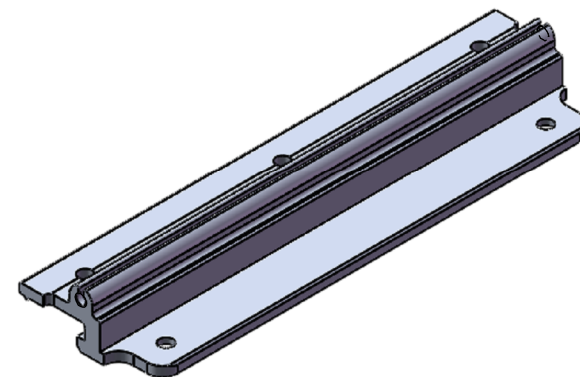
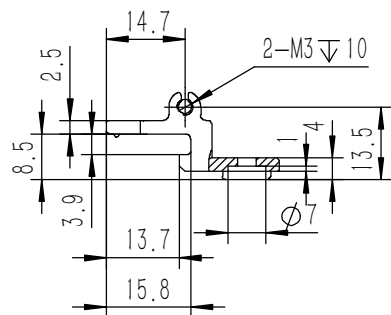
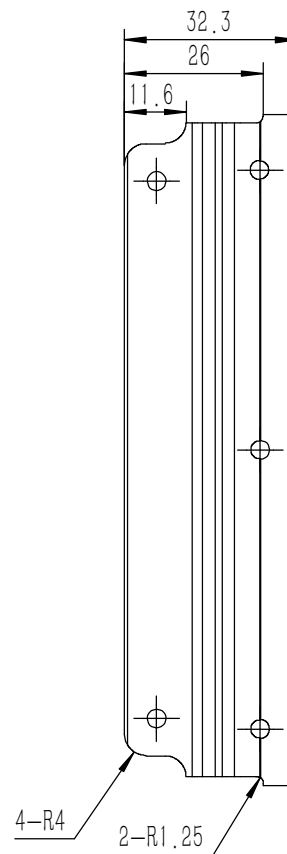
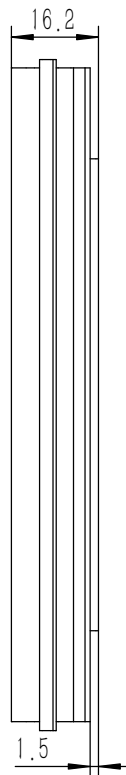
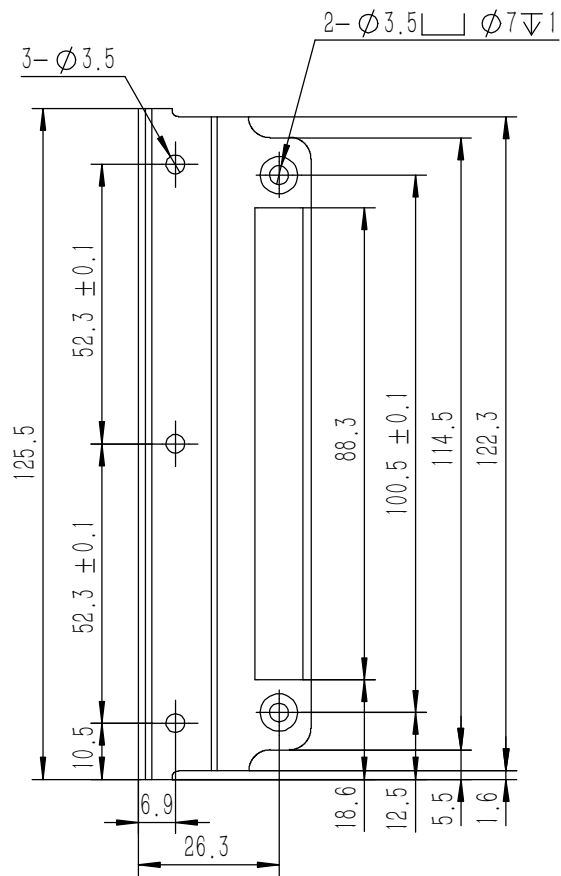


技术要求:

- 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
22	DIN-9250-S-NL-M3	不锈钢防松垫圈	SUS 304	8	0.000	
21	YG-TY-A13-011	A垫板	5052-H32	1	0.594	
20	YG-TY-XJD-001	自粘胶垫35X11X3	硅胶胶	8	0.0013	
19	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	
18	YG-TY-A07-003	后防护条-3U	5052-H32	2	0.054	
17	YG-TY-A12-011	前后面板-3U	5052-H32	2	0.867	
16	YG-TY-A11-003	面板下固定件3	电解板	2	0.067	
15	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	
14	S-M3-1-ZI	压铆螺母镀白锌M3X1	普通碳钢	8	0.3750	
13	GB-T-973-1976-C-NI-M3X6	碳钢镀锌十字大扁头螺丝M3X6	普通碳钢	20	0.0006	
12	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	
11	BSO-M3-5-ZI-D5.4	压铆螺母 M3X5	普通碳钢	10	0.001	
10	YG-TY-A01-011	上下盖板	5052-H32	1	1.081	
9	YG-TY-A05-002	A包角2	6063-T5	4	0.043	
8	YG-TY-A06-003	拉手-3U	6063-T5	2	0.103	
7	YG-TY-A10-003	面板上固定件3	电解板	2	0.061	
6	YG-TY-A05-001	A包角1	6063-T5	4	0.043	
5	YG-TY-A04-003	组合侧板	6063-T5	2	0.144	
4	YG-TY-A02-011	上盖板	5052-H32	1	1.043	
3	YG-TY-A03-003	组合侧板	6063-T5	6	0.274	
2	YG-TY-A09-003	侧板连接件	电解板	8	0.034	
1	YG-TY-A08-003	A侧板固定件3U	6063-T5	4	0.047	

Tolerances (未注公差):		Material (材料): (装配图)		YONGU 永固
0.5 to 6 ± 0.1		Weight: (重量) (Kg): 7.770		
6 to 30 ± 0.2		Protection: (表面处理):		
30 to 120 ± 0.3		Part Name (零/部件名称):		
120 to 400 ± 0.4		A11机箱		Drawing Number (图号): YG-A11-1000-000
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'		Size (图幅): A0
Position tolerances (未注位置公差): ± 0.05		>120° ± 1°		Scale (比例): 1:1.5
		Drawn by (绘图): 邓展锋		Date (日期): 2020.05.22
		Check by (校对):		Date (日期):
		Signature by (批准):		Date (日期):
				Sheet (页数): 1 / 1

