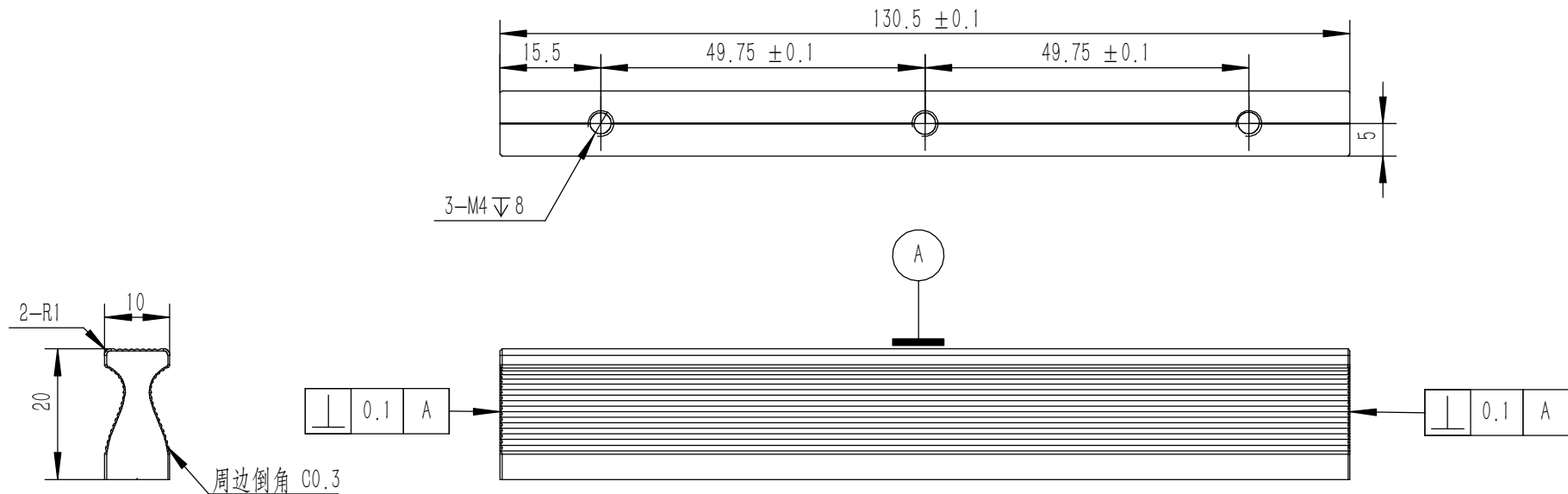


- 技术要求:
- 1、必须按照设计、工艺要求及本规定和有关标准进行装配;
 - 2、所有零部件(包括外购、外协件)必须具有检验合格证方能进行装配;
 - 3、零件在装配前必须清理和清洗干净,不得有毛刺、飞边、氧化皮、锈蚀、切屑、砂粒、灰尘和油污等,并应符合相应清洁度要求;
 - 4、装配过程中零件不得磕碰、划伤和锈蚀;
 - 5、油漆未干的零件不得进行装配;
 - 6、相对运动的零件,装配时接触面间应加润滑油脂;
 - 7、各零、部件装配后相对位置应准确。

18	GB-T-973-1976-C-NI-M3X6	碳钢镀镍十字大扁头螺丝M3X6	普通碳钢	12	0.0006	
17	GB-T-973-1976-C-NI-M3X4	碳钢镀镍十字大扁头螺丝M3X4	普通碳钢	36	0.0005	
16	GB-T-819.1-2000-C-NI-M4X8	碳钢镀镍十字沉头螺丝M4X8	普通碳钢	12	0.001	
15	YG-C23B-0000-002	后面板	5052-H32	1	0.767	
14	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	
13	YG-C23B-0000-005	组合侧板 3U-100	6063-T5	6	0.184	
12	YG-C23B-0000-009	侧板固定 3U-B	6063-T5	4	0.036	
11	YG-C23B-0000-001	前面板	5052-H32	1	0.857	
10	S-M3-1-ZI	压铆螺母镀白锌M3X1	普通碳钢	8	0.3750	
9	YG-C23B-0000-004	垫板	电解板	1	1.109	
8	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	
7	盲孔压铆螺柱镀白锌M3X5	压铆螺柱 M3X5	普通碳钢	8	0.001	
6	YG-C23B-0000-010	侧板连接件 3U	电解板	4	0.034	
5	YG-C23B-0000-012	面板下固定件	电解板	2	0.067	
4	YG-C23B-0000-007	拉手 3U	6063-T5	2	0.125	
3	YG-C23B-0000-003	盖板	5052-H32	2	0.904	
2	YG-C23B-0000-011	面板上固定件	电解板	2	0.061	
1	YG-C23B-0000-008	后防护条 3U	6063-T5	2	0.053	
序号	图号	名称	材料	数量	单重	备注

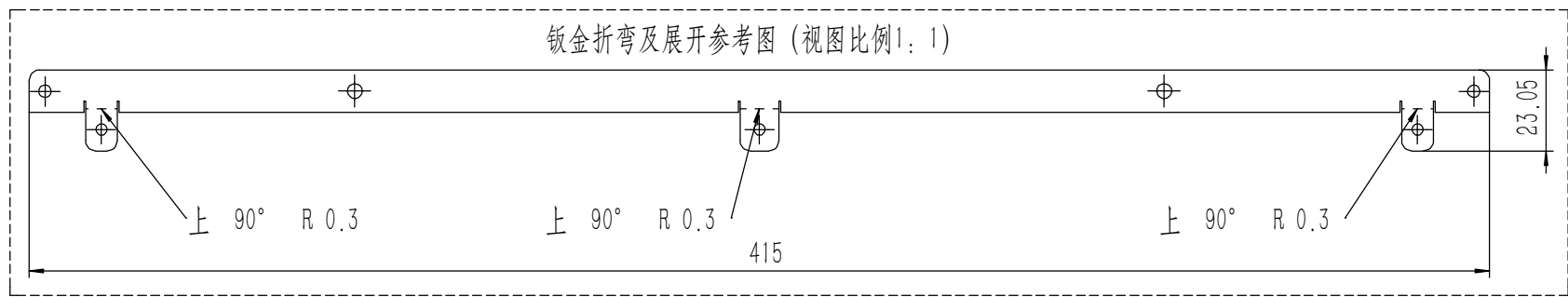
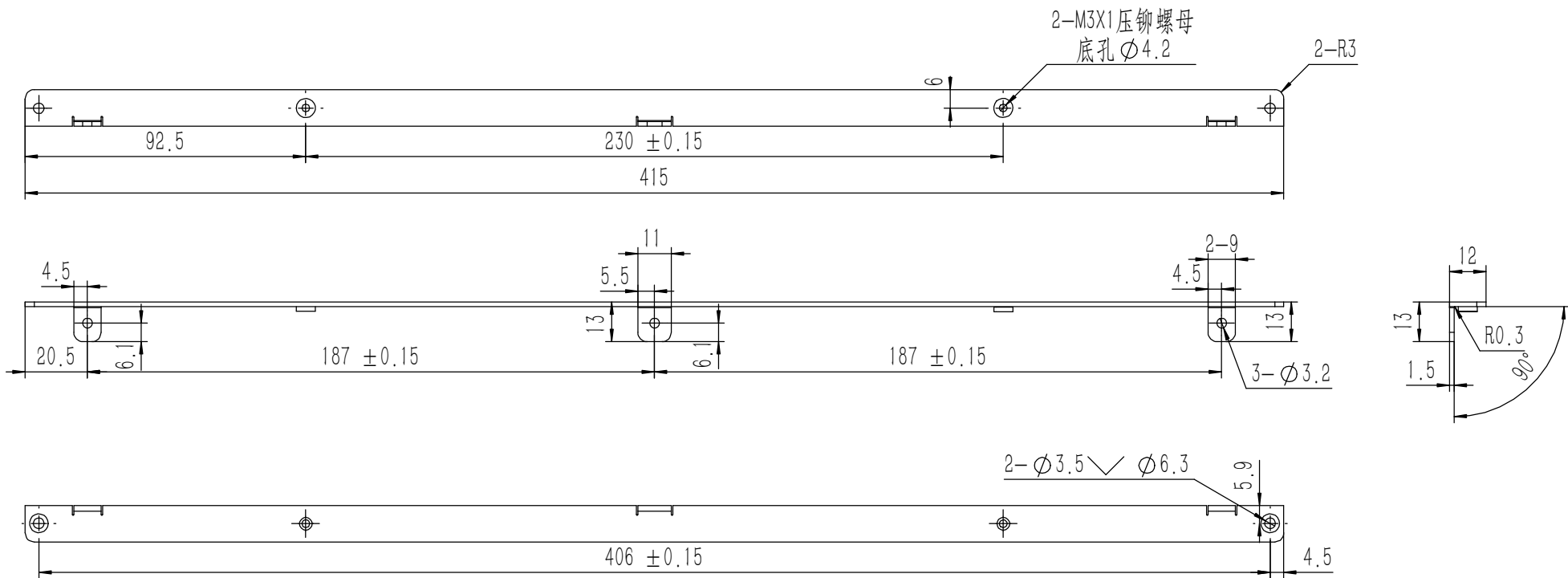
Tolerances (未注公差):		Material (材料): (装配图)		YONGU 永固
0.5 to 6 ± 0.1	Weight: (重量) (Kg): 6.594	Protection: (表面处理):		
6 to 30 ± 0.2	Part Name (零/部件名称):	Drawing Number (图号):		
30 to 120 ± 0.3	C23B机箱	YG-C23B-0000-000		
120 to 400 ± 0.4	Drawn by (绘图): 莫永康	Date (日期): 2020.05.27	Size (图幅): A0	Sheet (页数): 1 / 1
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Check by (校对):	Date (日期):	Scale (比例): 1:1	
Position tolerances (未注位置公差): ± 0.05	Signature by (批准):	Date (日期):	Revision (版本): A1	
Angular tolerances (未注角度公差):				
<6° ± 10'				
<30° ± 20'				
<120° ± 30'				
>120° ± 1°				



