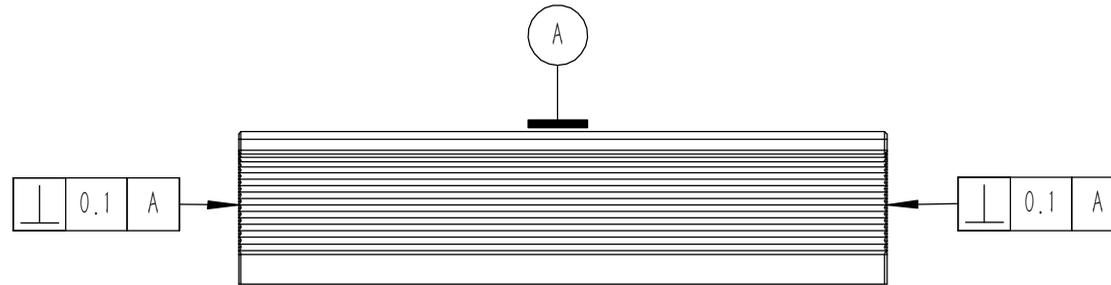
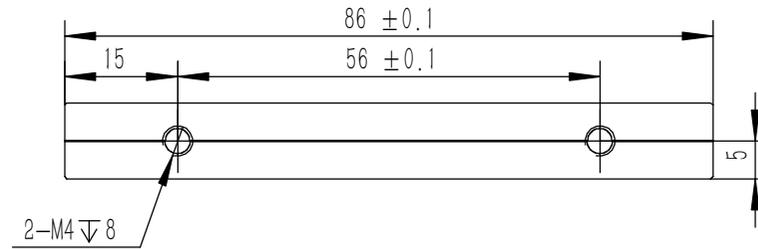
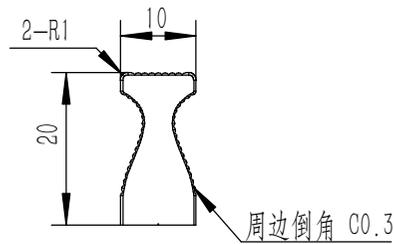


技术要求:

- 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。

19	YG-C22B-0000-002	后面板	5052-H32	1	0.511	
18	YG-C22B-0000-006	组合侧板 2U-50	6063-T5	2	0.066	
17	GB-T-819.1-2000-C-NI-M3X6	碳钢镀镍十字沉头螺丝M3X6	普通碳钢	16	0.0004	
16	YG-C22B-0000-005	组合侧板 2U-100	6063-T5	4	0.119	
15	YG-C22B-0000-009	侧板固定 2U	6063-T5	4	0.023	
14	YG-C22B-0000-001	前面板	5052-H32	1	0.569	
13	S-M3-1-ZI	压铆螺母镀白锌M3X1	普通碳钢	8	0.3750	
12	YG-C22B-0000-004	垫板	电解板	1	0.920	
11	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	
10	GB-T-819.1-2000-C-NI-M4X8	碳钢镀镍十字沉头螺丝M4X8	普通碳钢	8	0.001	
9	GB-T-973-1976-C-NI-M3X6	碳钢镀镍十字大扁头螺丝M3X6	普通碳钢	8	0.0006	
8	GB-T-973-1976-C-NI-M3X4	碳钢镀镍十字大扁头螺丝M3X4	普通碳钢	28	0.0005	
7	盲孔压铆螺母镀白锌M3X5	压铆螺母柱 M3X5	普通碳钢	8	0.001	
6	YG-C22B-0000-010	侧板连接件 2U	电解板	4	0.022	
5	YG-C22B-0000-012	面板下固定件	电解板	2	0.067	
4	YG-C22B-0000-007	拉手 2U	6063-T5	2	0.080	
3	YG-C22B-0000-003	盖板	5052-H32	2	0.760	
2	YG-C22B-0000-011	面板上固定件	电解板	2	0.061	
1	YG-C22B-0000-008	后防护条 2U	6063-T5	2	0.035	
序号	图号	名称	材料	数量	单重	备注

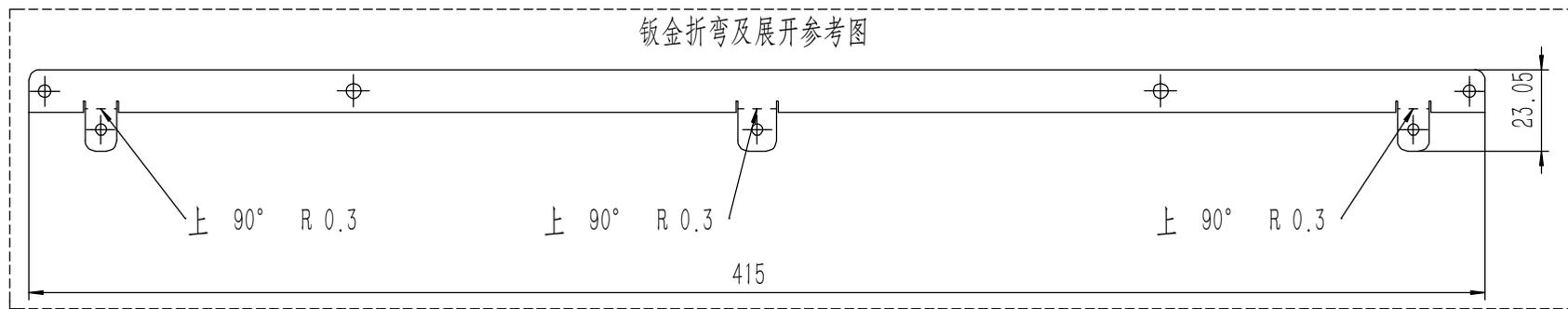
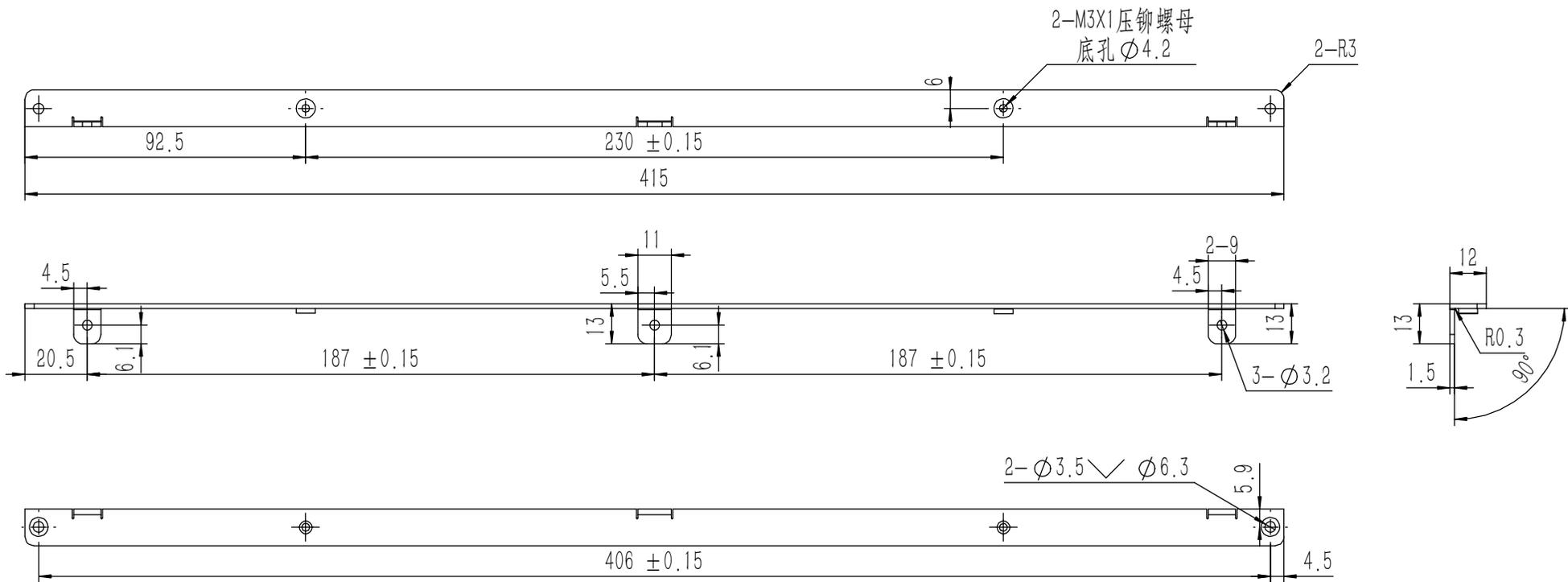
Tolerances (未注公差):		Material (材料): (装配图)		YONGU 永固	
0.5 to 6 ± 0.1	6 to 30 ± 0.2	Weight: (重量) (Kg):	4.843		
30 to 120 ± 0.3	120 to 400 ± 0.4	Protection: (表面处理):			
Part Name (零/部件名称):		C22B机箱		Drawing Number (图号): YG-C22B-0000-000	
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Angular tolerances (未注角度公差): <6° ± 10'	Drawn by (绘图): 莫永康	Date (日期): 2020.05.27	Size (图幅): A0	Sheet (页数): 1 / 1
Position tolerances (未注位置公差): ± 0.05	<30° ± 20'	Check by (校对):	Date (日期):	Scale (比例): 1:1	Revision (版本): A1
	<120° ± 30'	Signature by (批准):	Date (日期):		
	>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。