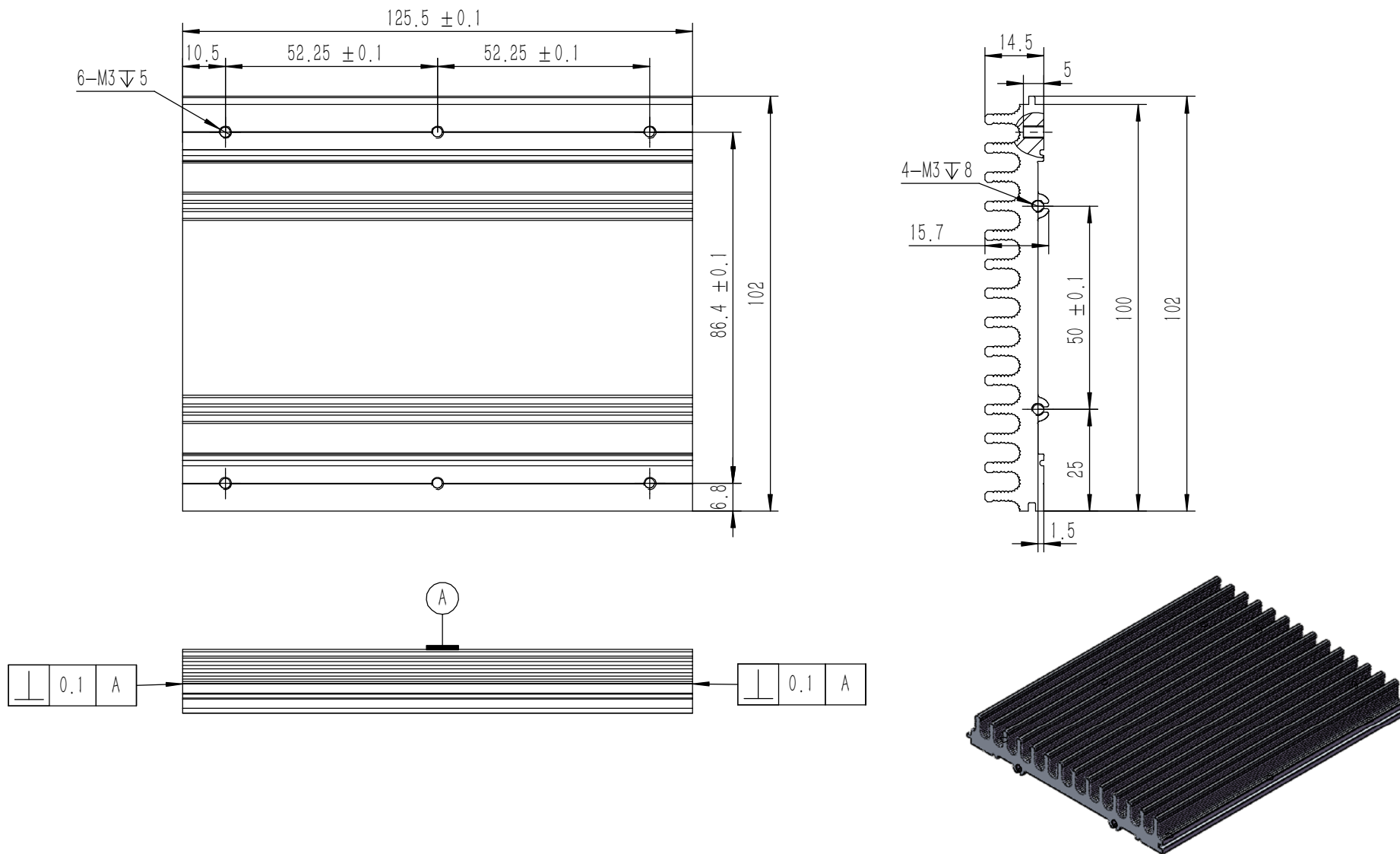


技术要求:

- 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。

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	

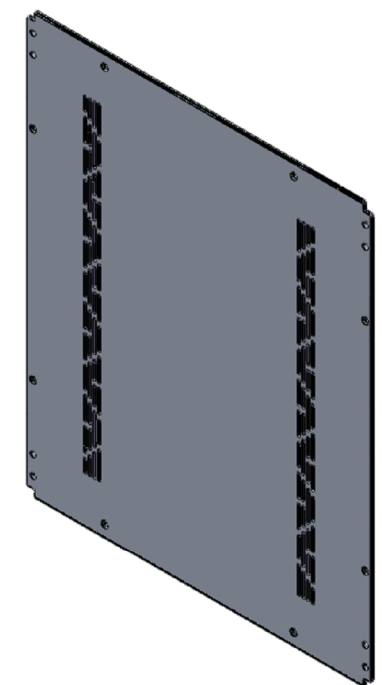
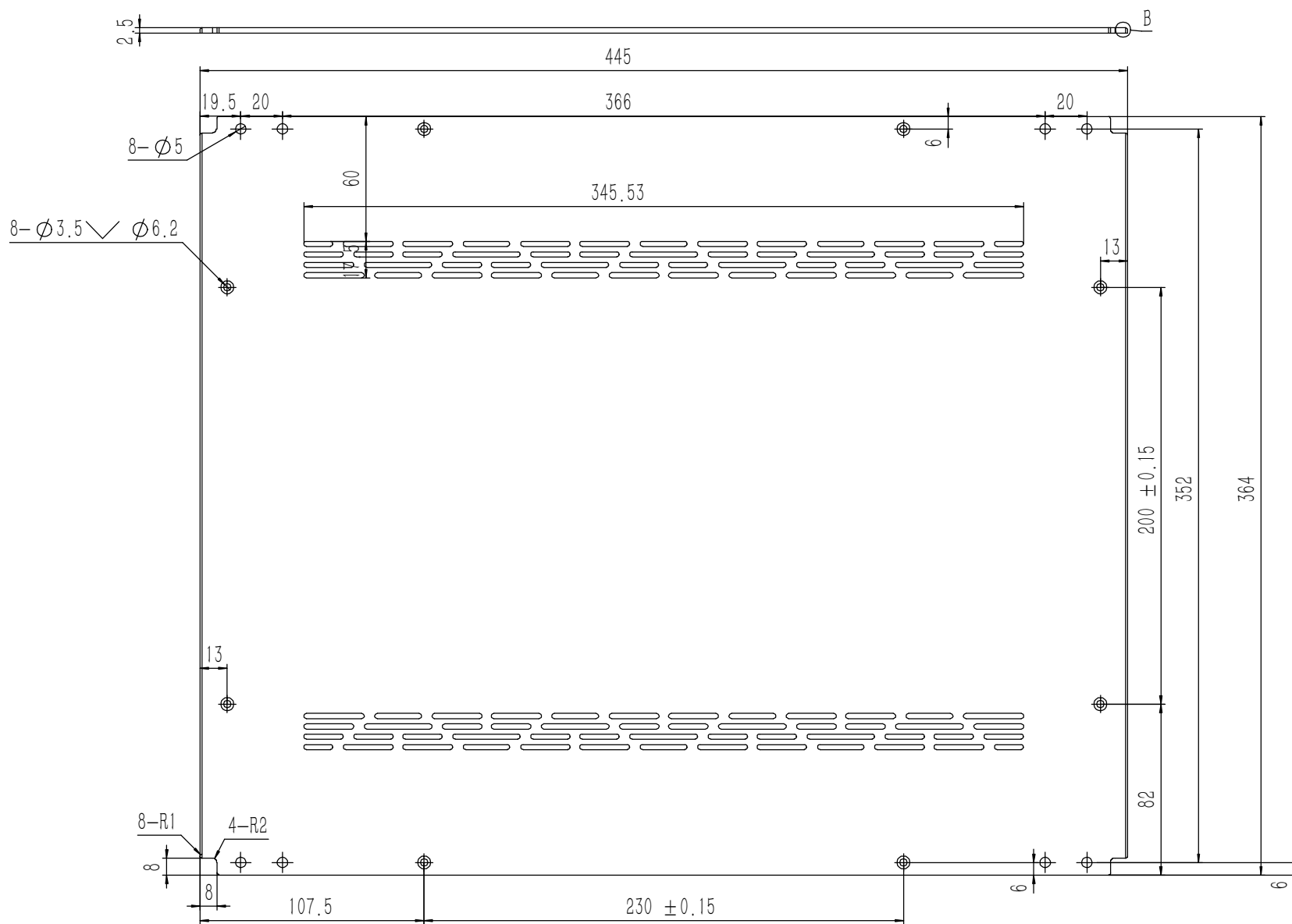
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): 6063-T5	YONGU 永固
	Weight: (重量) (Kg) 0.047	
	Protection: (表面处理):	Drawing Number (图号): YG-TY-A08-003
	Part Name (零/部件名称): A侧板固定件3U	
	Drawn by (绘图): 邓展锋	Date (日期): 2020.05.18
	Check by (校对):	Date (日期):
	Signature by (批准):	Date (日期):
	Size (图幅): A3	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。