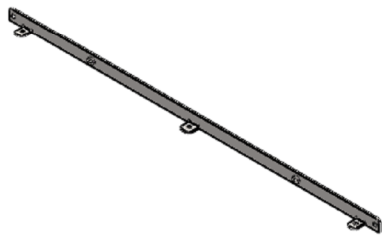
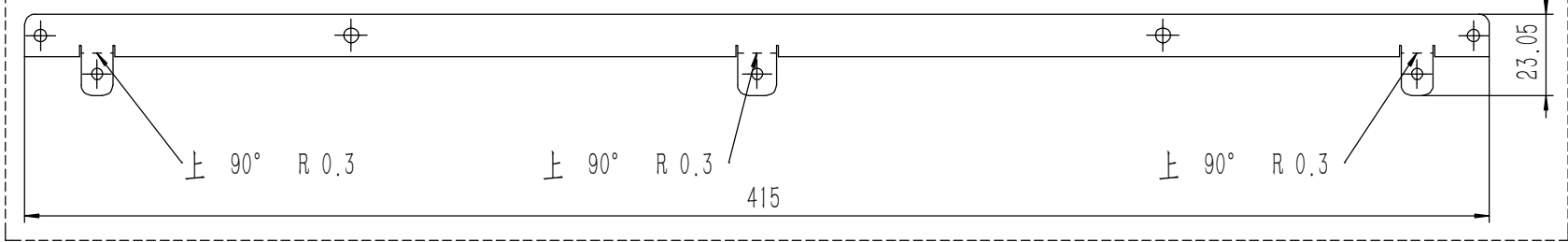
技术要求:

- 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		
	Weight: (重量) (Kg) 0.053		
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Part Name (零/部件名称): 后防护条 3U		Drawing Number (图号): YG-C23B-0000-008
	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): 莫永康 Date (日期): 2020.05.27 Check by (校对): Date (日期): Signature by (批准): Date (日期):



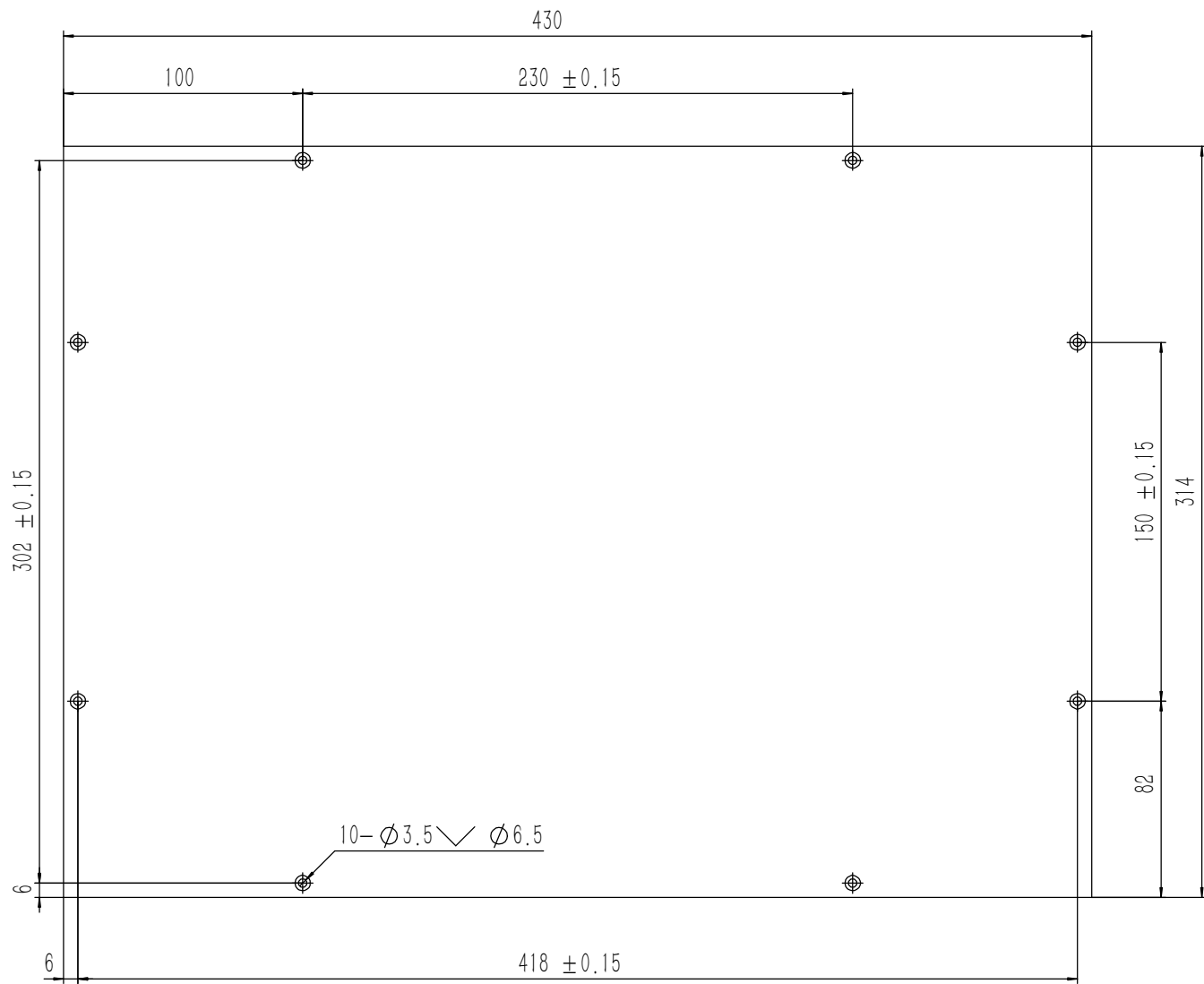
钣金折弯及展开参考图 (视图比例1:1)



