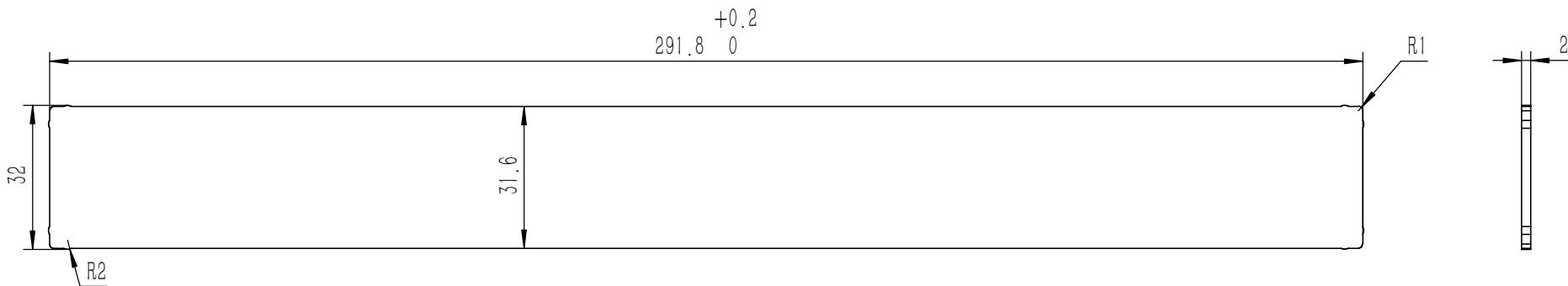


- 技术要求:
- 1、必须按照设计、工艺要求及本规定和有关标准进行装配;
 - 2、所有零部件(包括外购、外协件)必须具有检验合格证方能进行装配;
 - 3、零件在装配前必须清理和清洗干净,不得有毛刺、飞边、氧化皮、锈蚀、切屑、砂粒、灰尘和油污等,并应符合相应清洁度要求;
 - 4、装配过程中零件不得磕碰、划伤和锈蚀;
 - 5、油漆未干的零件不得进行装配;
 - 6、相对运动的零件,装配时接触面间应加润滑油脂;
 - 7、各零、部件装配后相对位置应准确。

| | | | | | | |
|----|----------------------------|-----------------|----------|----|--------|--|
| 11 | YG-N104-0000-001 | 通用挡板 | 5052-H32 | 1 | 0.049 | |
| 10 | YG-N104-0000-009 | 支柱B | 6063-T5 | 2 | 0.153 | |
| 9 | YG-N104-0000-008 | 支柱A | 6063-T5 | 3 | 0.153 | |
| 8 | GB-T-819.1-2000-C-NI-M4X10 | 碳钢镀镍十字沉头螺丝M4X10 | 普通碳钢 | 10 | 0.001 | |
| 7 | YG-N104-0000-002 | 前盖板 | 5052-H32 | 1 | 0.527 | |
| 6 | YG-N104-0000-004 | 右侧板 | 5052-H32 | 1 | 0.288 | |
| 5 | YG-N104-0000-010 | 通用挡板 | 5052-H32 | 1 | 0.049 | |
| 4 | YG-N104-0000-006 | 底板 | 5052-H32 | 1 | 0.363 | |
| 3 | YG-N104-0000-003 | 后挡板 | 5052-H32 | 1 | 0.350 | |
| 2 | 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 | |
| 1 | YG-N104-0000-005 | 左侧板 | 5052-H32 | 1 | 0.288 | |

| 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 | | Weight: (重量) (Kg): 2.691 | | | | |
| 6 to 30 ± 0.2 | | Protection: (表面处理): | | Drawing Number (图号): YG-N104-0000-000 | | |
| 30 to 120 ± 0.3 | | Part Name (零/部件名称): N104控制台机箱 | | Size (图幅): A0 | | |
| 120 to 400 ± 0.4 | | Date (日期): 2022.10.24 | | Scale (比例): 1:1 | | |
| Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45° | | Angular tolerances (未注角度公差): | | Sheet (页数): 1 / 1 | | |
| <6° ± 10' | | <30° ± 20' | | Revision (版本): A1 | | |
| <120° ± 30' | | >120° ± 1° | | Date (日期): | | |
| Position tolerances (未注位置公差): ±0.05 | | Date (日期): | | Date (日期): | | |