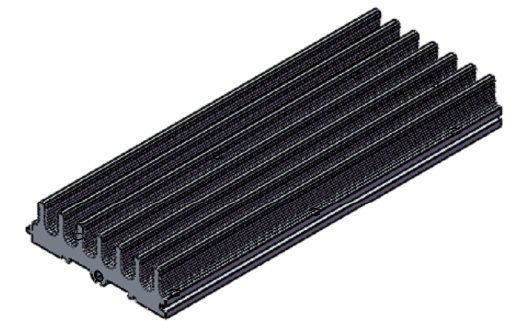
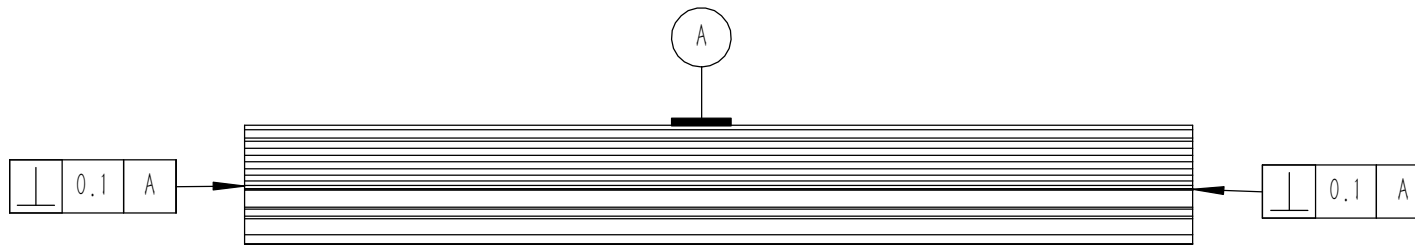
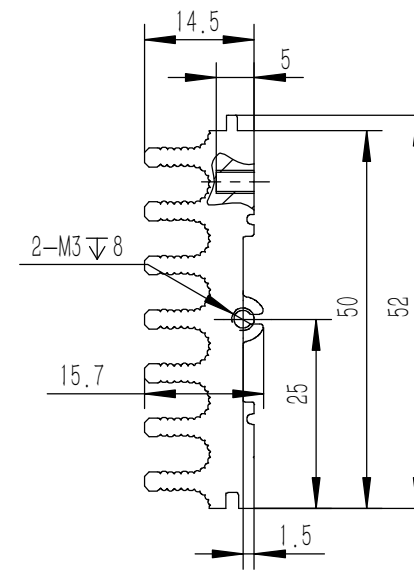
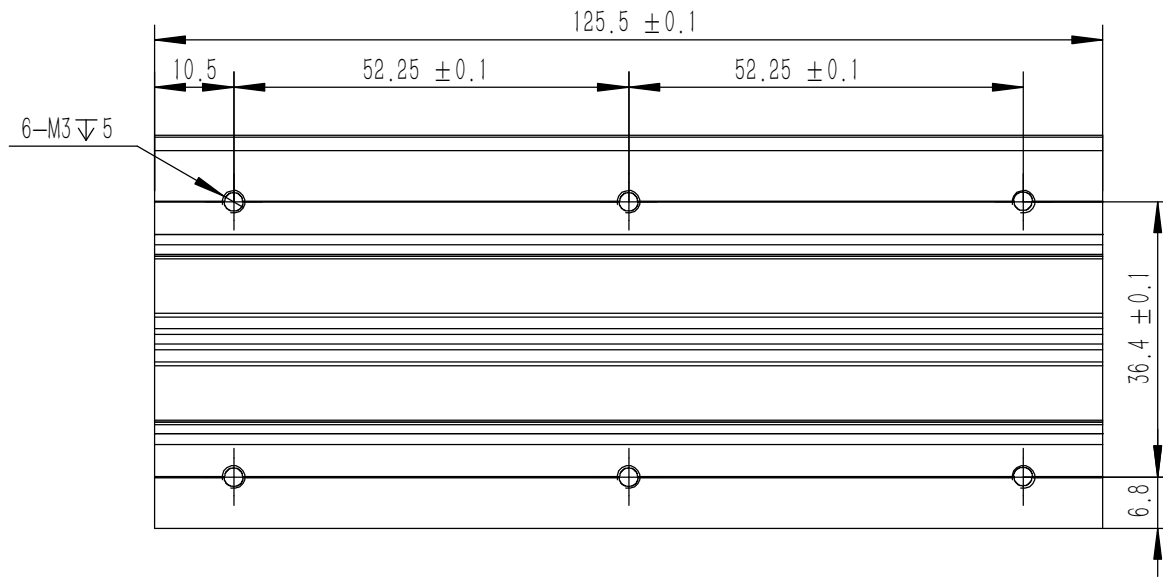
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料):	6063-T5		YONGU 永固
	Weight: (重量) (Kg)	0.274		
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):			Drawing Number (图号): YG-TY-A03-003
	Position tolerances (未注位置公差): ±0.05	Part Name (零/部件名称): 组合侧板		
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		Size (图幅): A3
	Drawn by (绘图): 莫永康	Date (日期): 2020.05.15	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):		




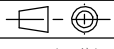
- 技术要求:
- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
 - 2、去除毛刺飞边, 锐角倒钝;
 - 3、未标注尺寸见3D数模。