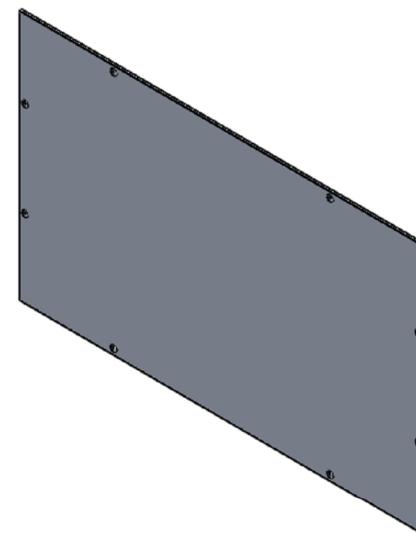
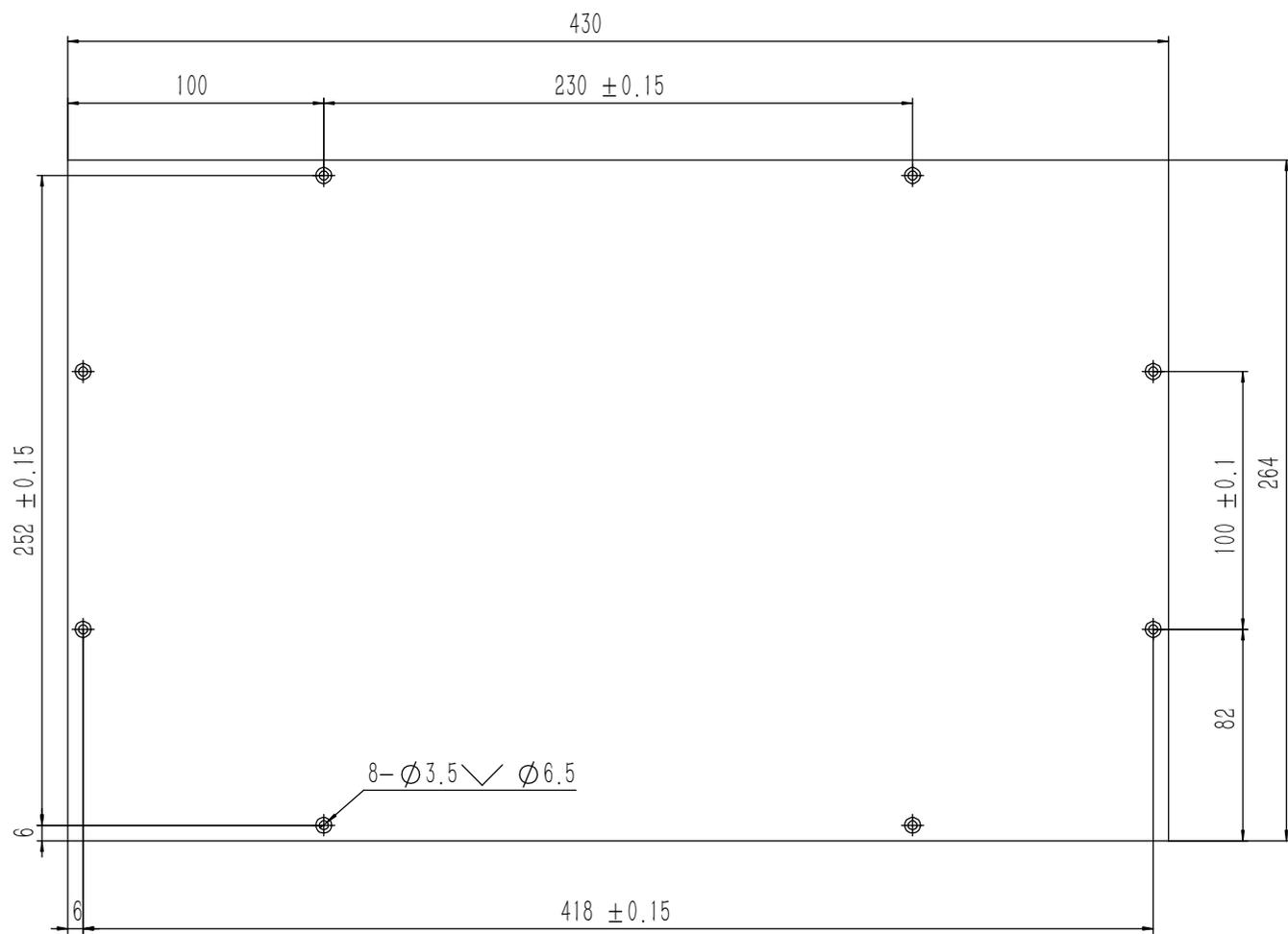
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): 6063-T5	YONGU 永固	
	Weight: (重量) (Kg) 0.035		
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):	Part Name (零/部件名称): 后防护条 2U	
	Position tolerances (未注位置公差): ±0.05	Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Drawing Number (图号): YG-C22B-0000-008
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	Check by (校对):	Date (日期):	Scale (比例): 1:1
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			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):	电解板	
	Weight: (重量) (Kg):	0.061	
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):	面板上固定件
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Drawn by (绘图):	莫永康	Date (日期): 2020.05.26
	Check by (校对):		Date (日期):
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Drawing Number (图号):			YG-C22B-0000-011
Size: (图幅): A2		Sheet (页数): 1 / 1	
Scale (比例): 1:1		Revision (版本): A1	