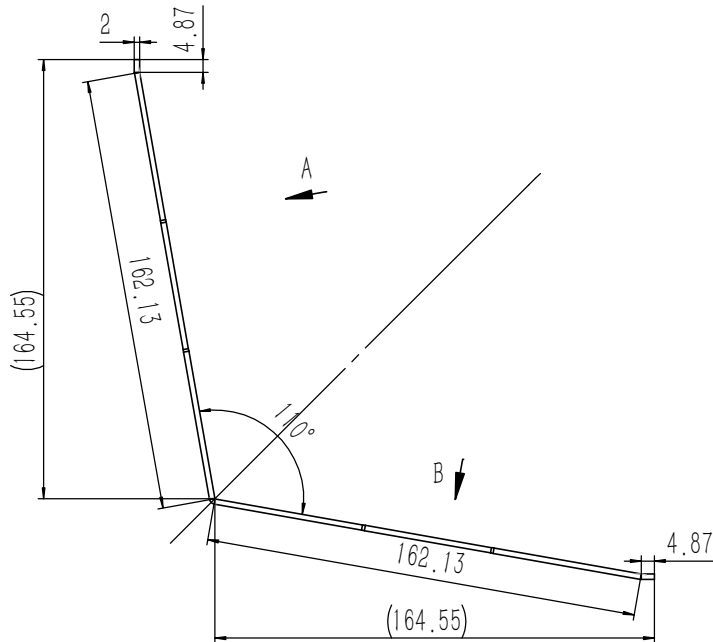
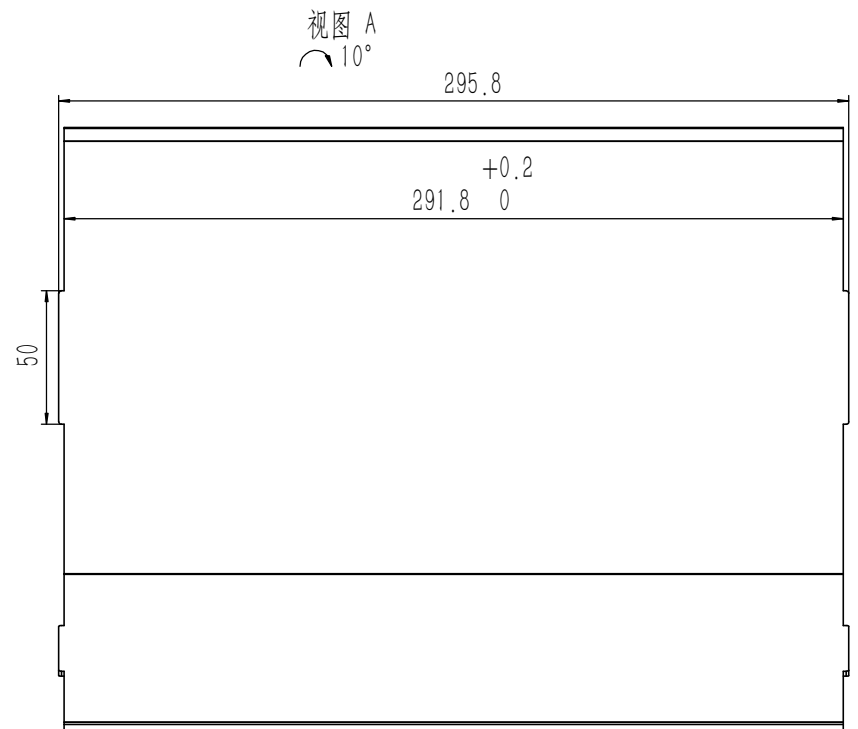
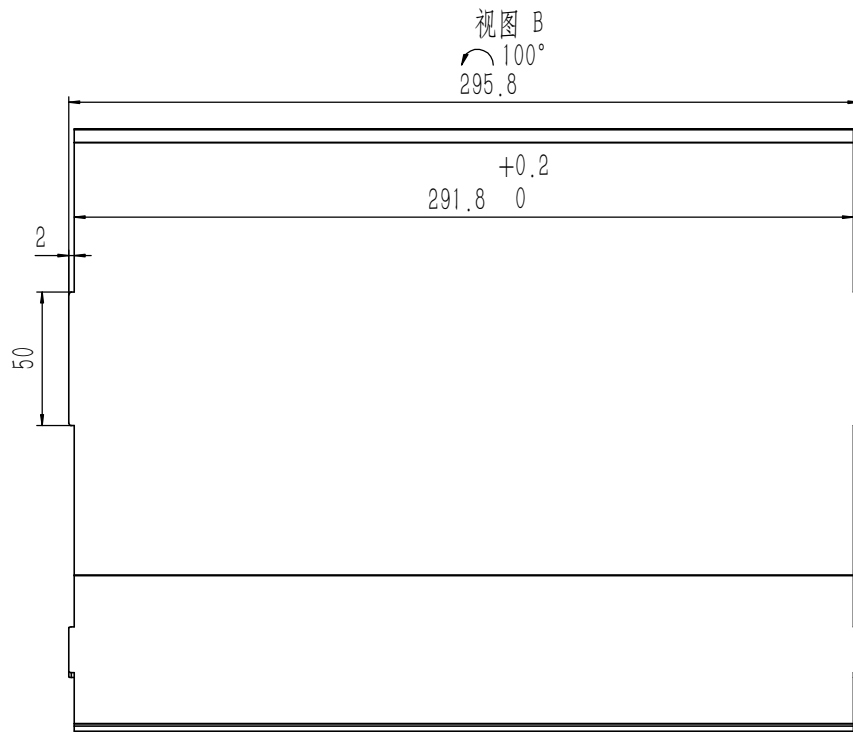
业务代码:



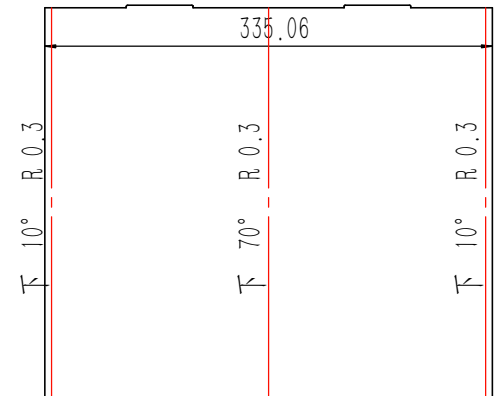
- 技术要求:
- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
 - 2、去除毛刺飞边,锐角倒钝;
 - 3、未标注尺寸见3D数模。

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) | 0.049 | | |
| 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): | 通用挡板 | | Drawing Number (图号): YG-N104-0000-001 |
| 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 |
| | Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1° | 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 |



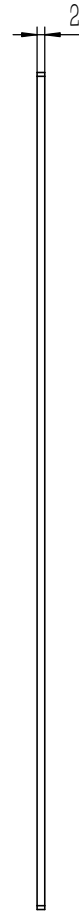
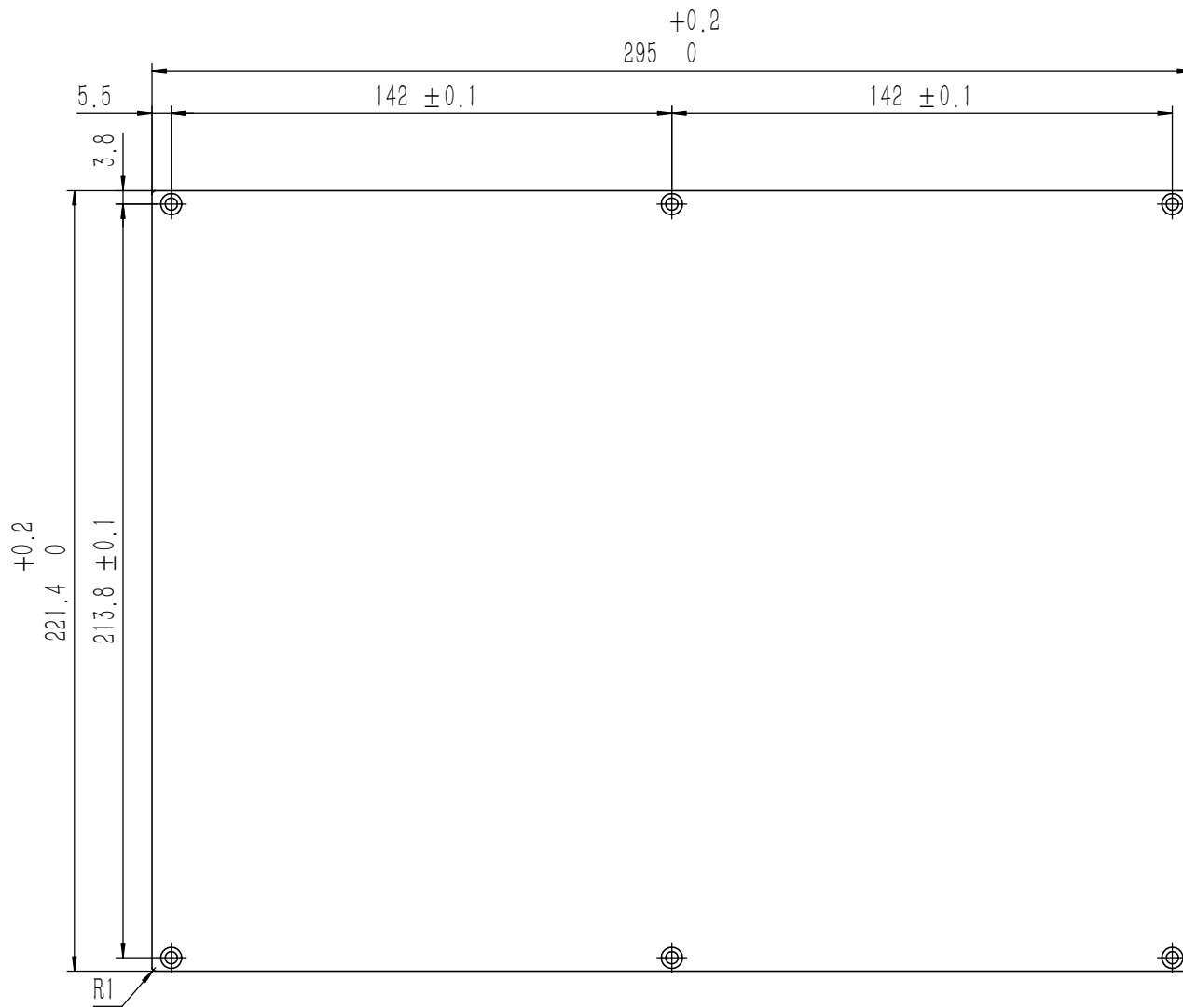
钣金展开及折弯方向参考图 (视图比例1:2)



- 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 | YONGU 永固 |
| | | Position tolerances (未注位置公差): ± 0.05 | Weight: (重量) (Kg): 0.526 | |
| Part Name (零/部件名称): 前盖板 | | | Protection: (表面处理): | Size: (图幅): A1 Scale (比例): 1:1 Revision (版本): A1 |
| Drawn by (绘图): 邓展锋 | | Date (日期): 2022.10.24 | Part Name (零/部件名称): 前盖板 | |
| Check by (校对): | | Date (日期): | Signature by (批准): | Date (日期): |