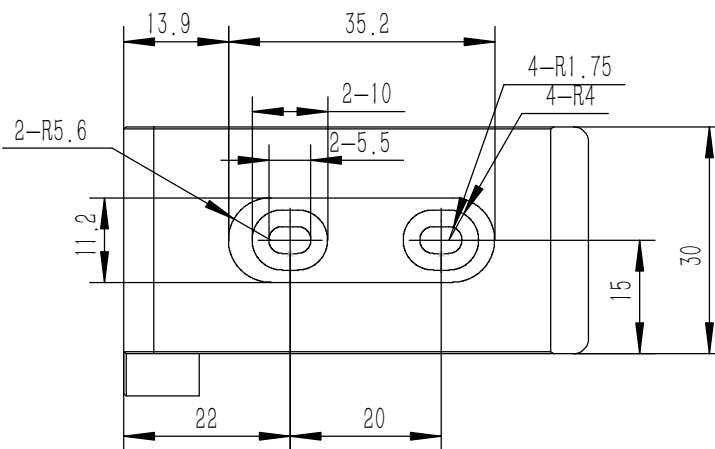
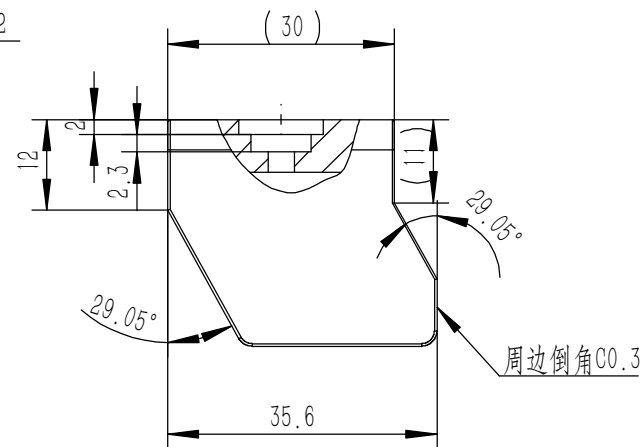
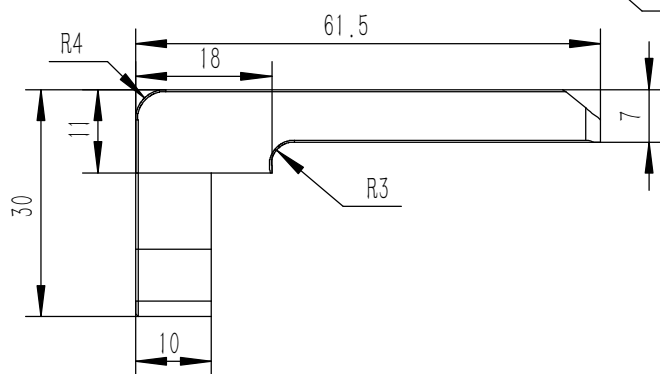
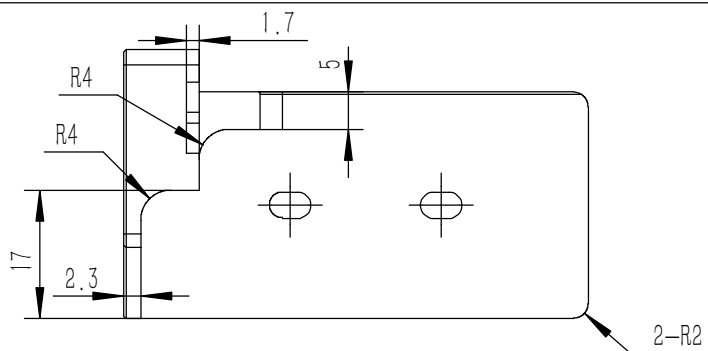
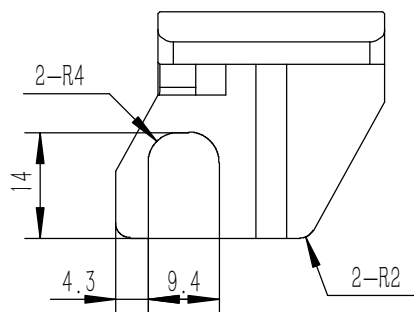
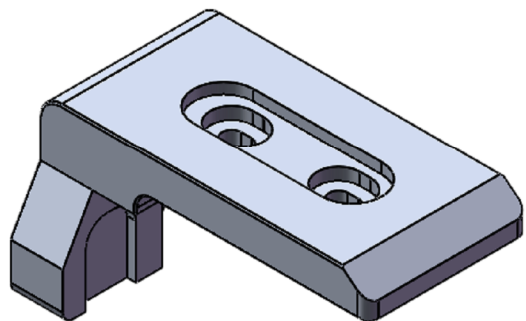
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料):	5052-H32	
	Weight: (重量) (Kg):	1.043	
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):		
	Part Name (零/部件名称):	上盖板	
Position tolerances (未注位置公差): ± 0.05	Angular tolerances (未注角度公差):	<6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	
	Drawing Number (图号): YG-TY-A02-011	Drawn by (绘图): 莫永康 Date (日期): 2020.05.18	Size: (图幅): A1 Scale (比例): 1:1
	Signature by (批准): Date (日期):	Drawing Number (图号): YG-TY-A02-011	Revision (版本): A1

YONGU 永固



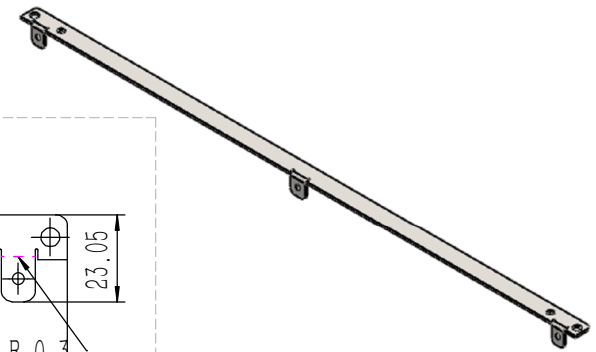
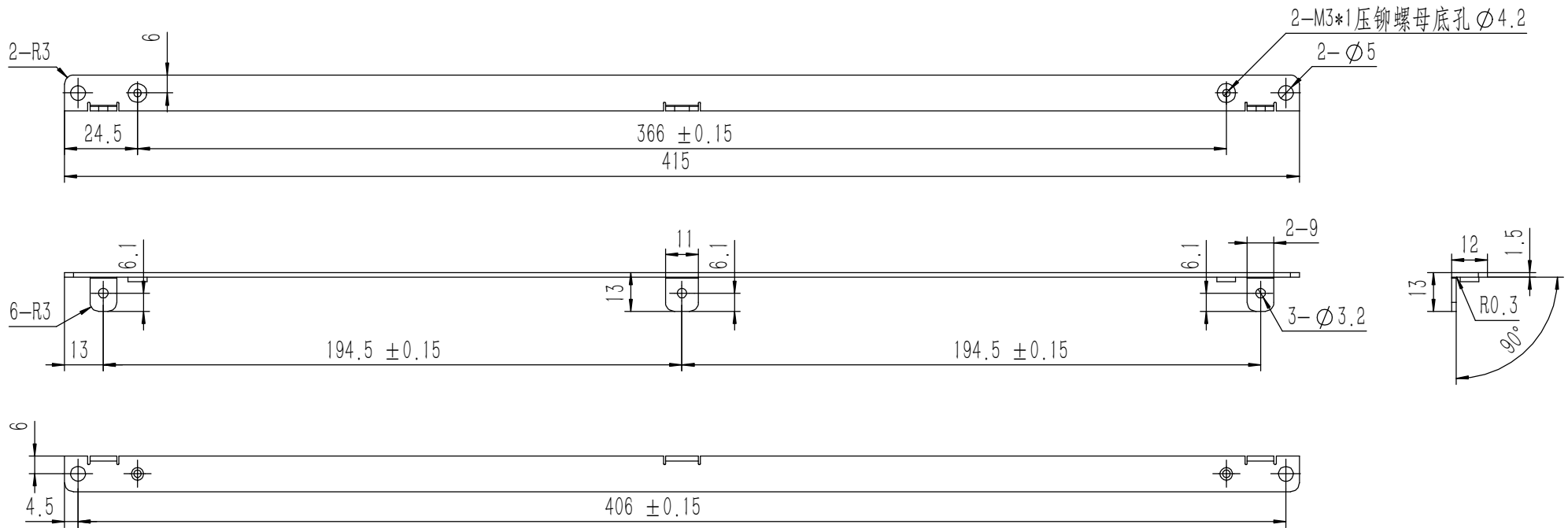
- 技术要求:
- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
 - 2、去除毛刺飞边, 锐角倒钝;
 - 3、未标注尺寸见3D数模。