YONGU 永固

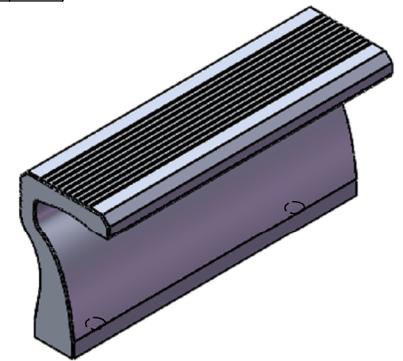
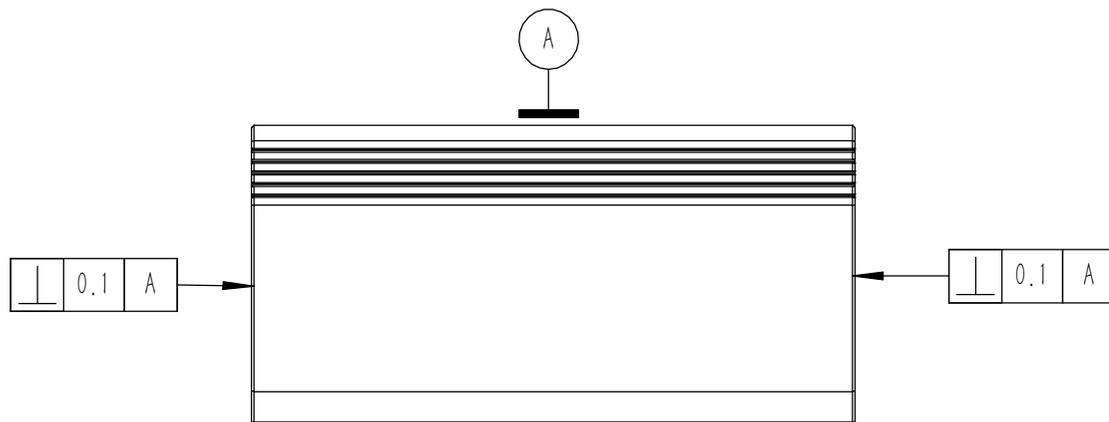
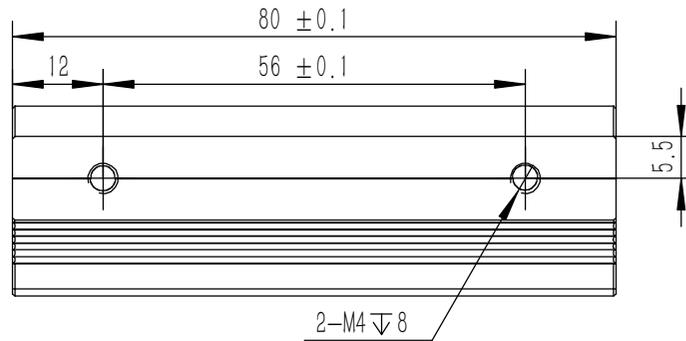
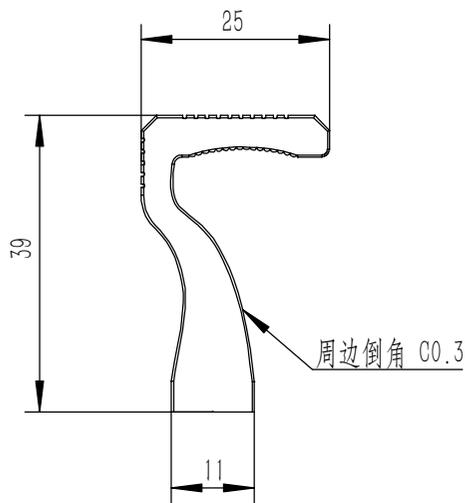


技术要求:

- 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):	0.760	
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):	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°	Drawing Number (图号):	YG-C22B-0000-003
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		Sheet (页数):	1 / 1