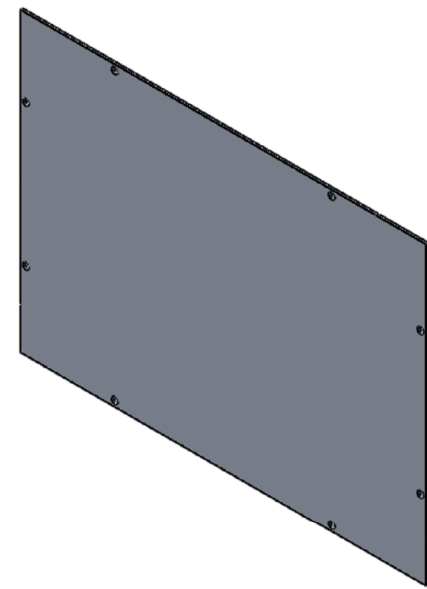
技术要求:

- 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	YONGU 永固
	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):		Drawing Number (图号): YG-C23B-0000-011
	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):	莫永康	Date (日期): 2020.05.27
	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



2.5



技术要求:

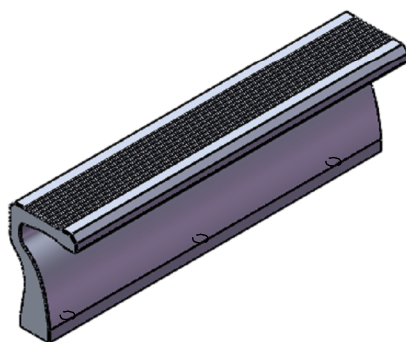
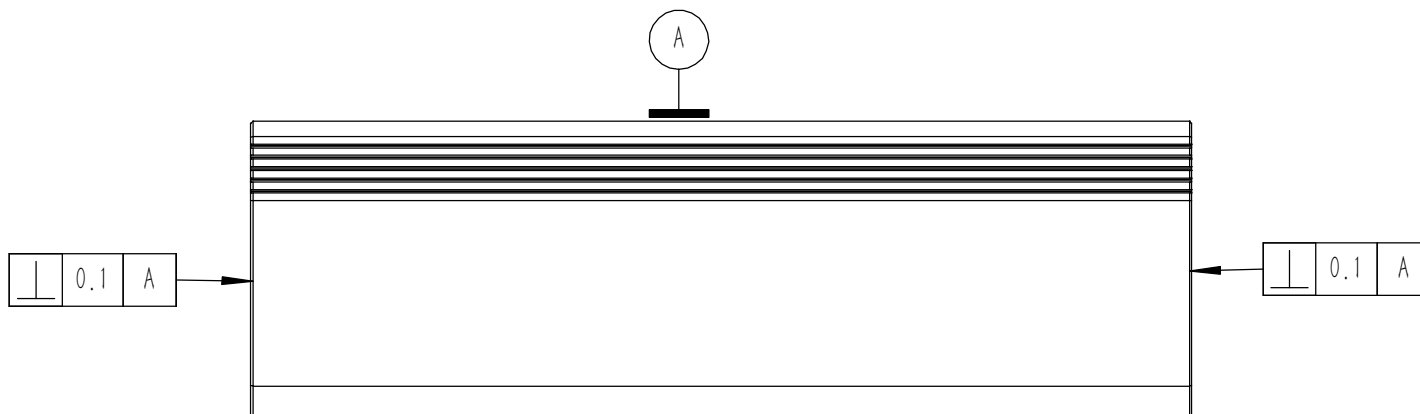
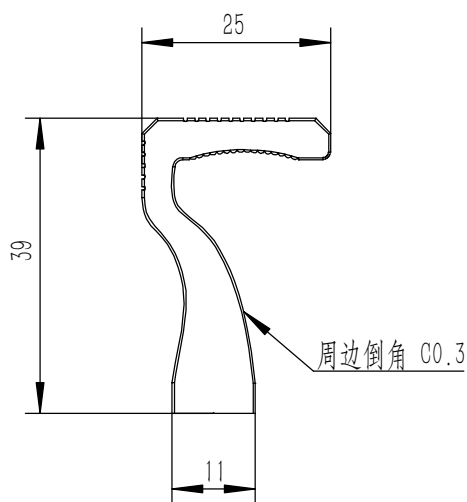
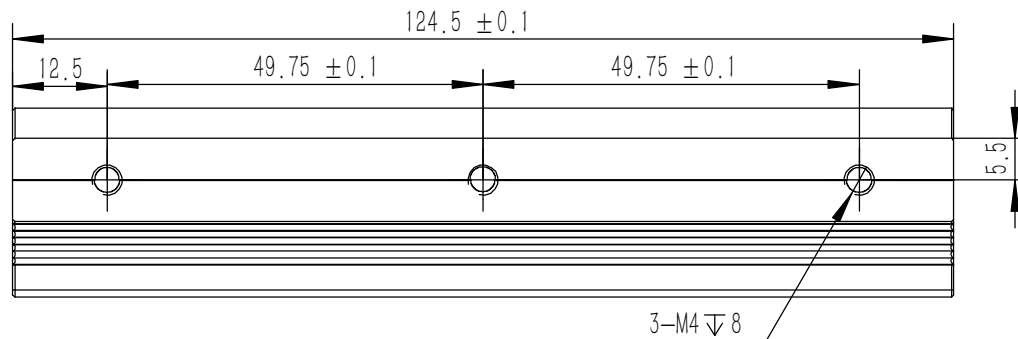
- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
- 2、去除毛刺飞边,锐角倒钝;
- 3、未标注尺寸见3D数模。

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):	0.904
Protection: (表面处理):	
Part Name (零/部件名称):	盖板

		Drawing Number (图号):	
		YG-C23B-0000-003	
Drawn by (绘图): 莫永康	Date (日期): 2020.05.27	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	