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): 6063-T5	YONGU 		
	Weight: (重量) (Kg) 0.144			
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): 组合侧板		
	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°	Date (日期): 2020.05.15	Drawing Number (图号): YG-TY-A04-003
Drawn by (绘图): 莫永康		Date (日期):	Scale (比例): 1:1	Sheet (页数):  1 / 1
Check by (校对):		Date (日期):	Revision (版本): A1	
Signature by (批准):		Date (日期):		

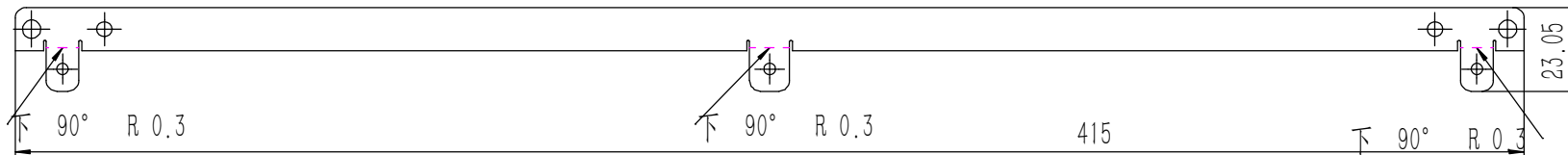


- 技术要求:
- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
 - 2、去除毛刺飞边, 锐角倒钝;
 - 3、未标注尺寸见3D数模。

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): 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):	
	Position tolerances (未注位置公差): ±0.05	A包角1	
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):	
	Part Name (零/部件名称):	YG-TY-A05-001	
Part Name (零/部件名称):	Drawn by (绘图): 莫永康	Date (日期): 2020.05.18	Size: (图幅): A4
Part Name (零/部件名称):	Check by (校对):	Date (日期):	Scale (比例): 1:1
Part Name (零/部件名称):	Signature by (批准):	Date (日期):	Revision (版本): A1
Part Name (零/部件名称):	Part Name (零/部件名称):	Part Name (零/部件名称):	Sheet (页数): 1 / 1



钣金展开及折弯方向参考图 (视图比例1:1)

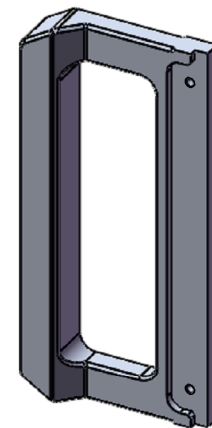
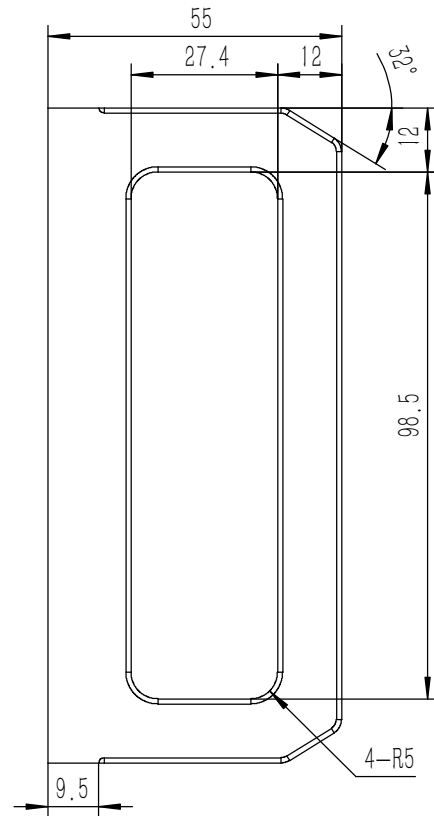
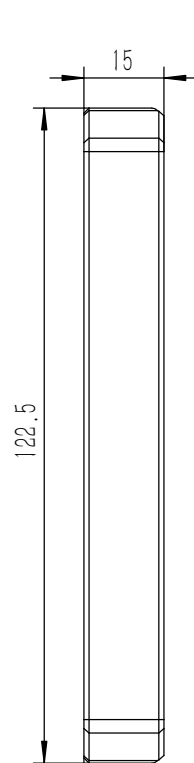
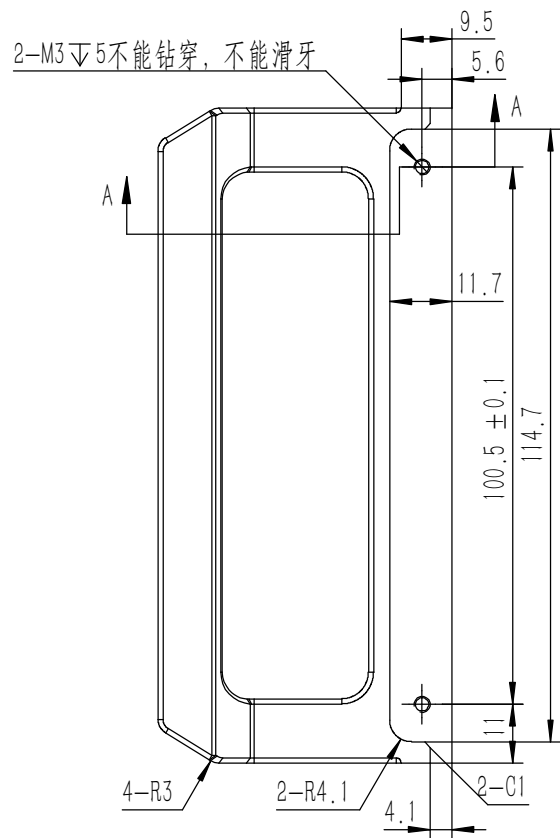
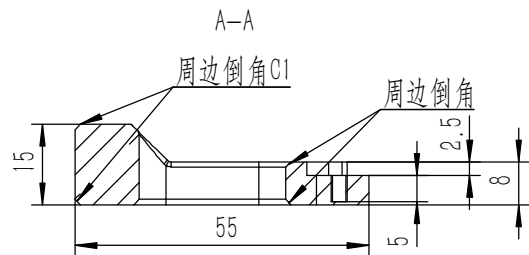