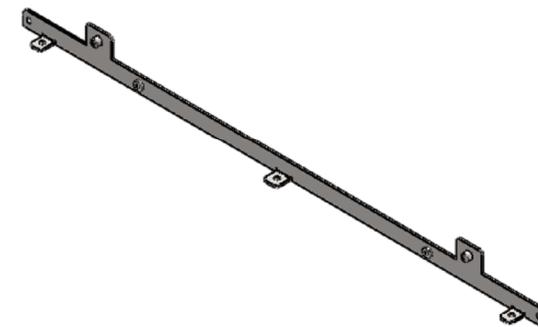
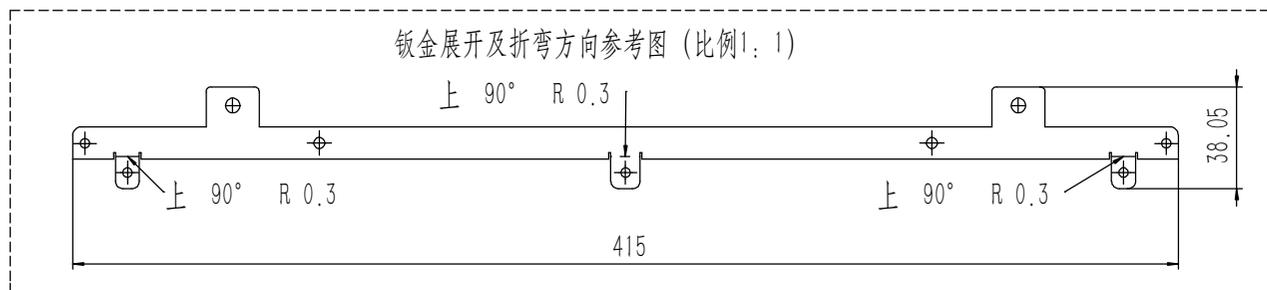
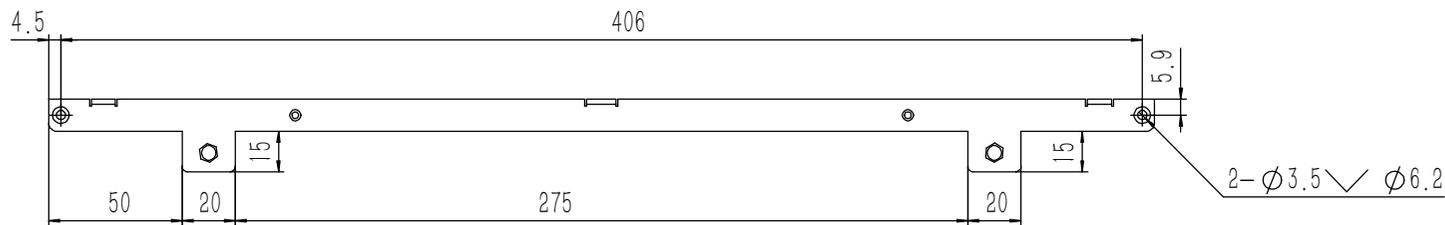
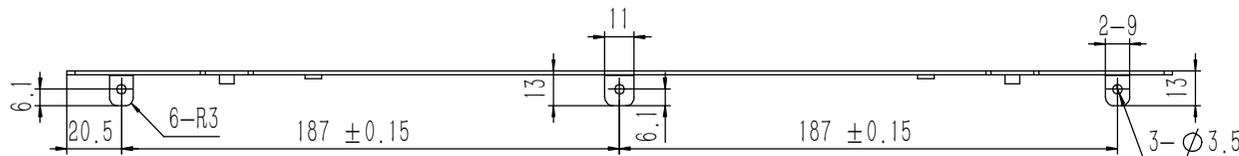
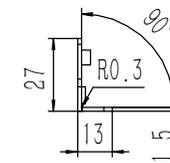
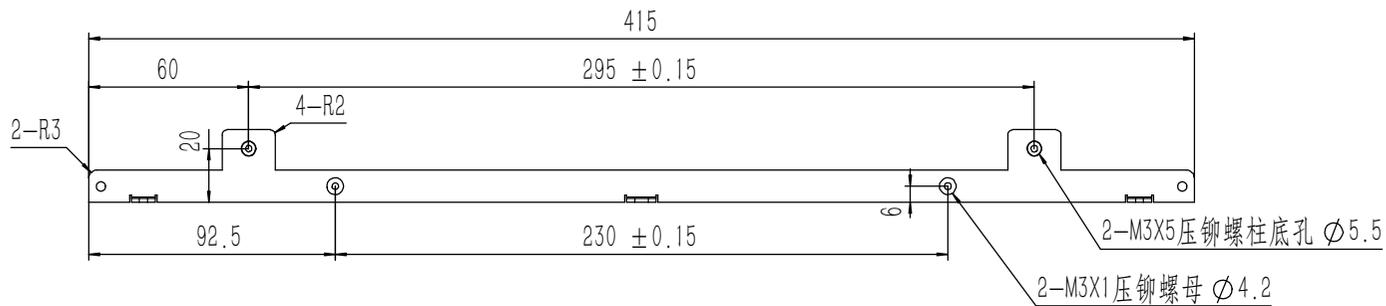
YONGU 永固



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。

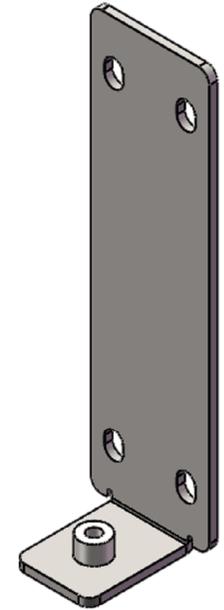
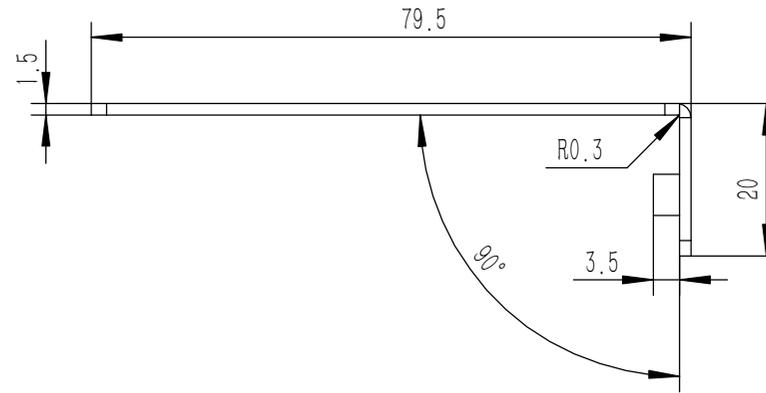
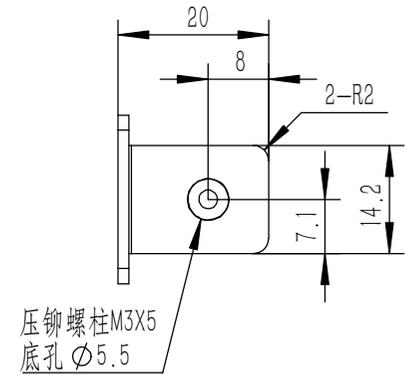
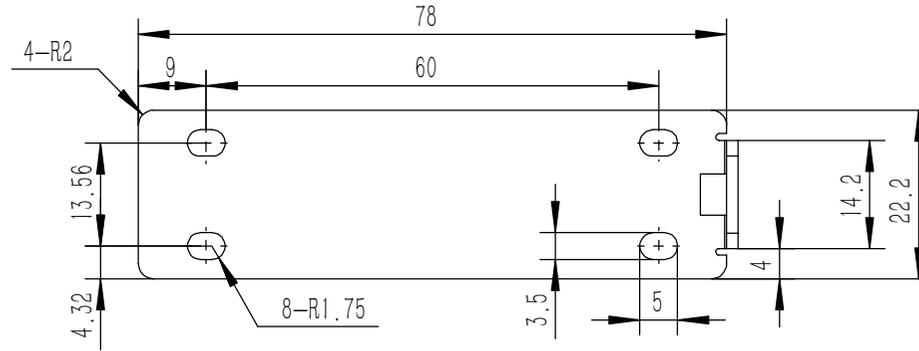
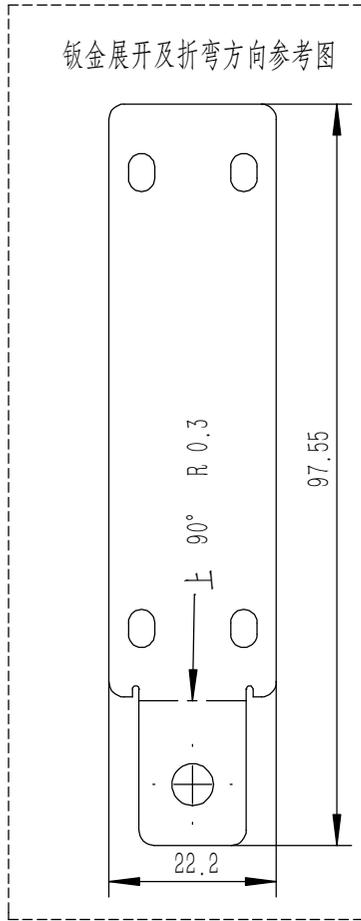
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): 6063-T5	YONGU 永固	
	Weight: (重量) (Kg) 0.080		
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):	Part Name (零/部件名称):	
	Position tolerances (未注位置公差): ± 0.05	拉手 2U	
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Material (材料): 6063-T5	Drawing Number (图号): YG-C22B-0000-007	
	Weight: (重量) (Kg) 0.080	Drawn by (绘图): 莫永康	Date (日期): 2020.05.26
Position tolerances (未注位置公差): ± 0.05	Protection: (表面处理):	Check by (校对):	Date (日期):
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Part Name (零/部件名称):	Signature by (批准):	Date (日期):
		Scale (比例): 1:1	Sheet (页数): 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。