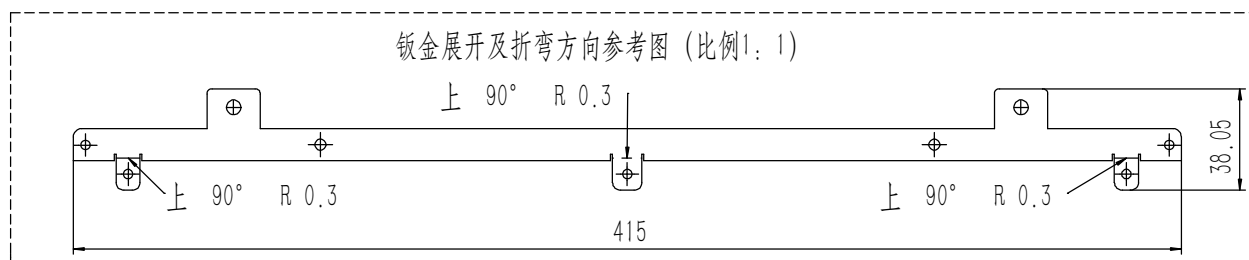
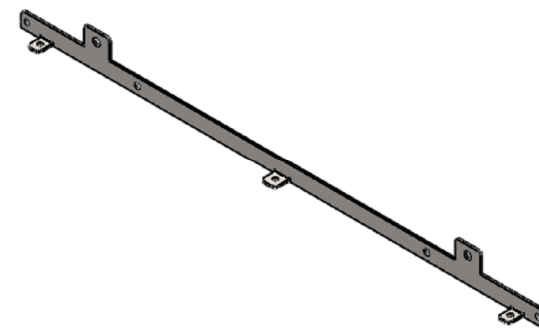
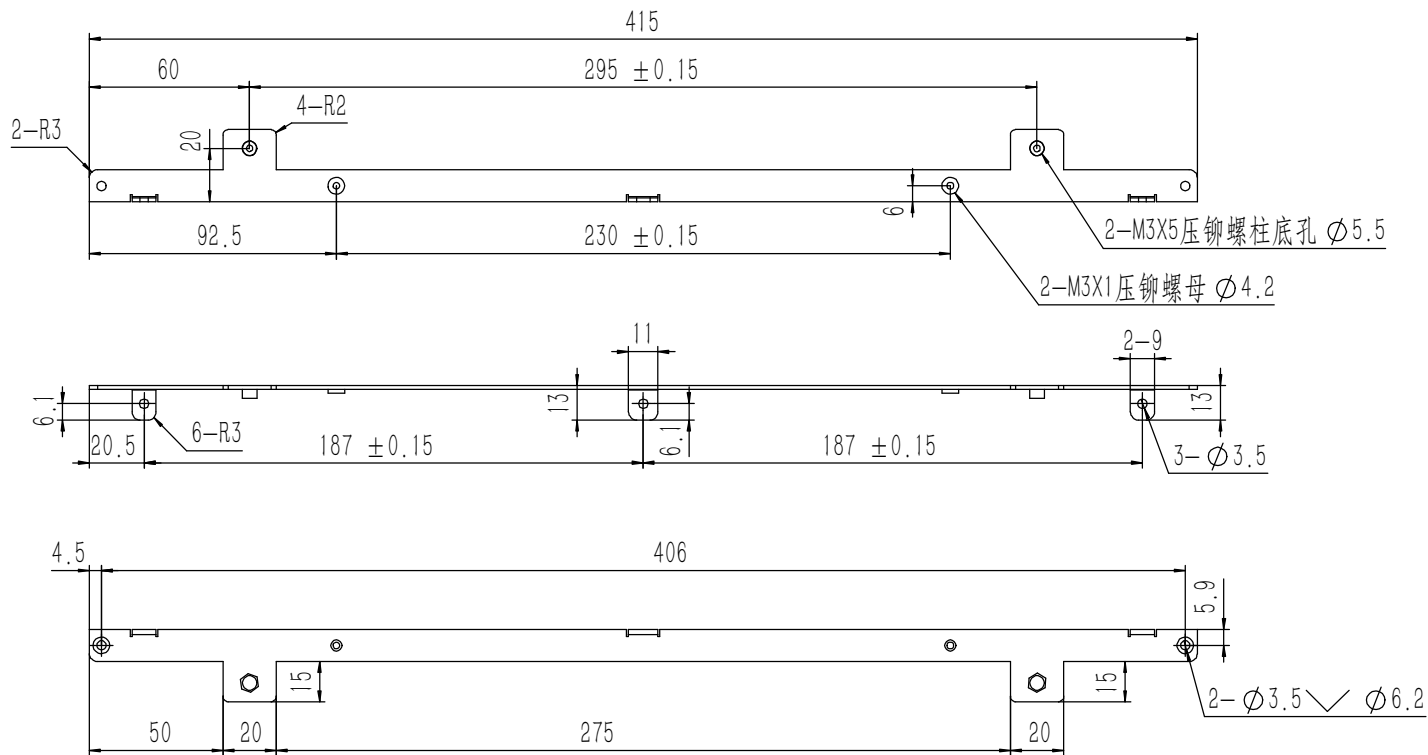
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Angular tolerances (未注角度公差):
Position tolerances (未注位置公差): ± 0.05	<6° ± 10'
	<30° ± 20'
	<120° ± 30'
	>120° ± 1°



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) 0.125		
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 3U	
	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-C23B-0000-007
	Drawn by (绘图): 莫永康	Date (日期): 2020.05.27	Size: (图幅): A4
	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

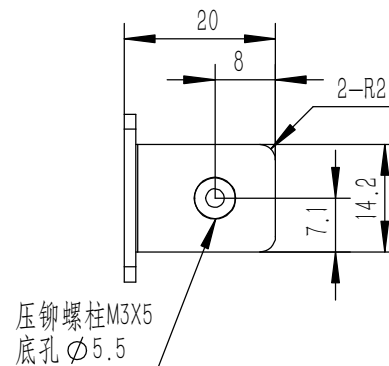
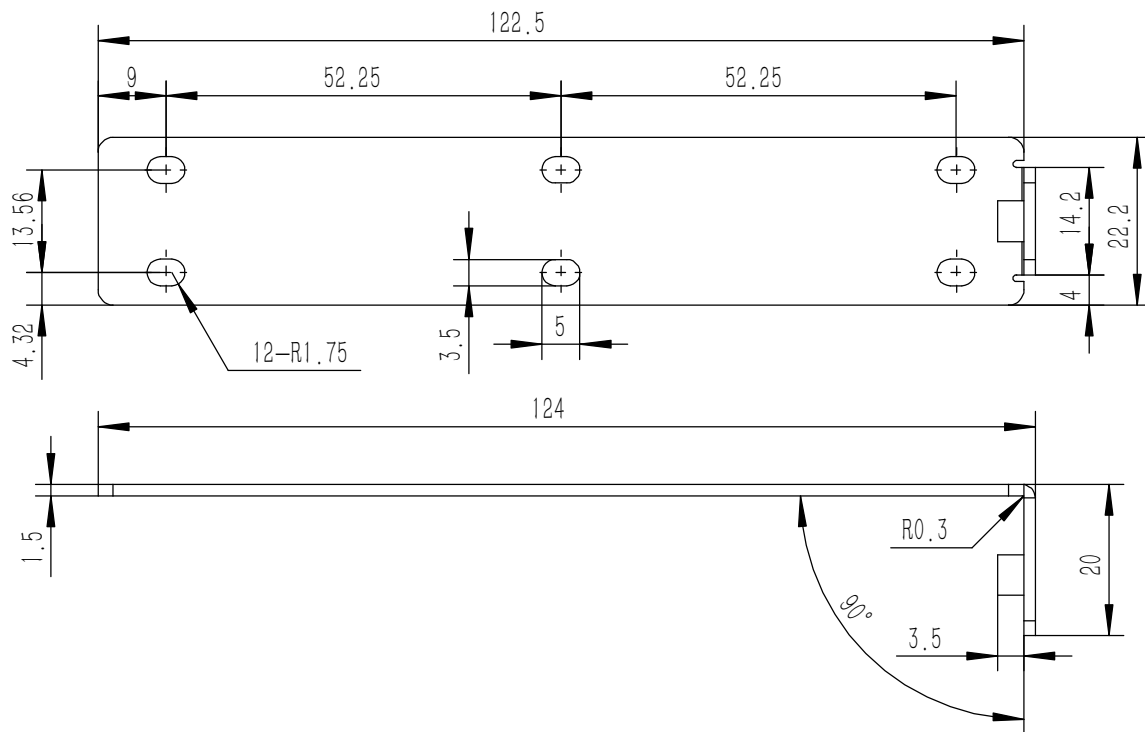