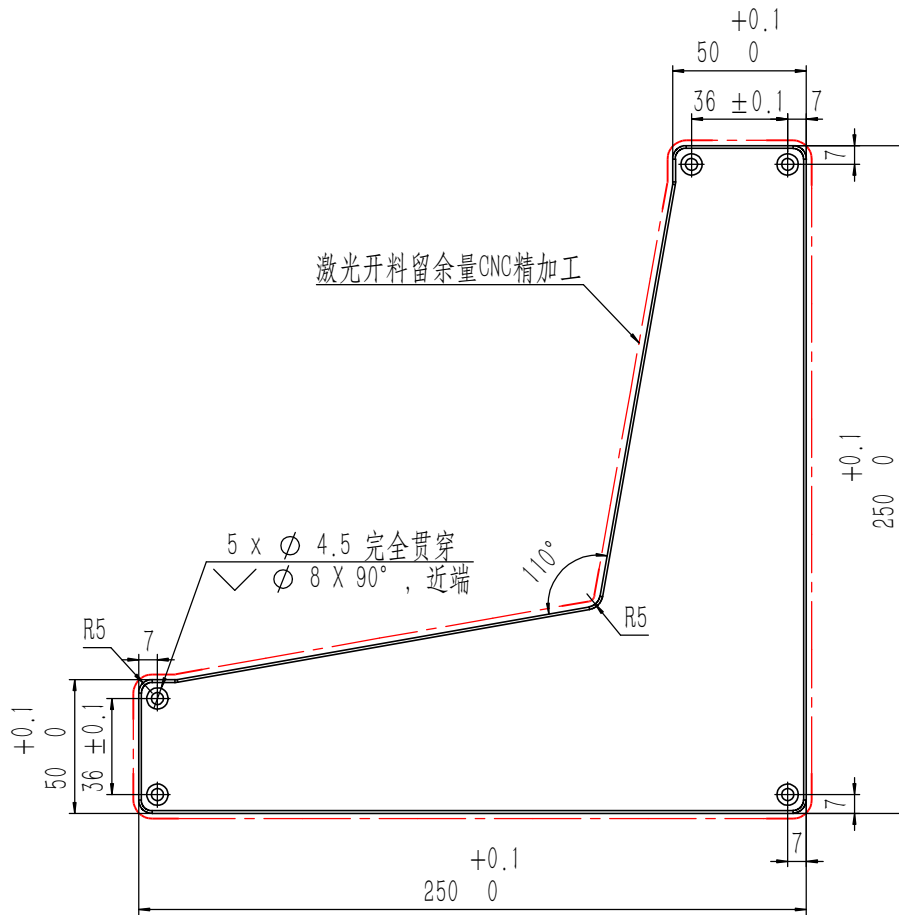


技术要求:

- 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。

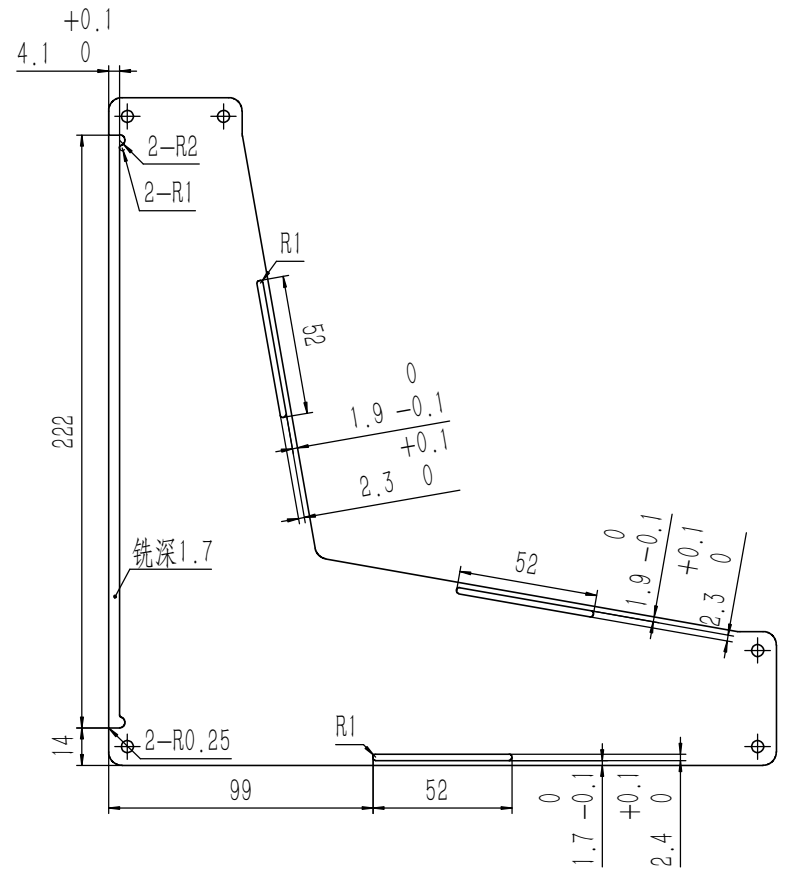
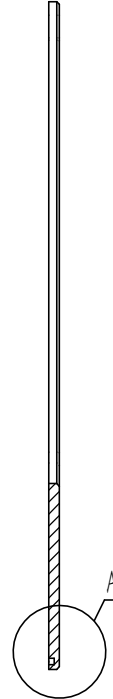
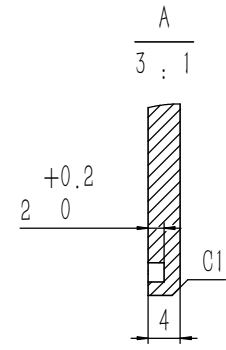
业务代码:

| | | | | |
|---|---|-----------------------|-------------------|----------------------|
| 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 |
| | Weight: (重量) (Kg): | 0.350 | | |
| 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): | 后挡板 | |
| 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 | | Drawing Number (图号): |
| | Drawn by (绘图): 邓展锋 | Date (日期): 2022.10.24 | Size: (图幅): A2 | YG-N104-0000-003 |
| | 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 | |



激光开料留余量CNC精加工

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

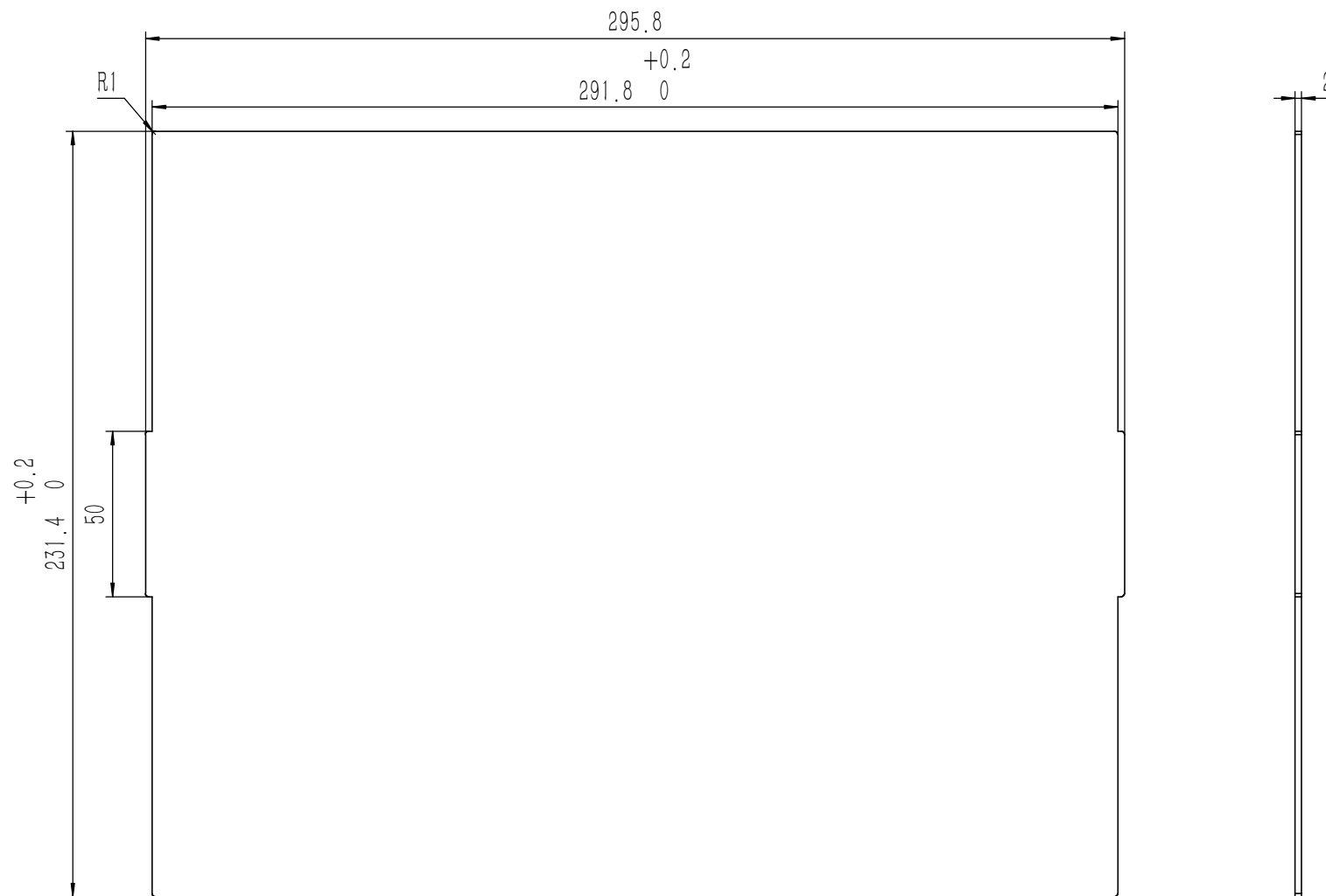


- 技术要求:
- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
 - 2、去除毛刺飞边, 锐角倒钝;
 - 3、未标注尺寸见3D数模。