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): 0.069 Protection: (表面处理): Part Name (零/部件名称): 面板下固定件	Drawing Number (图号): YG-C22B-0000-012	
		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°
YONGU 永固		Sheet (页数): 1 / 1	

钣金展开及折弯方向参考图

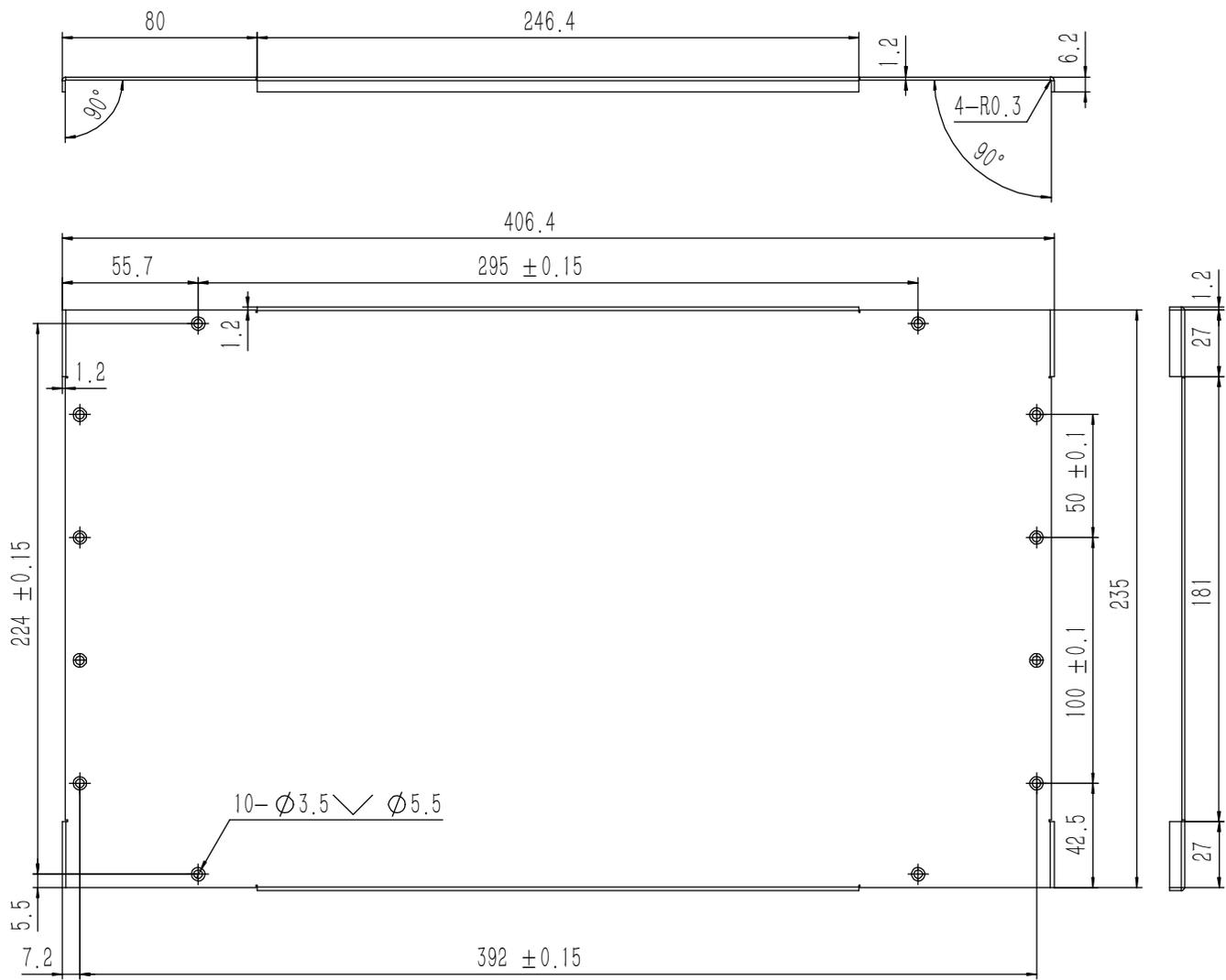
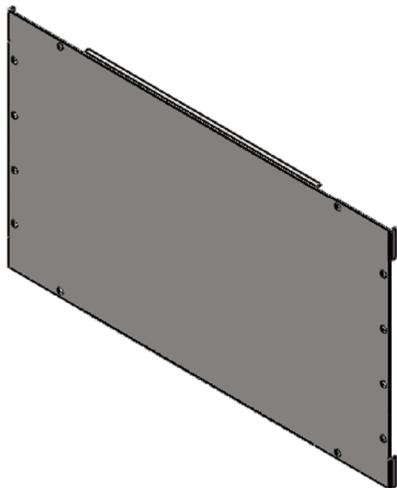
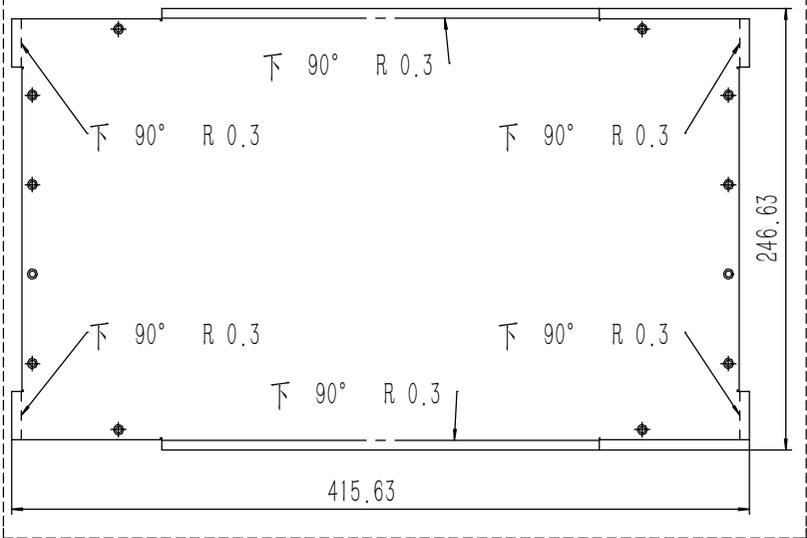


技术要求:

- 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。

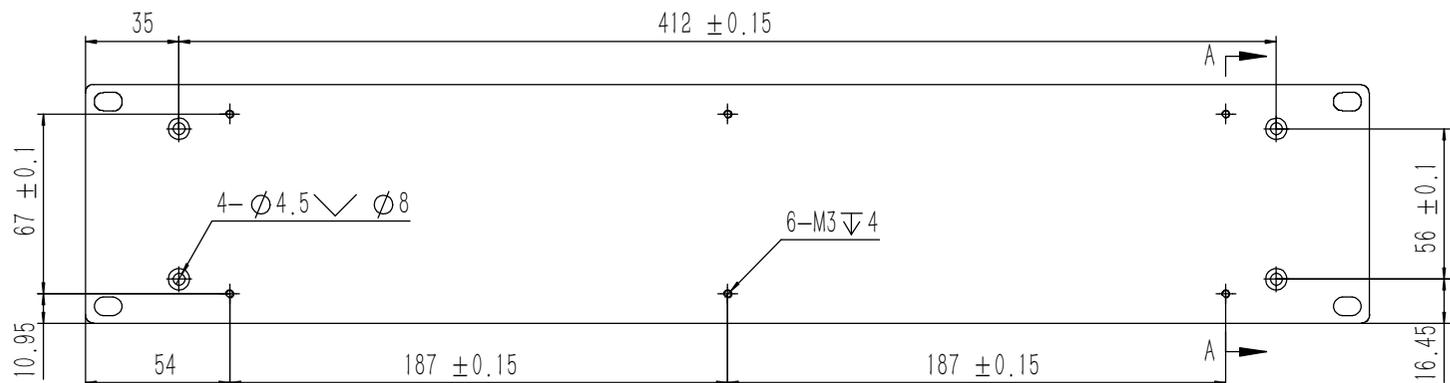
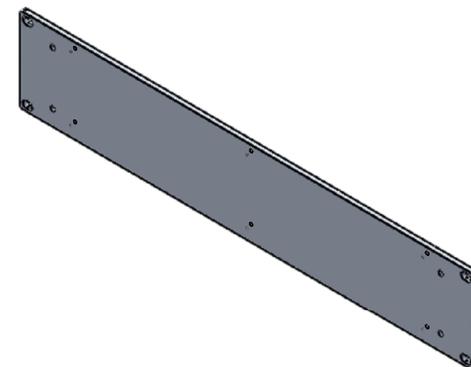
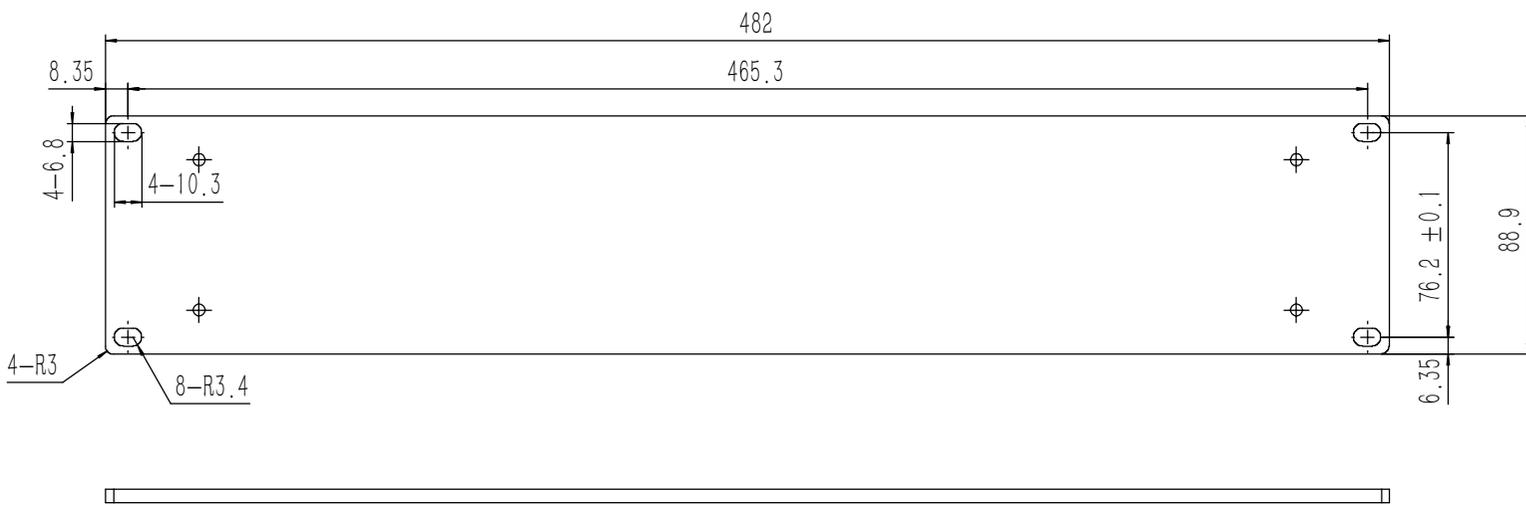
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料):	电解板	
	Weight: (重量) (Kg)	0.023	
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):		
	Position tolerances (未注位置公差): ±0.05	Part Name (零/部件名称):	侧板连接件 2U
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Material (材料):	电解板	
	Weight: (重量) (Kg)	0.023	
Position tolerances (未注位置公差): ±0.05	Protection: (表面处理):		
	Part Name (零/部件名称):	侧板连接件 2U	
Drawn by (绘图):	莫永康	Date (日期):	2020.05.26
Check by (校对):		Date (日期):	
Signature by (批准):		Date (日期):	
Drawing Number (图号):		YG-C22B-0000-010	
Size: (图幅):	A4	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 (比例1:1.5)



- 技术要求:
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 - 2、去除毛刺飞边, 锐角倒钝;
 - 3、未标注尺寸见3D数模。

