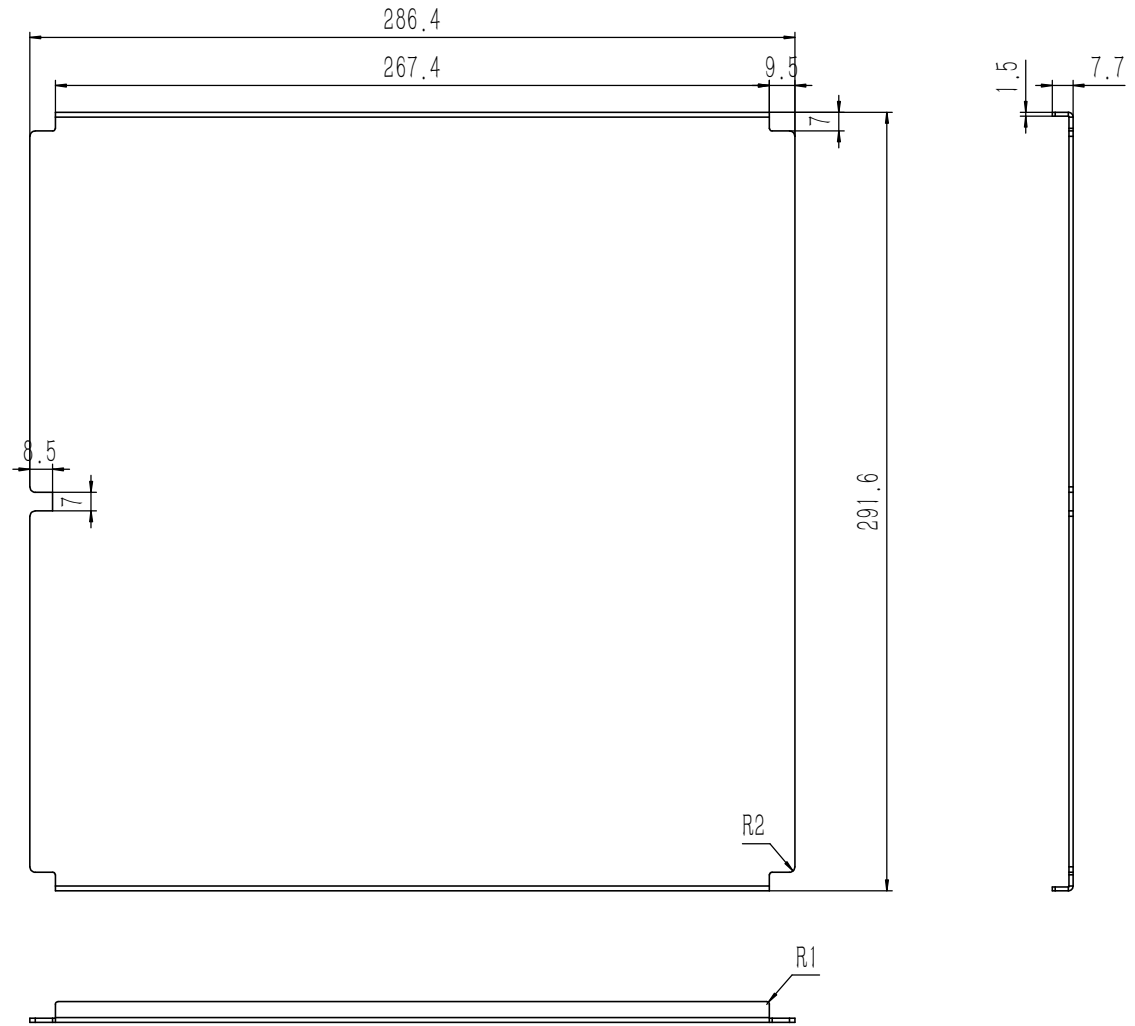
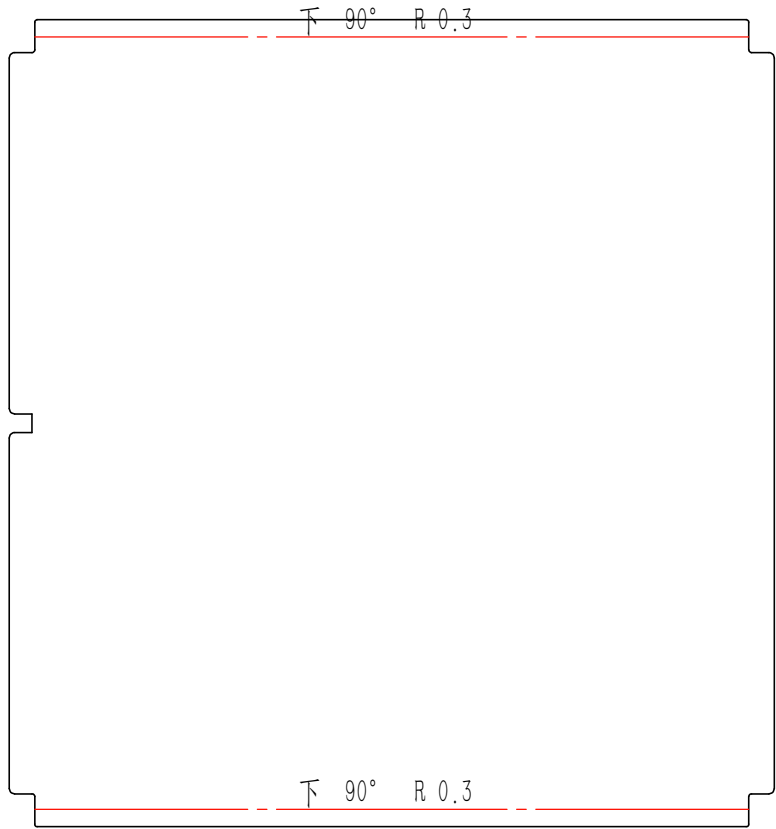