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 | YONGU 永固 |
| Weight: (重量) (Kg): 0.288 | Protection: (表面处理): | |
| Part Name (零/部件名称): 右侧板 | Drawing Number (图号): YG-N104-0000-004 | |
| Drawn by (绘图): 邓展锋 | Date (日期): 2022.10.24 | 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:

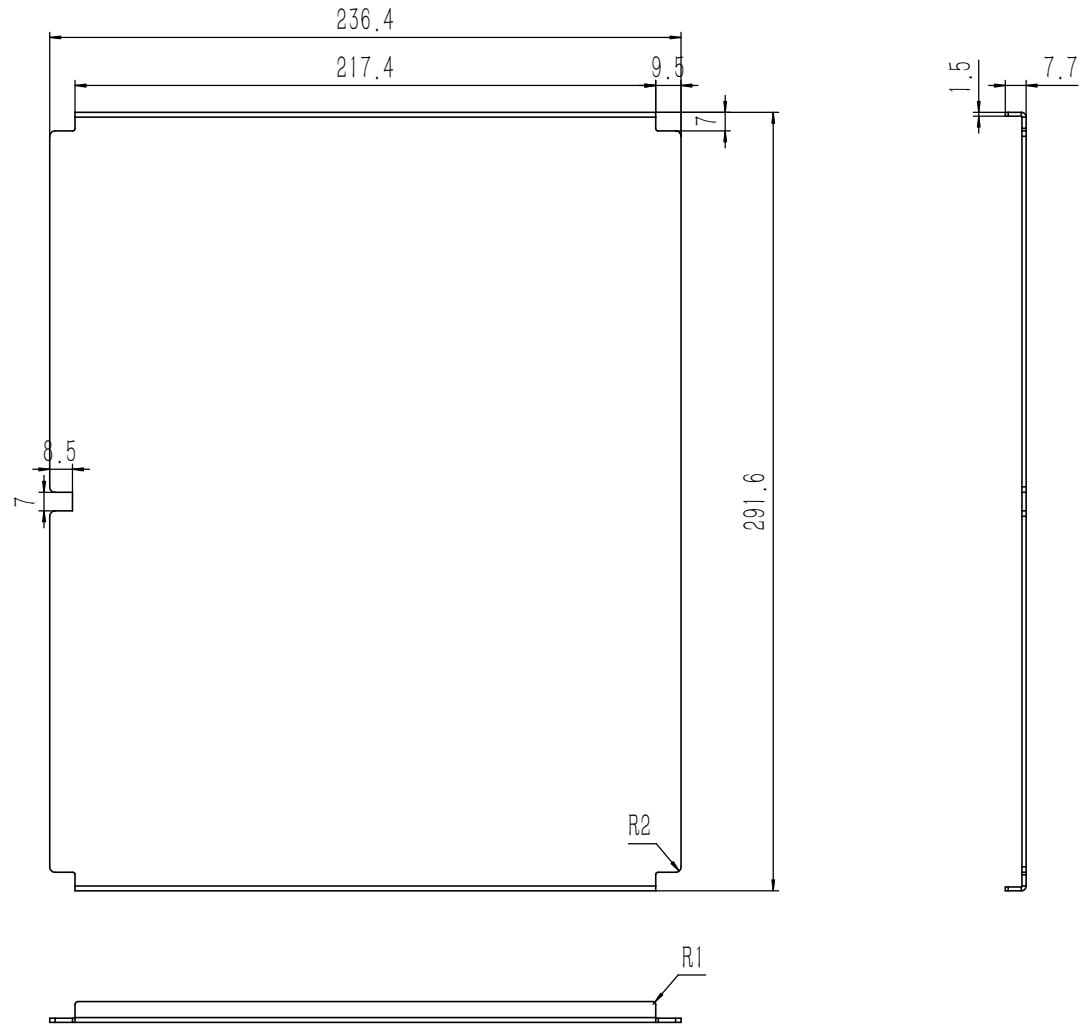
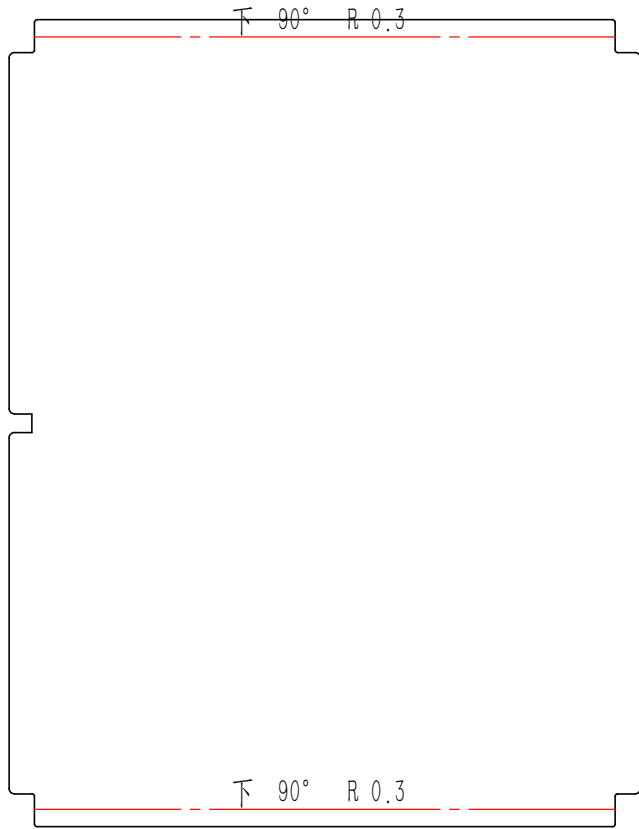
- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
- 2、去除毛刺飞边, 锐角倒钝;
- 3、未标注尺寸见3D数模。