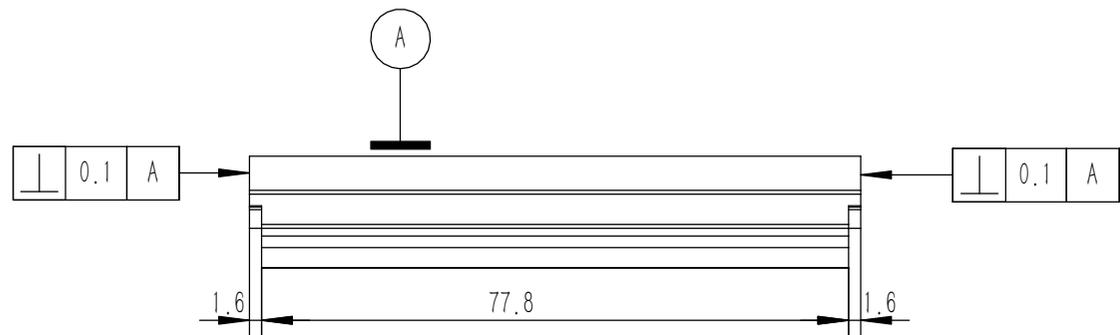
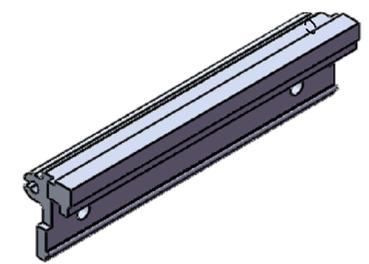
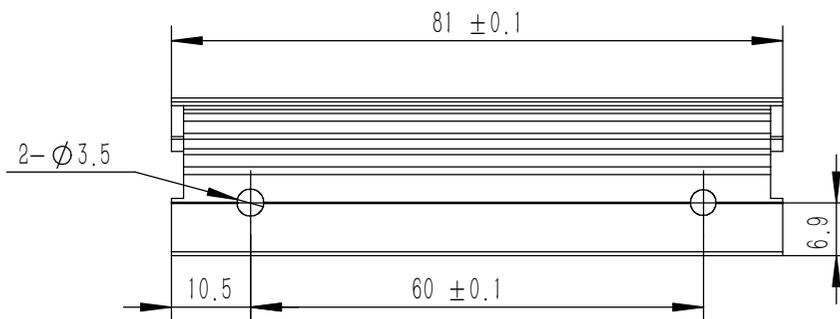
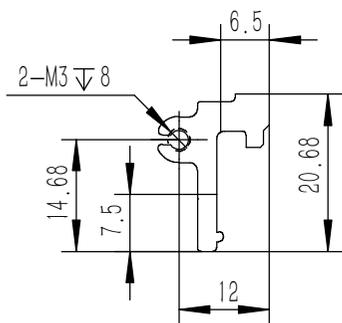
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料):	电解板	YONGU 永固			
	Weight: (重量) (Kg):	0.920				
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):		Drawing Number (图号): YG-C22B-0000-004			
	Position tolerances (未注位置公差): ± 0.05	Part Name (零/部件名称):		垫板		
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Drawn by (绘图):	莫永康	Date (日期):	2020.05.26	Size: (图幅):	A1
	Signature by (批准):		Date (日期):		Scale (比例):	1:1
			Date (日期):		Revision (版本):	A1



技术要求:
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 2、去除毛刺飞边, 锐角倒钝;
 3、未标注尺寸见3D数模。

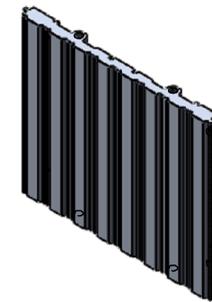
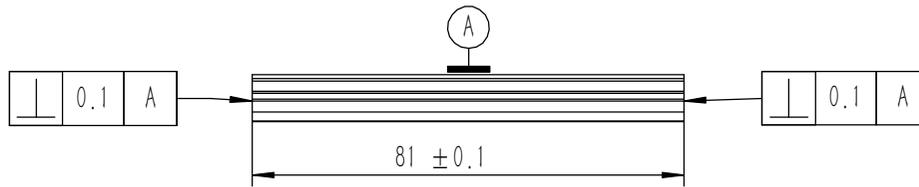
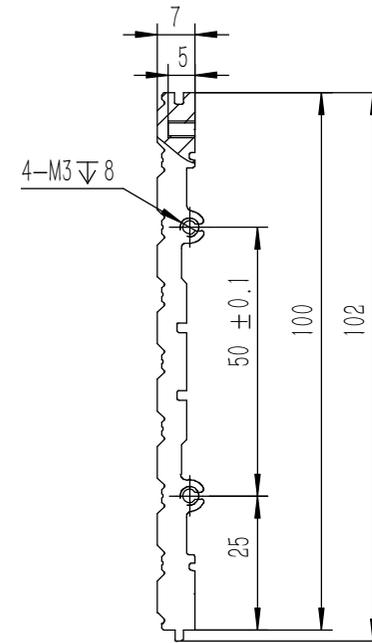
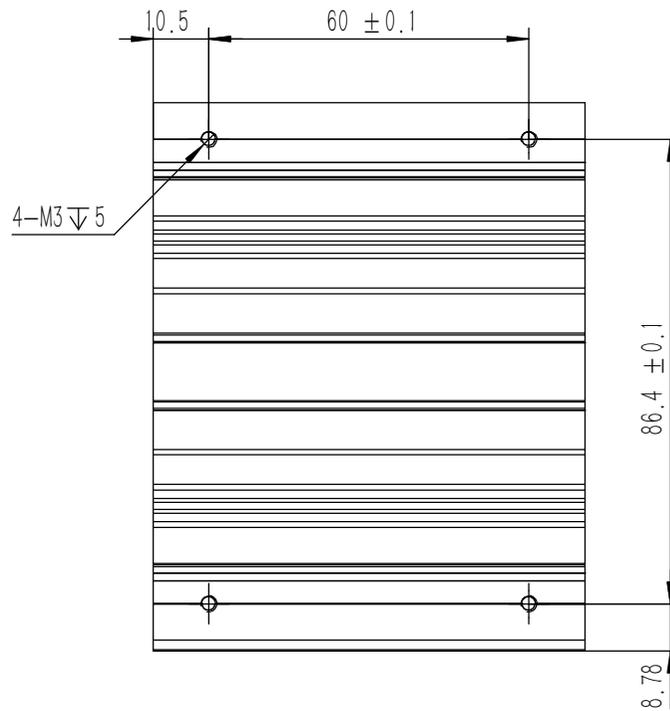
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料):	5052-H32	
	Weight: (重量) (Kg):	0.569	
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):		
	Part Name (零/部件名称):	前面板	
Position tolerances (未注位置公差): ± 0.05	Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Drawing Number (图号):	YG-C22B-0000-001
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	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。

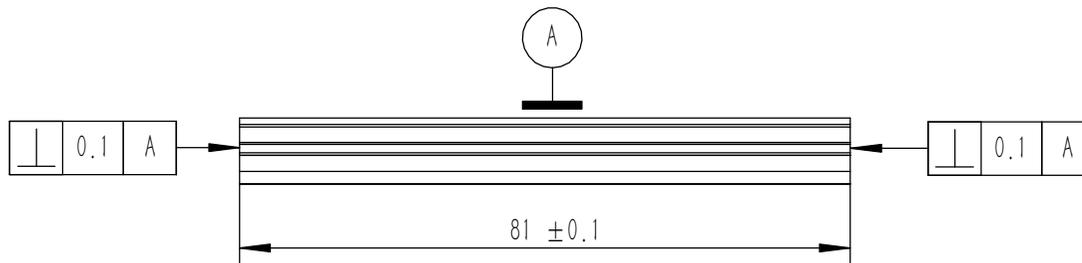
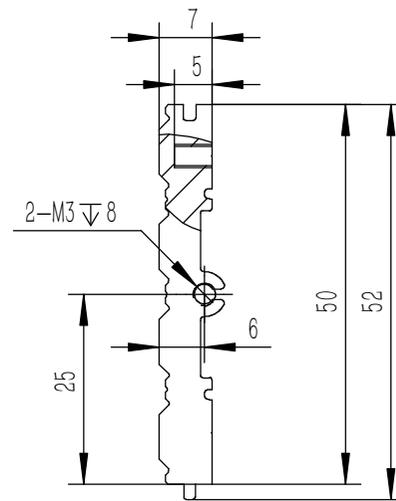
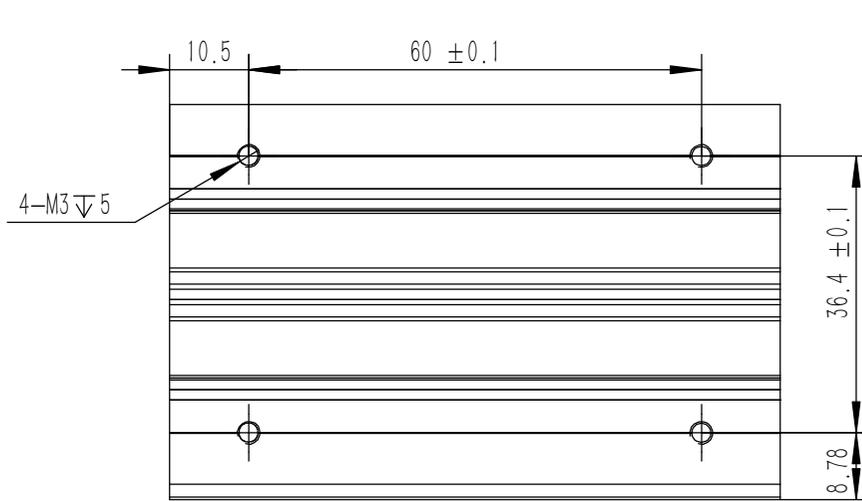
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料):	6063-T5		YONGU 永固	
	Weight: (重量) (Kg)	0.023			
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):			Drawing Number (图号): YG-C22B-0000-009	
	Position tolerances (未注位置公差): ±0.05	Part Name (零/部件名称):	侧板固定 2U		
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Part Name (零/部件名称):	侧板固定 2U		Scale (比例): 1:1 Revision (版本): A1	
	Drawn by (绘图):	莫永康	Date (日期): 2020.05.26		Sheet (页数): 1 / 1
	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。