- 技术要求:
- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
 - 2、去除毛刺飞边, 锐角倒钝;
 - 3、未标注尺寸见3D数模。

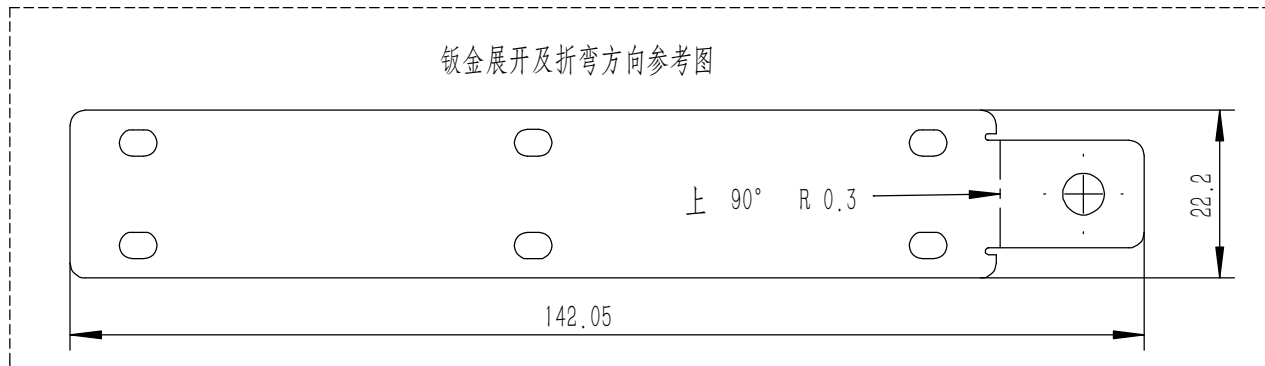
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料):	电解板	
	Weight: (重量) (Kg):	0.069	
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):		
	Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1'	Part Name (零/部件名称):	面板下固定件
Position tolerances (未注位置公差): ± 0.05	Drawn by (绘图):	莫永康	Date (日期): 2020.05.27
	Signature by (批准):		Date (日期):
		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

YONGU 永固

Drawing Number (图号):
YG-C23B-0000-012

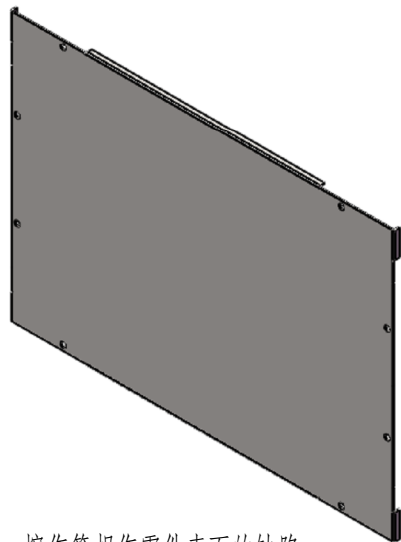
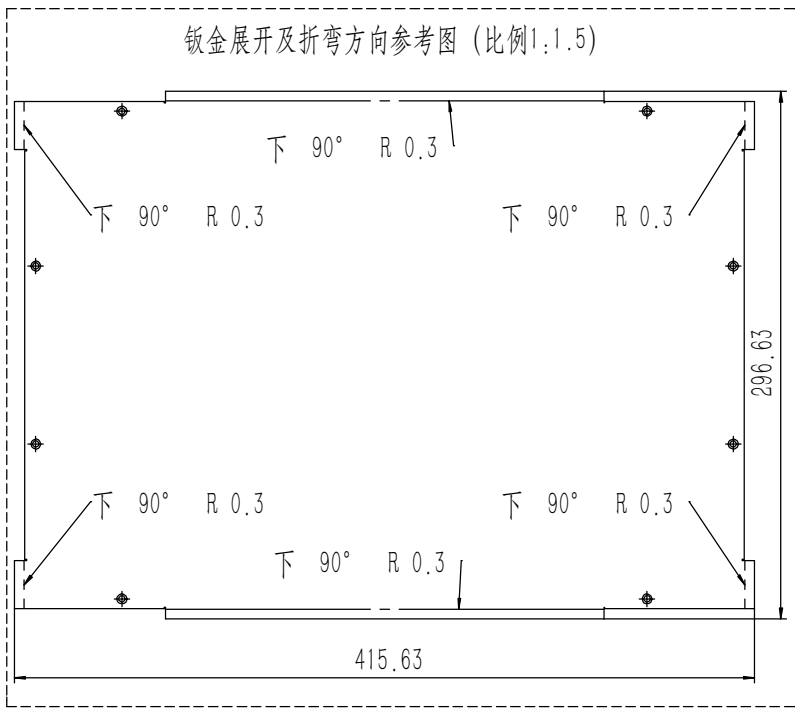


钣金展开及折弯方向参考图



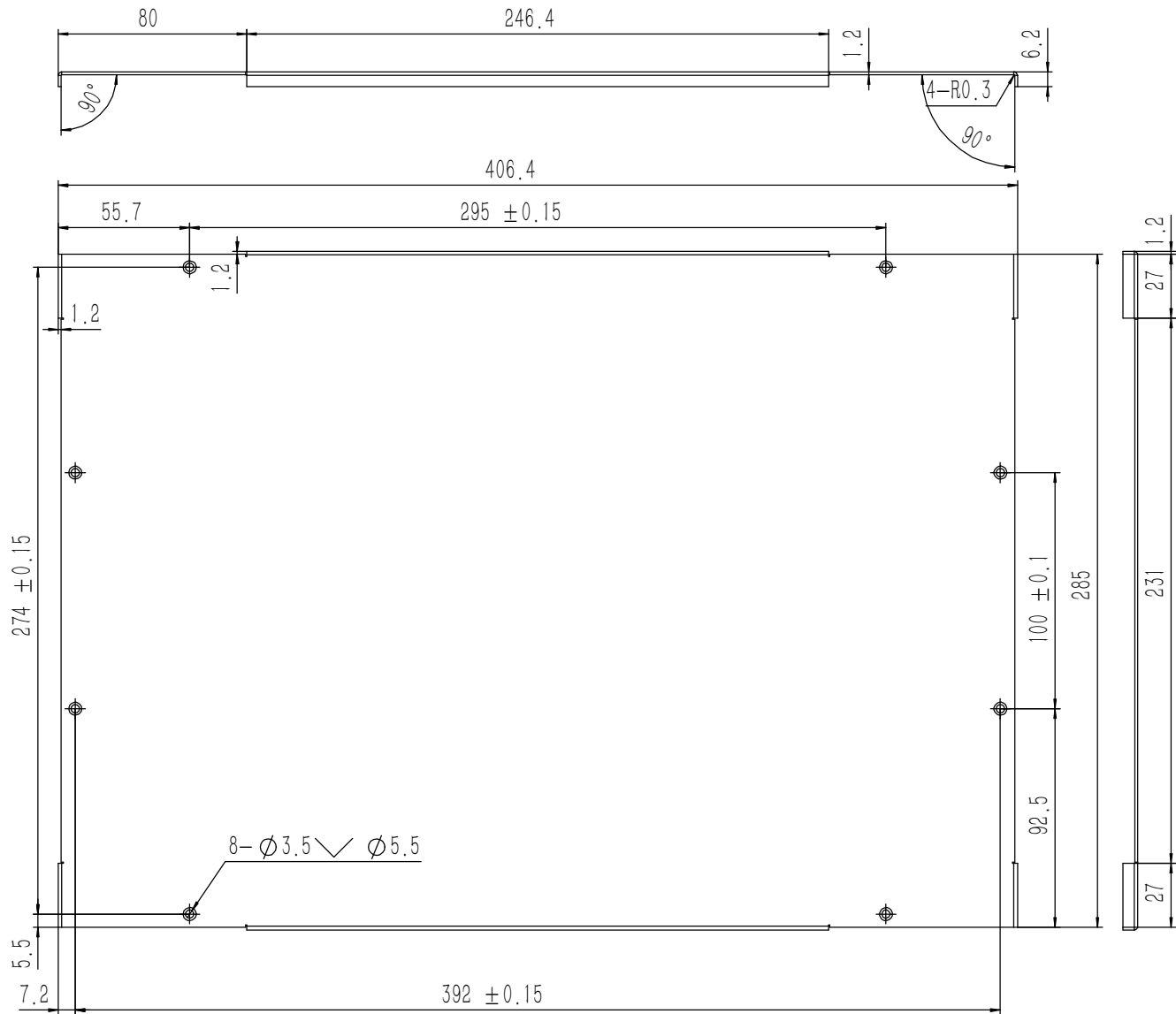
- 技术要求:
- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
 - 2、去除毛刺飞边, 锐角倒钝;
 - 3、未标注尺寸见3D数模。