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° |
| 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  |
| | Weight: (重量) (Kg): 0.363 | |
| Protection: (表面处理): | Part Name (零/部件名称): 底板 | |
| | Drawing Number (图号): YG-N104-0000-006 | |
| Drawn by (绘图): 邓展锋 | Date (日期): 2022.10.24 | Size (图幅): A2 |
| 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 |

钣金展开及折弯方向参考图 (视图比例1:1)



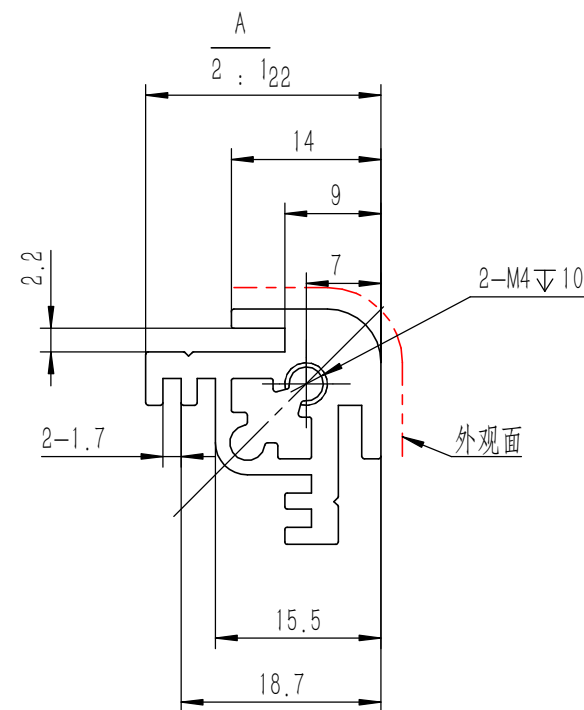
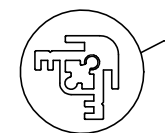
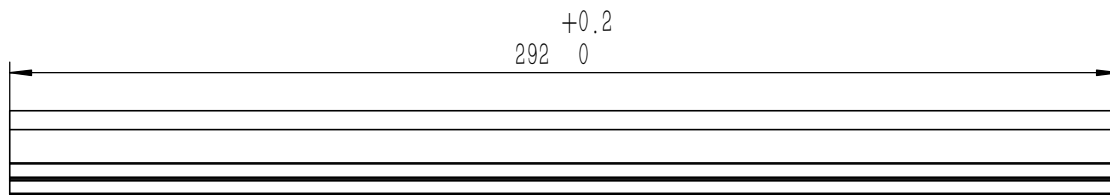
技术要求:

- 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 | YONGU 永固 |
| | Weight: (重量) (Kg): 0.286 | |
| | Protection: (表面处理): | Drawing Number (图号): YG-N104-0000-007 |
| | Part Name (零/部件名称): 附件-安装衬板 | |
| | 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 | Sheet (页数): 1 / 1 |
| | Scale (比例): 1:1 | Revision (版本): A1 |