业务代码:

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。

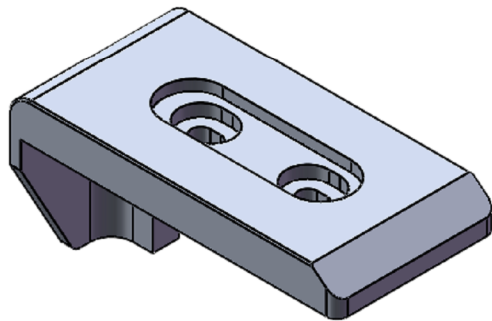
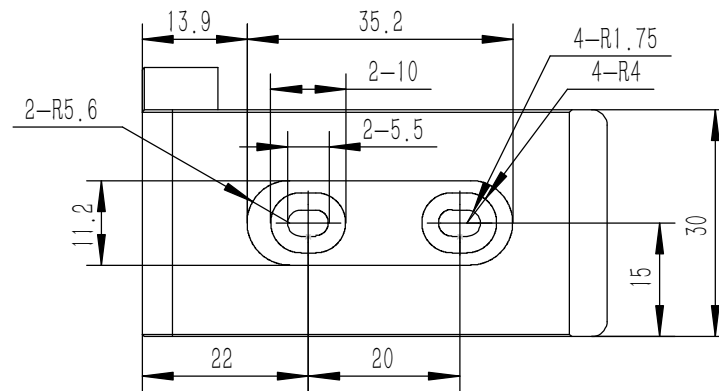
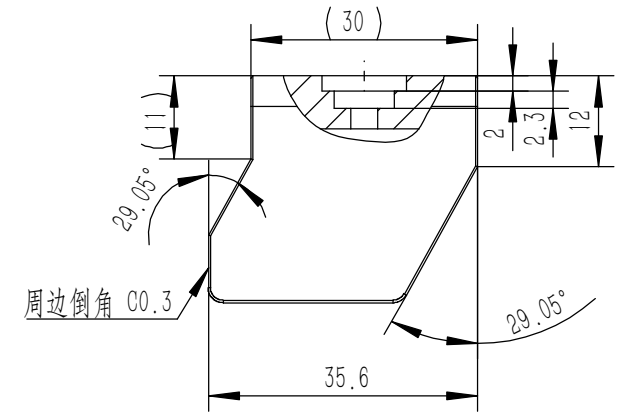
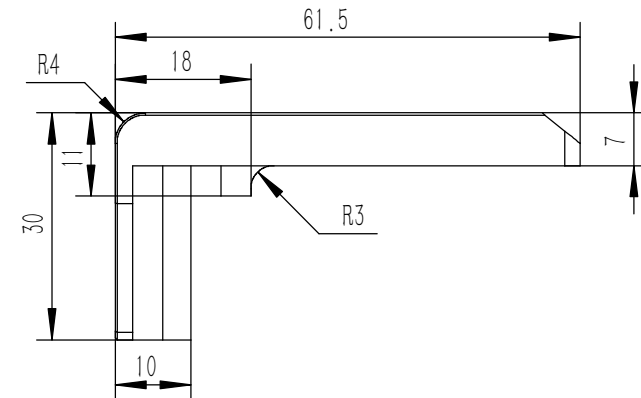
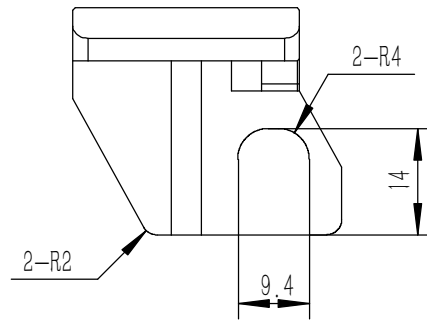
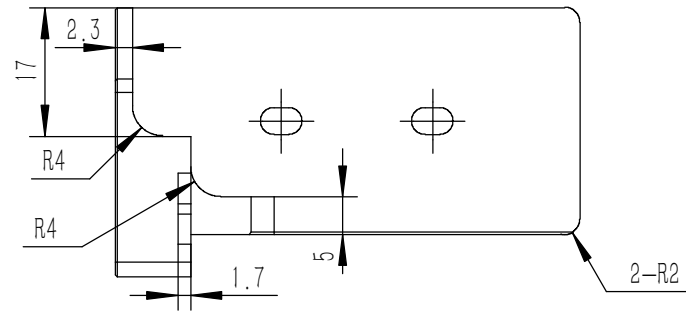
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): 电解板	YONGU 永固	Drawing Number (图号): YG-TY-A10-003
	Weight: (重量) (Kg): 0.061		
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理): 毛坯	面板上固定件3	Size: (图幅): A2
	Part Name (零/部件名称):		
Position tolerances (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):	Revision (版本): A1
	Drawn by (绘图): 许宏彬	Date (日期): 2020.09.18	Scale (比例): 1:1
	Check by (校对):	Date (日期):	
	Signature by (批准):	Date (日期):	



技术要求:

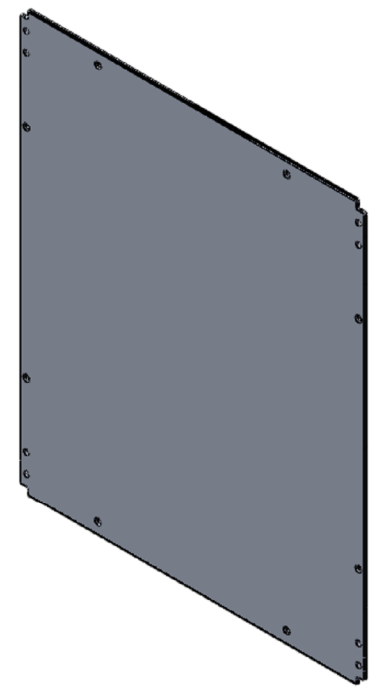
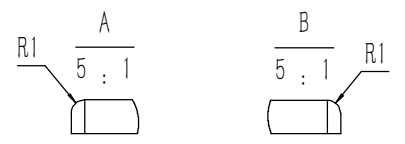
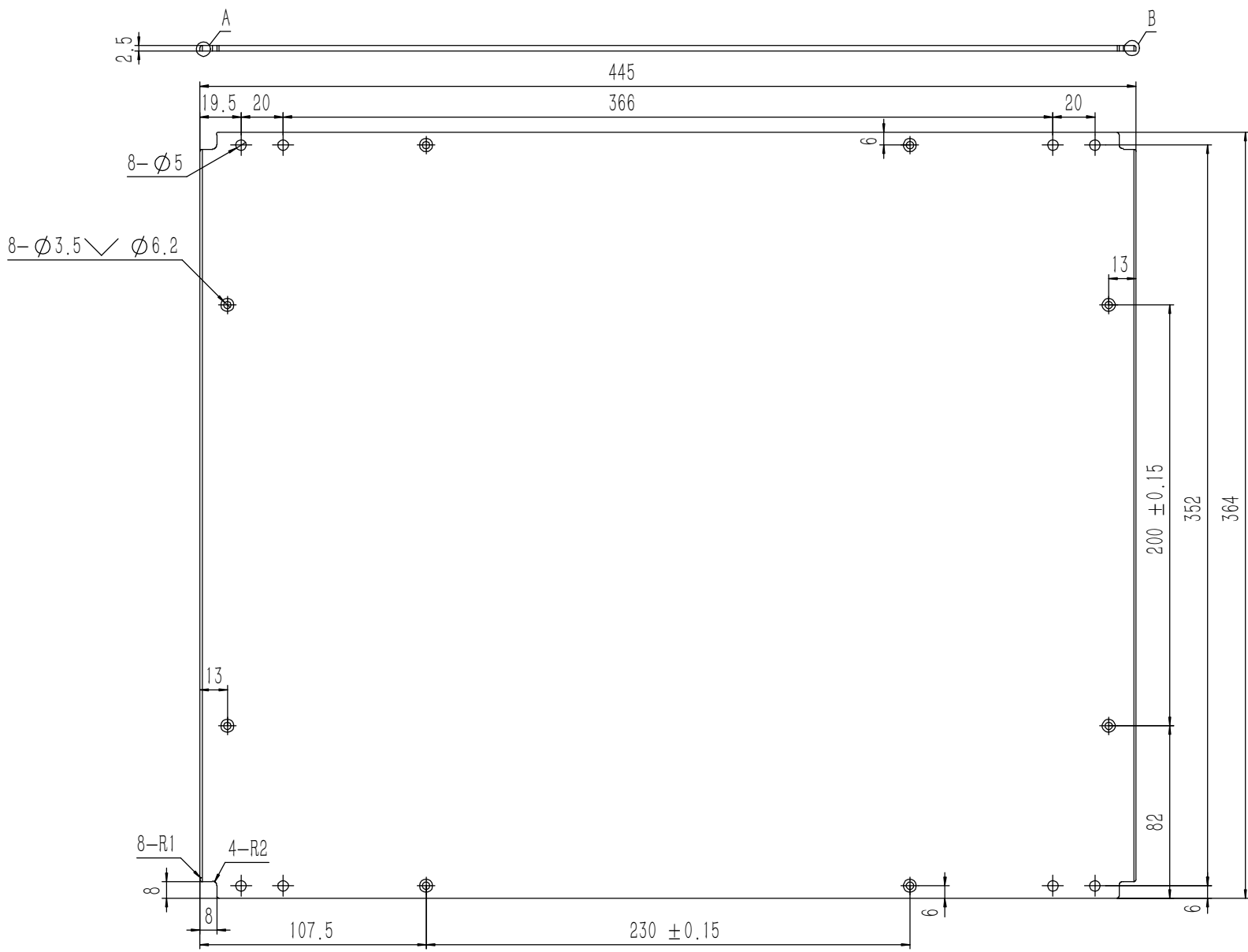
- 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
- 2、去除毛刺飞边, 锐角倒钝;
- 3、未标注尺寸见3D数模。

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)	0.103		
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-TY-A06-003
	Position tolerances (未注位置公差): ±0.05	Part Name (零/部件名称):	拉手-3U	
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):	2020.05.18
	Signature by (批准):		Date (日期):	
		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。

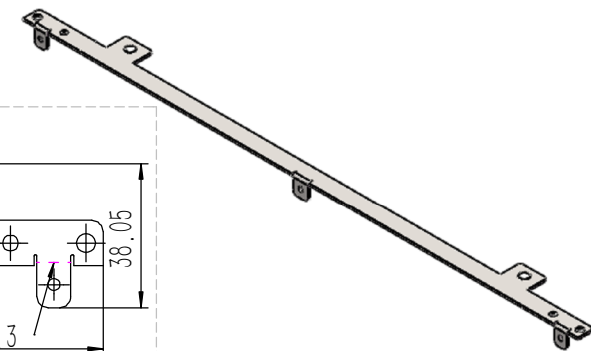
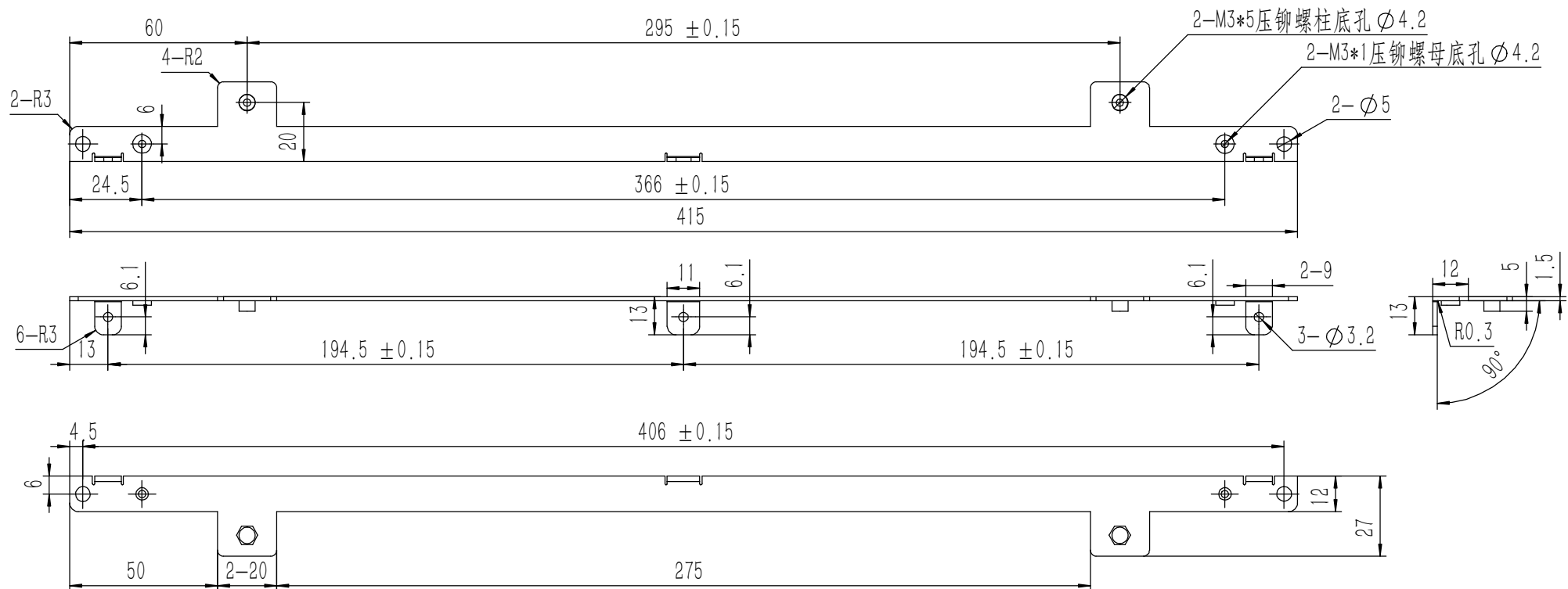
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料): 6063-T5	YONGU 永固	
	Weight: (重量) (Kg) 0.043		
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):	Part Name (零/部件名称):	
	Position tolerances (未注位置公差): ±0.05	A包角2	
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Part Name (零/部件名称):	Drawing Number (图号):	
	Part Name (零/部件名称):	YG-TY-A05-002	
Drawn by (绘图):	Date (日期): 2020.05.18	Size: (图幅): A4	Sheet (页数):
Check by (校对):	Date (日期):	Scale (比例): 1:1	
Signature by (批准):	Date (日期):	Revision (版本): A1	1 / 1