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		YONGU 永固
	Weight: (重量) (Kg)	0.034		
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-C23B-0000-010
	Position tolerances (未注位置公差): ±0.05	Part Name (零/部件名称):	侧板连接件 3U	
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Part Name (零/部件名称):	侧板连接件 3U		Scale (比例): 1:1 Sheet (页数): 1 / 1
	Drawn by (绘图):	莫永康	Date (日期): 2020.05.27	
	Check by (校对):		Date (日期):	
	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

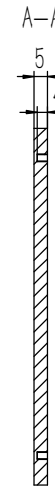
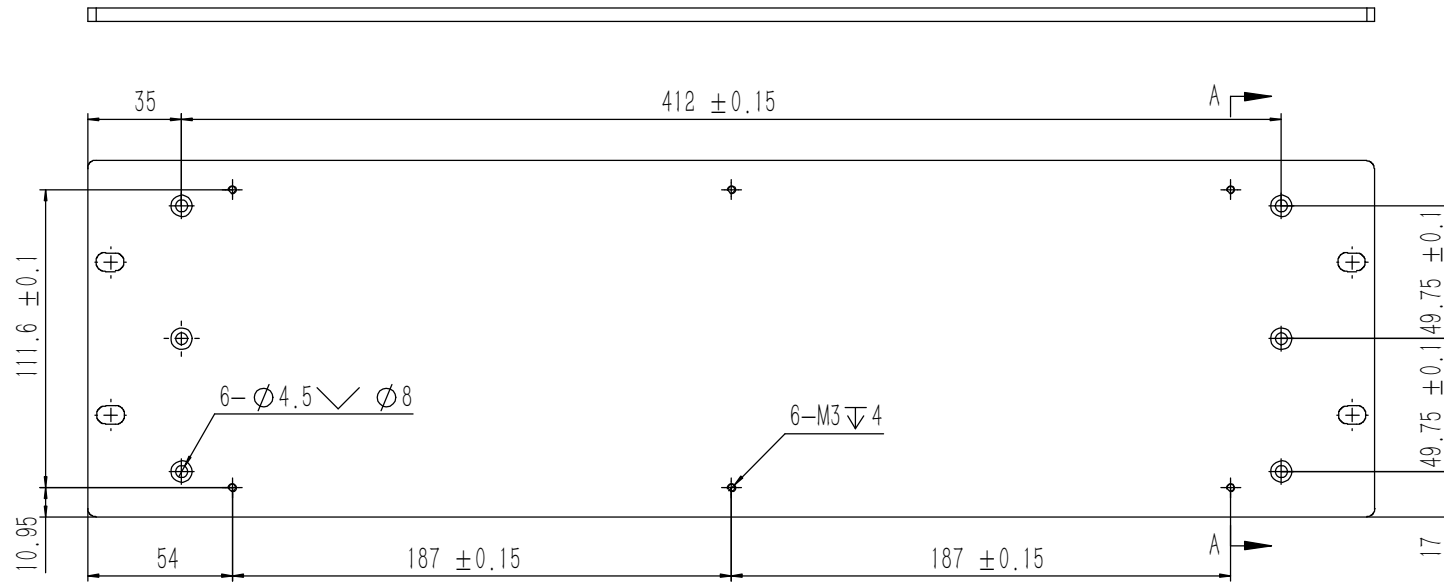
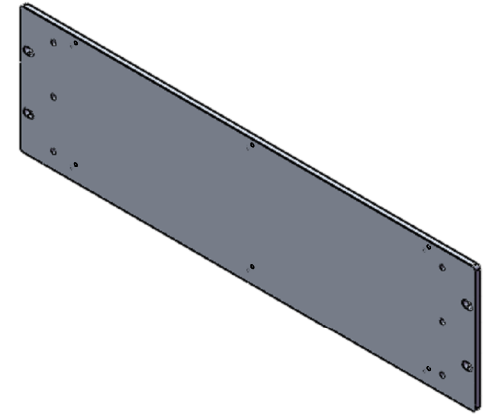
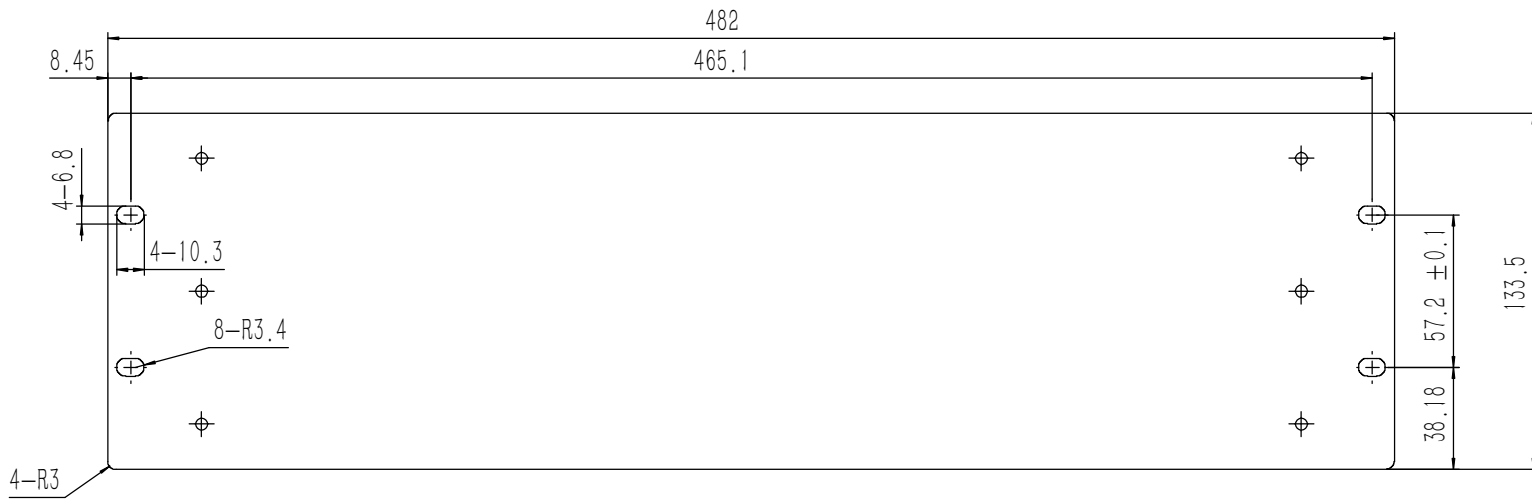
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Angular tolerances (未注角度公差):
	<6° ± 10'
	<30° ± 20'
	<120° ± 30'
	>120° ± 1°