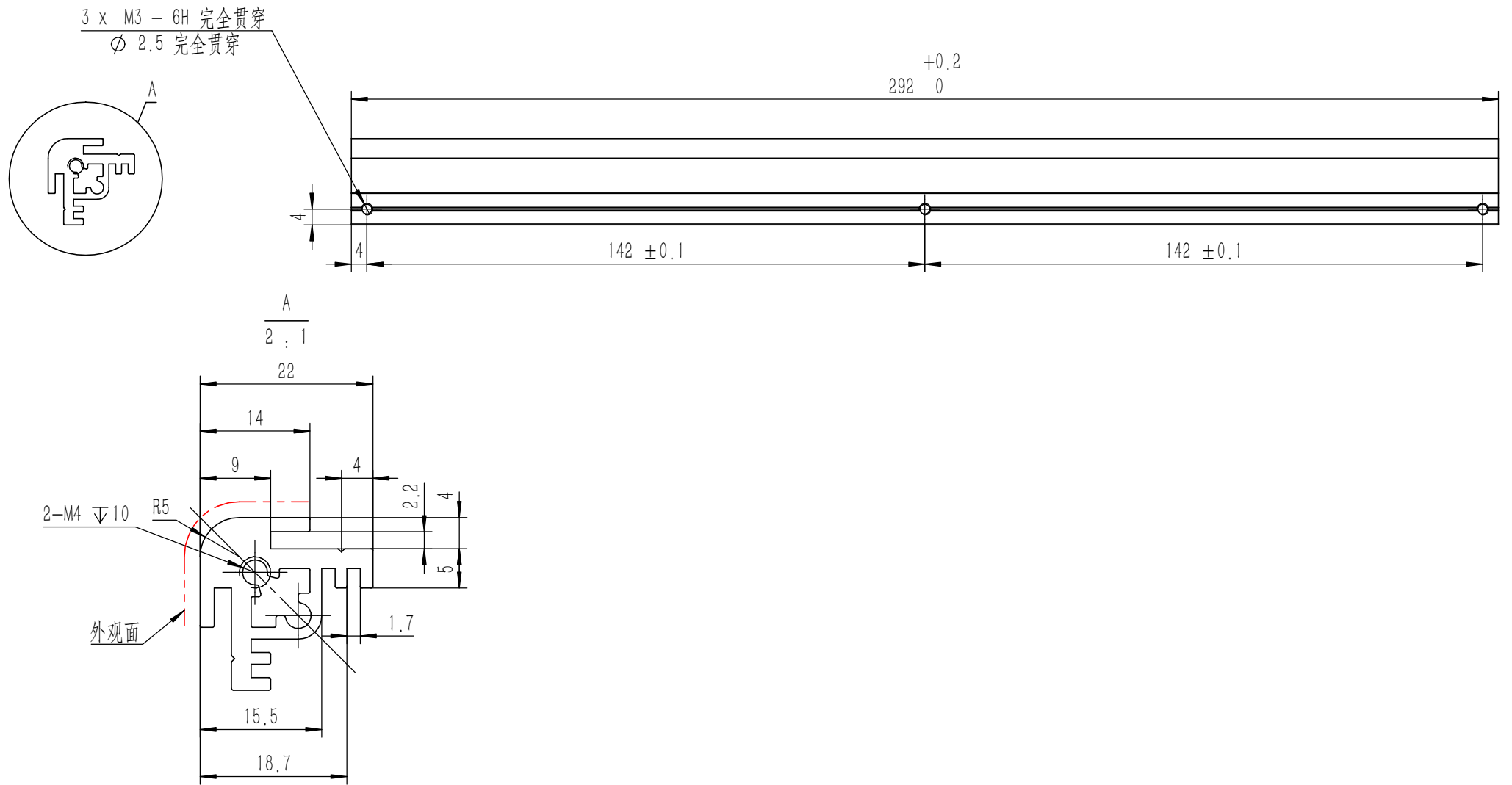


技术要求:

- 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:

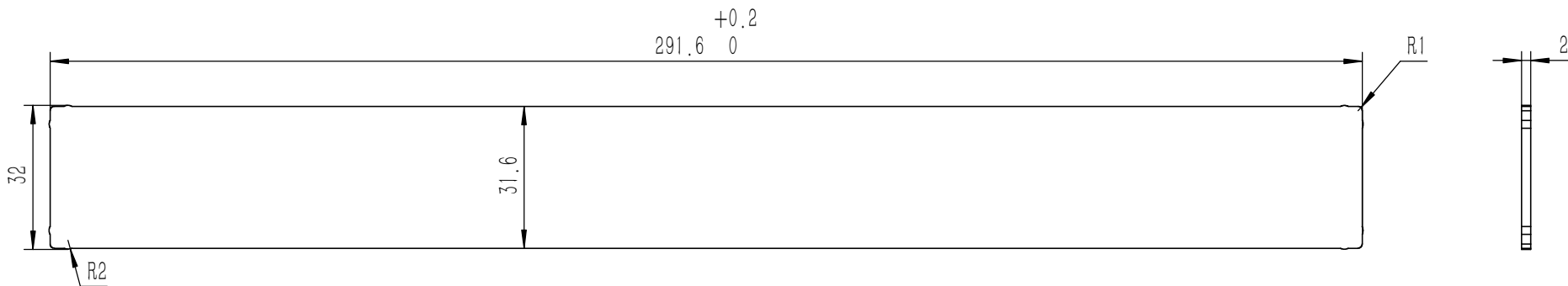
| | | | | |
|--|---------------------------------|---------------------|---------|----------------------|
| Tolerances (未注公差): | | Material (材料): | 6063-T5 | YONGU |
| 0.5 to 6 | ± 0.1 | Weight: (重量) (Kg) | 0.153 | |
| 6 to 30 | ± 0.2 | Protection: (表面处理): | | |
| 30 to 120 | ± 0.3 | Part Name (零/部件名称): | 支柱A | Drawing Number (图号): |
| 120 to 400 | ± 0.4 | | | YG-N104-0000-008 |
| 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): |
| | <6° $\pm 10'$ | | | 2022.10.24 |
| | <30° $\pm 20'$ | Check by (校对): | | Date (日期): |
| | <120° $\pm 30'$ | Signature by (批准): | | Date (日期): |
| | >120° $\pm 1^\circ$ | | | Date (日期): |
| Position tolerances (未注位置公差): | | | | Size: (图幅): |
| ± 0.05 | | | | A3 |
| | | | | Scale (比例): |
| | | | | 0.71:1 |
| | | | | 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): | 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-N104-0000-009 |
| | Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1° | Part Name (零/部件名称): | |
| 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): |
| | | 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:

| | |
|--|---|
| 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) 0.049 | | |
| | Part Name (零/部件名称): 通用挡板 | Drawing Number (图号): YG-N104-0000-010 | |
| | 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 |