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- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
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  - 3、未标注尺寸见3D数模。

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	<b>YONGU</b> 永固				
	Weight: (重量) (Kg):	0.327					
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-N101-0000-006				
	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):	2022.10.17	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)



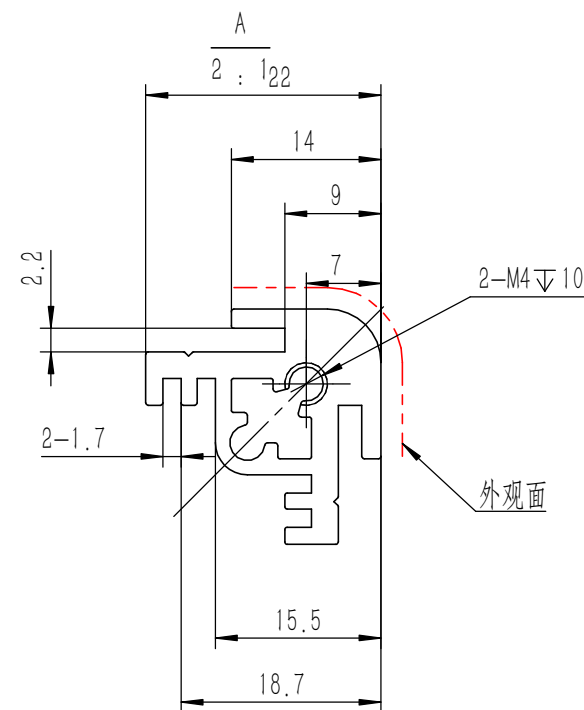
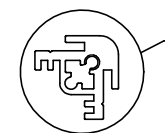
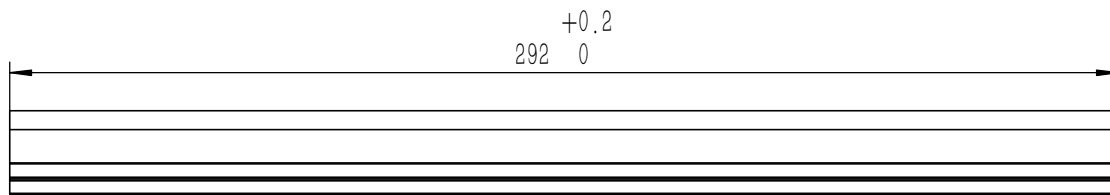
技术要求:

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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		<b>YONGU</b> 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): YG-N101-0000-007
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): 邓展锋 Date (日期): 2022.10.24	Size: (图幅): A1 Scale (比例): 1:1	Sheet (页数): 1 / 1
	Signature by (批准): Date (日期):	Revision (版本): A1		



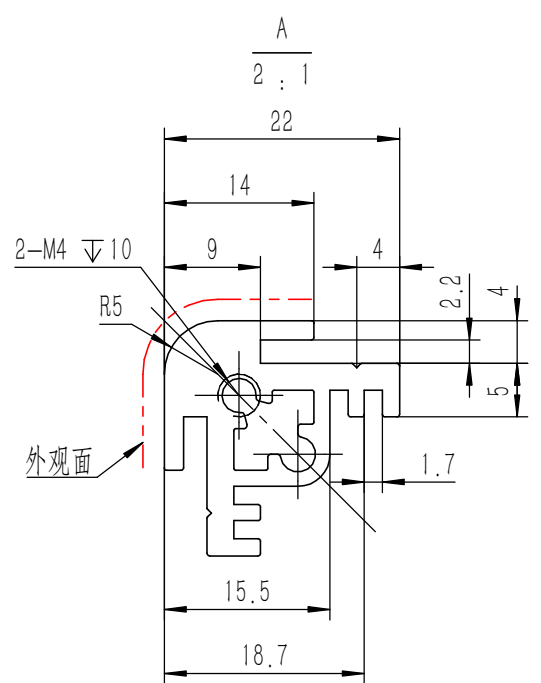
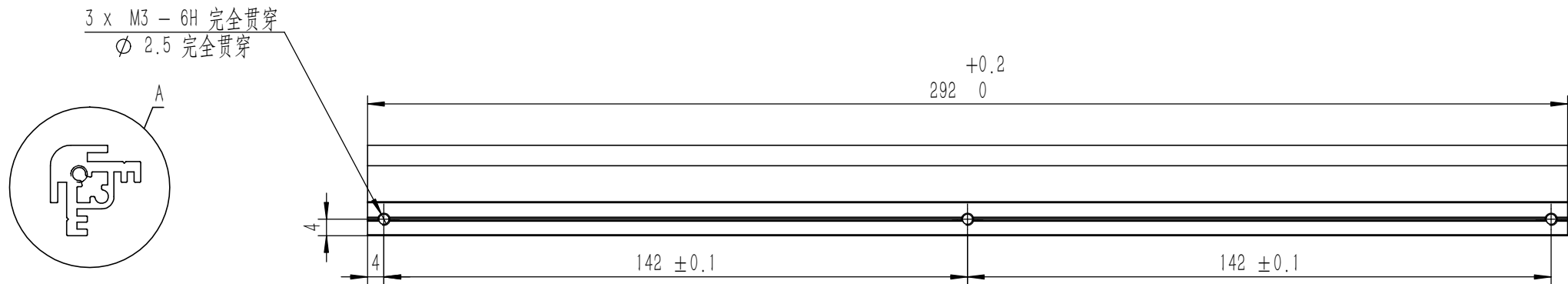


技术要求:

- 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。

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	<b>YONGU</b> 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-N101-0000-008
	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): 邓展锋	Date (日期): 2022.10.17	Size: (图幅): A3
		Check by (校对):	Date (日期):
	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:

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° $\pm 10'$ <30° $\pm 20'$ <120° $\pm 30'$ >120° $\pm 1^\circ$
Position tolerances (未注位置公差): $\pm 0.05$	

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	YONGU 永固
	Weight: (重量) (Kg) 0.152	
	Protection: (表面处理):	
	Part Name (零/部件名称): 支柱B	Drawing Number (图号): YG-N101-0000-009
	Drawn by (绘图): 邓展锋	Date (日期): 2022.10.17
	Check by (校对):	Date (日期):
	Signature by (批准):	Date (日期):
	Size: (图幅): A3	Sheet (页数): 1 / 1
	Scale (比例): 1:1	Revision (版本): A1