Position tolerances (未注位置公差): ± 0.05
--

Material (材料):	电解板
Weight: (重量) (Kg):	1.109
Protection: (表面处理):	
Part Name (零/部件名称):	垫板

YONGU 永固

Drawing Number (图号): YG-C23B-0000-004		Size: (图幅): A1		Sheet (页数): 1 / 1	
Drawn by (绘图): 莫永康	Date (日期): 2020.05.27	Scale (比例): 1:1	Revision (版本): A1		
Check by (校对):	Date (日期):	Signature by (批准):			
Signature by (批准):	Date (日期):				



技术要求:

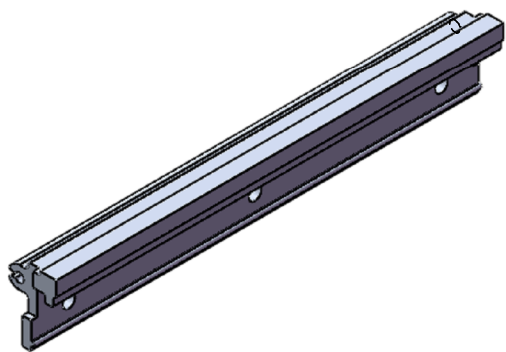
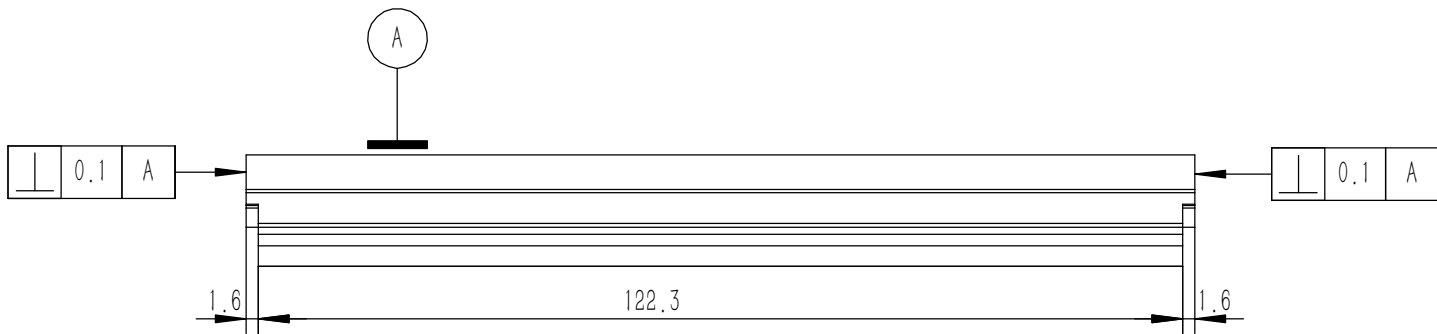
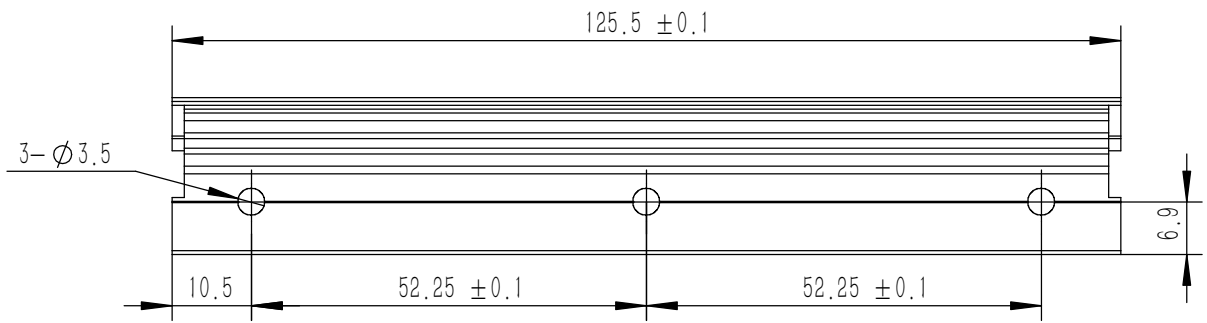
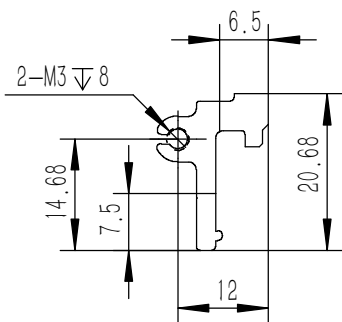
- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
- 2、去除毛刺飞边, 锐角倒钝;
- 3、未标注尺寸见3D数模。

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):	5052-H32	
	Weight: (重量) (Kg):	0.857	
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):	前面板
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):	2020.05.27
	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	

YONGU 永固

Drawing Number (图号):
YG-C23B-0000-001

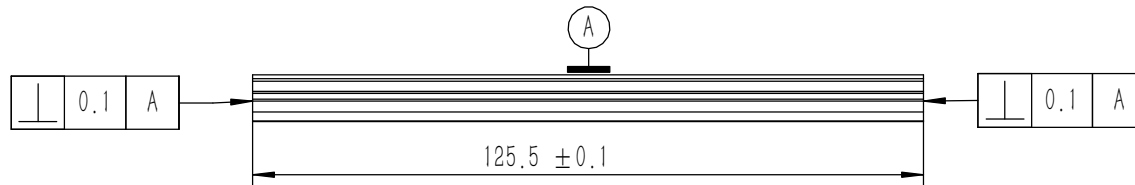
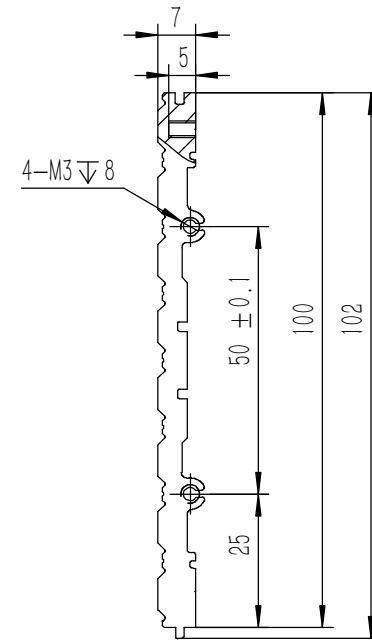
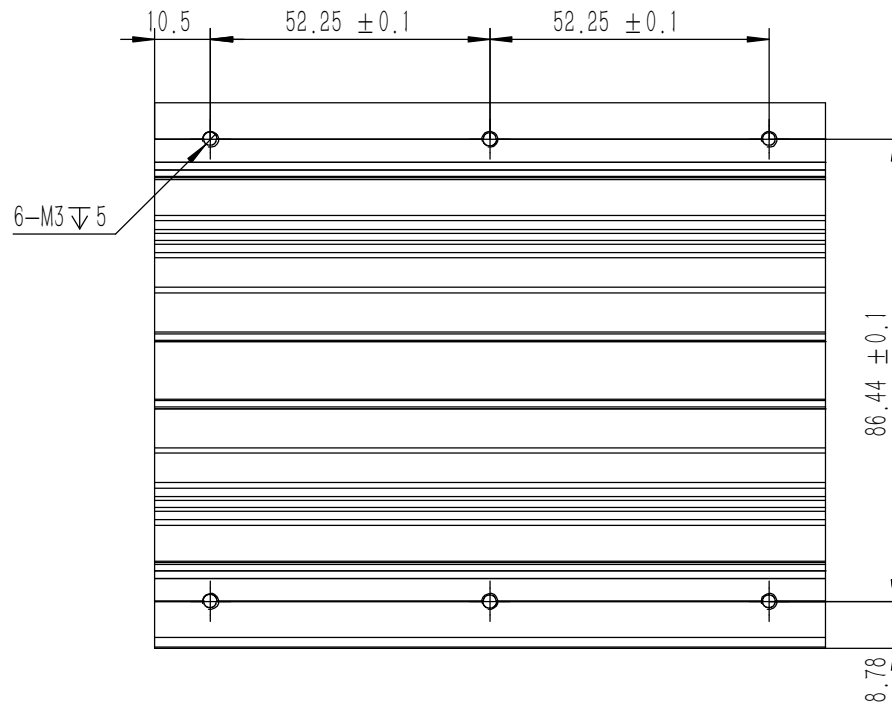