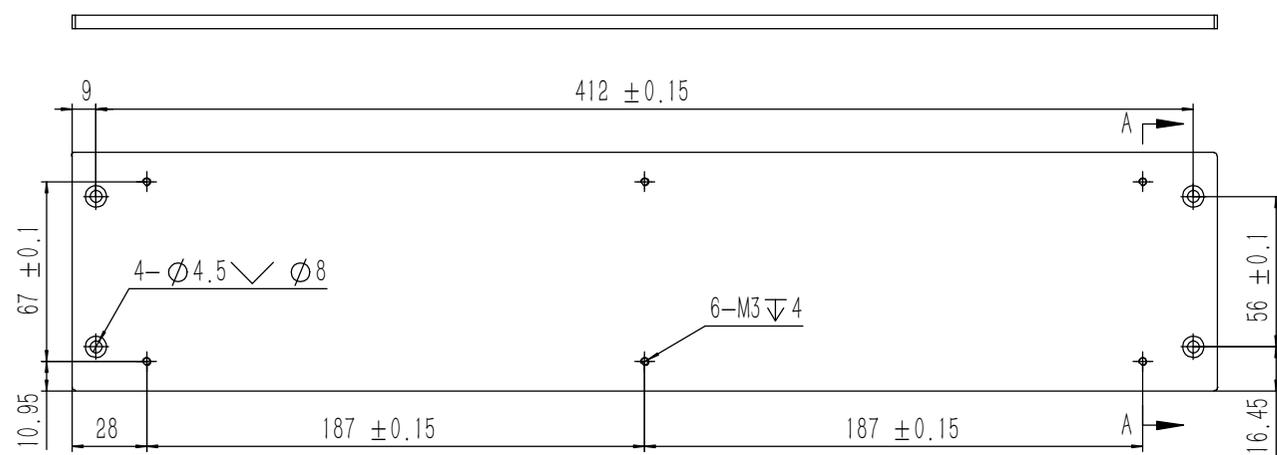
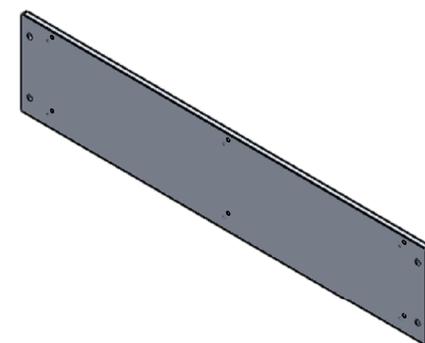
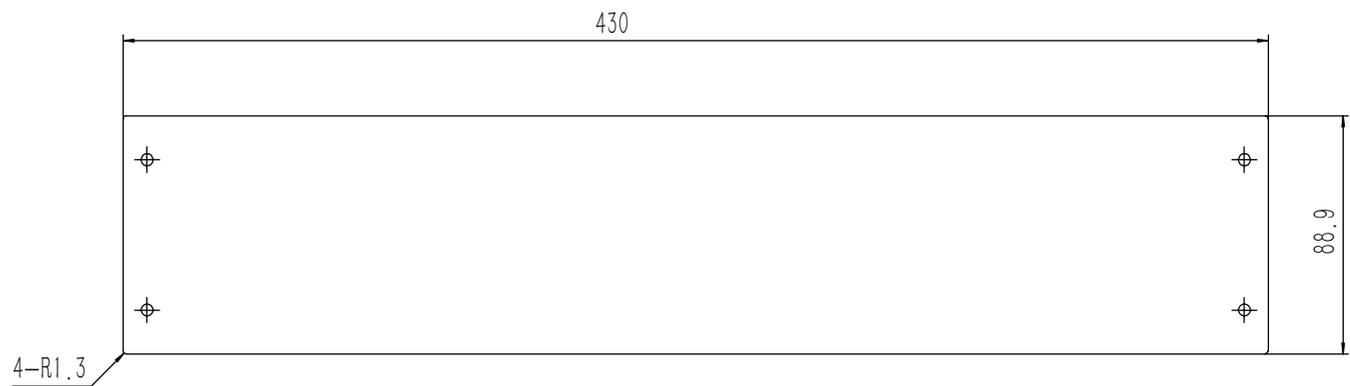
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料):	6063-T5		YONGU 永固
	Weight: (重量) (Kg)	0.119		
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):			Drawing Number (图号): YG-C22B-0000-005
	Part Name (零/部件名称):	组合侧板 2U-100		
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Part Name (零/部件名称):	组合侧板 2U-100		Size (图幅): A3
	Drawn by (绘图):	莫永康	Date (日期): 2020.05.26	
Position tolerances (未注位置公差): ±0.05	Check by (校对):			Scale (比例): 1:1
	Signature by (批准):			



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) 0.066				
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): 组合侧板 2U-50			
	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): YG-C22B-0000-006		
	Material (材料):	Drawn by (绘图): 莫永康	Date (日期): 2020.05.26	Size: (图幅): A4	 Sheet (页数): 1 / 1
	Weight: (重量) (Kg):	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	



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):	0.511	
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):	后面板
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Signature by (批准):	莫永康	莫永康
		Date (日期):	2020.05.26
	Check by (校对):		
	Signature by (批准):		
	Date (日期):		
	Scale (比例):	1:1	
	Revision (版本):	A1	
	Sheet (页数):	1 / 1	



Drawing Number (图号):
YG-C22B-0000-002