技术要求:

- 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。

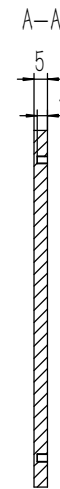
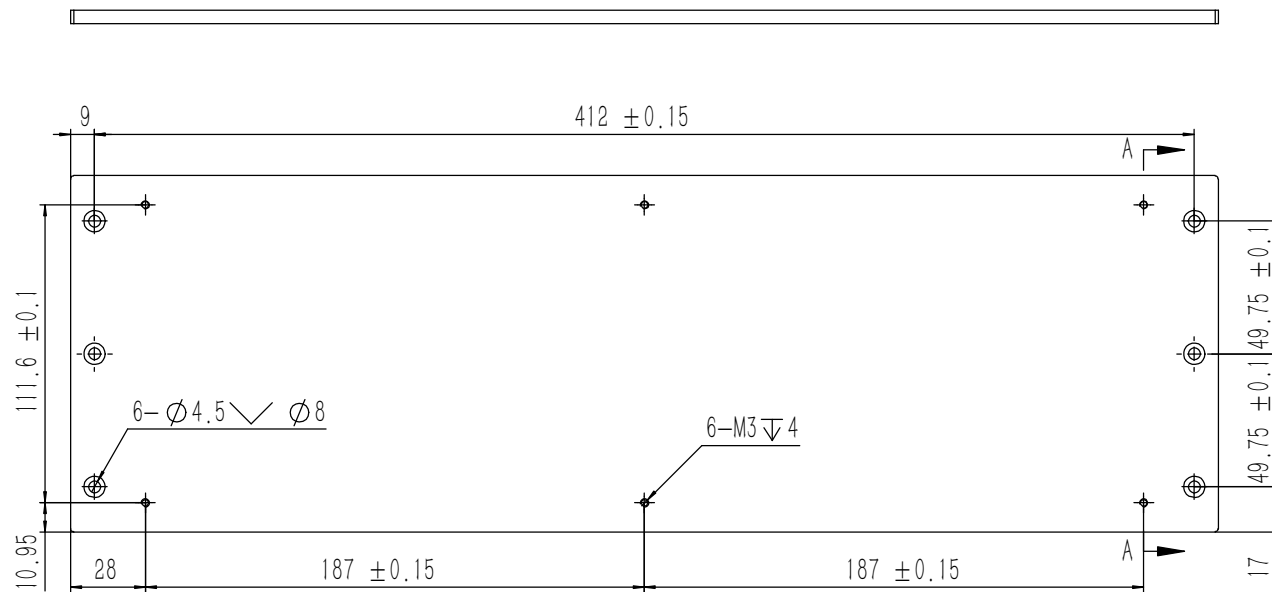
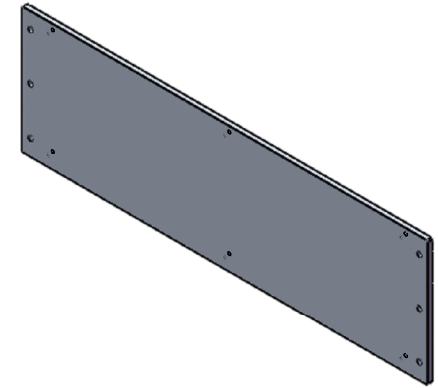
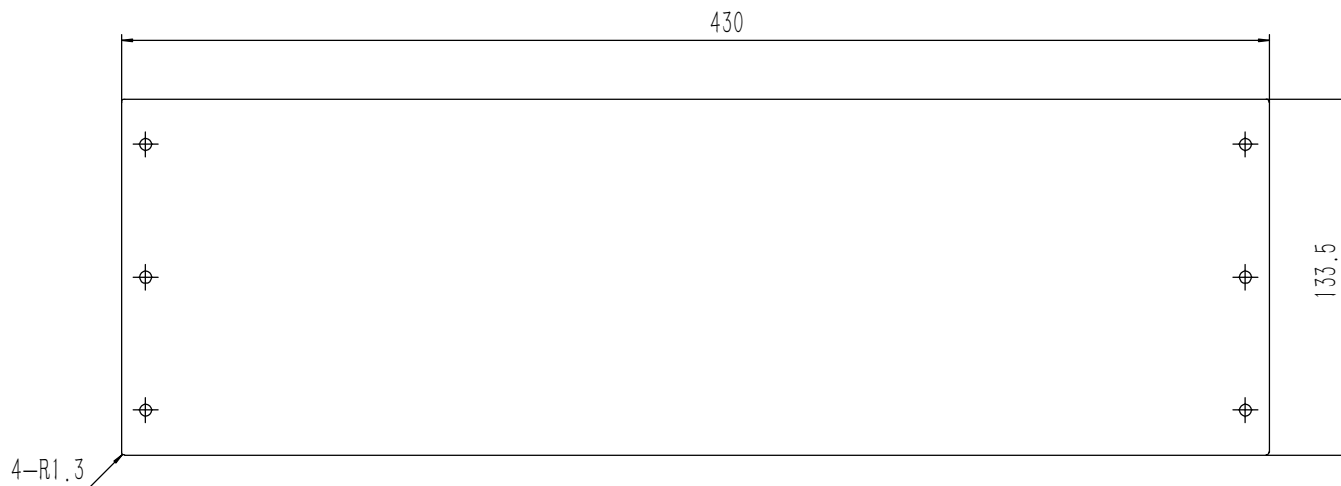
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): 6063-T5	YONGU 永固	
	Weight: (重量) (Kg) 0.036		
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):	Part Name (零/部件名称): 侧板固定 3U-B	
	Position tolerances (未注位置公差): ±0.05	Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Drawing Number (图号): YG-C23B-0000-009
	Part Name (零/部件名称): 侧板固定 3U-B	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):
		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):	6063-T5		YONGU 永固
	Weight: (重量) (Kg)	0.184		
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-C23B-0000-005
	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 3U-100	
Position tolerances (未注位置公差): ±0.05	Part Name (零/部件名称):	组合侧板 3U-100		Size (图幅): A3
	Drawn by (绘图): 莫永康	Date (日期): 2020.05.27	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。

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): 0.767	
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): 后面板
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°	Part Name (零/部件名称):	Size: (图幅): A1
	Part Name (零/部件名称):	Scale (比例): 1:1
	Part Name (零/部件名称):	Revision (版本): A1
	Part Name (零/部件名称):	Sheet (页数): 1 / 1
	Part Name (零/部件名称):	Sheet (页数): 1 / 1