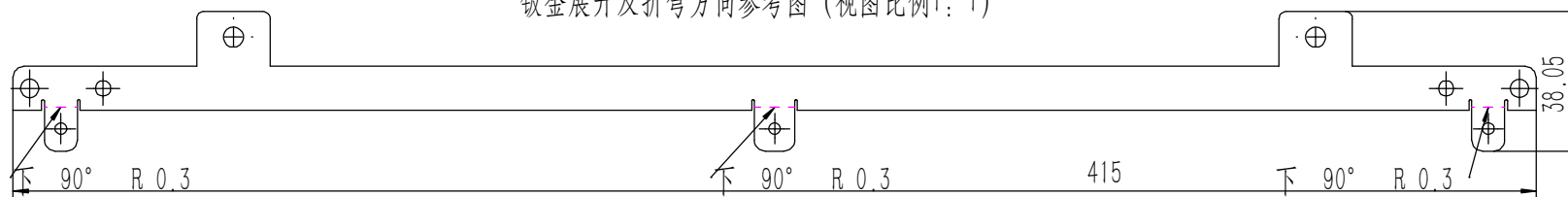
技术要求:
 1、零件加工表面不应有划痕、擦伤等损伤零件表面的缺陷;
 2、去除毛刺飞边,锐角倒钝;
 3、未标注尺寸见3D数模。

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):	1.081	
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):	
Angular tolerances (未注角度公差): <6° ± 10' <30° ± 20' <120° ± 30' >120° ± 1°	Drawing Number (图号):		YG-TY-A01-011
	Part Name (零/部件名称):		上下盖板
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





钣金展开及折弯方向参考图 (视图比例1:1)

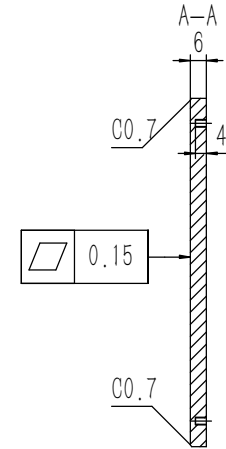
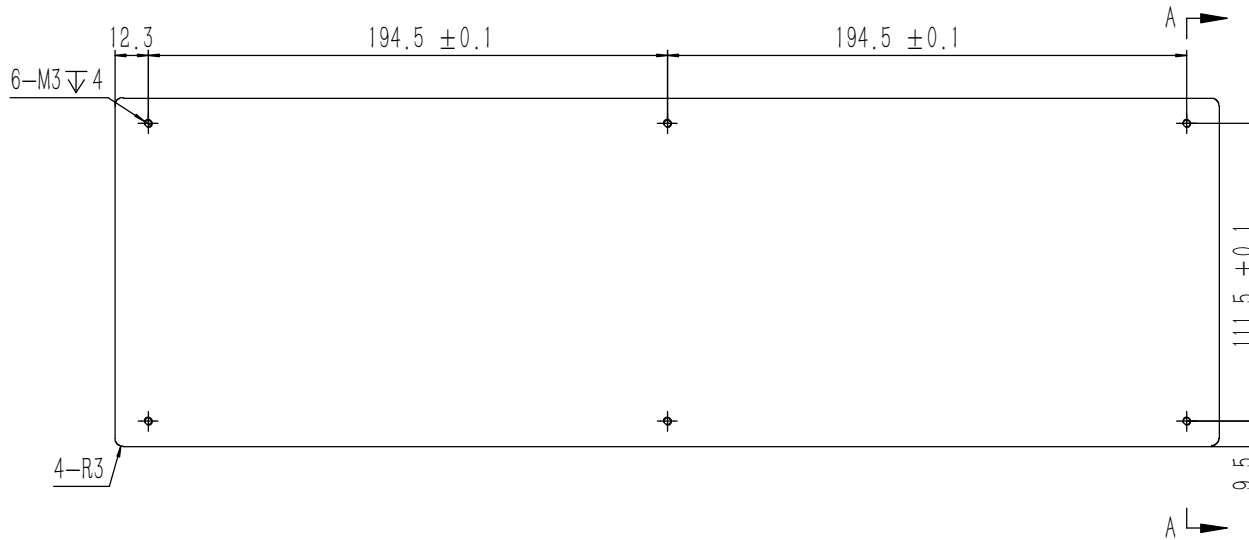
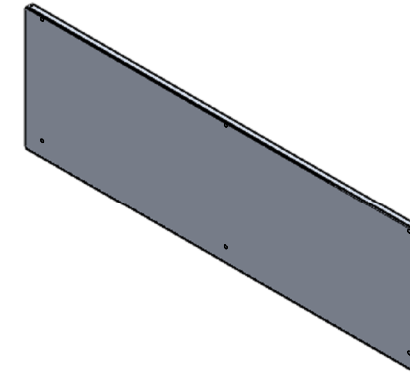
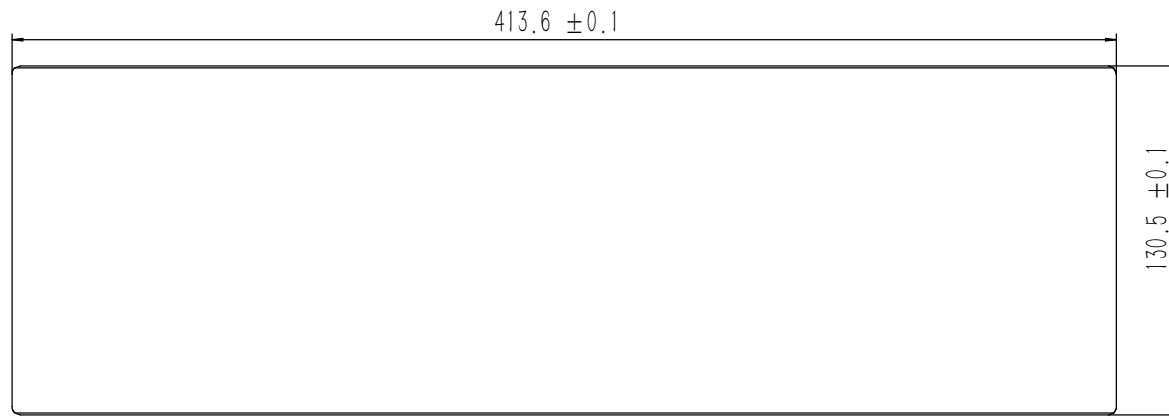


业务代码:

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)	YONGU 永固	Drawing Number (图号): YG-TY-A11-003
	Weight: (重量) (Kg): 0.069		
	Protection: (表面处理): 毛坯		
	Part Name (零/部件名称):		
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3	
Position tolerances (未注位置公差): ±0.05	Drawn by (绘图): 许宏彬	Date (日期): 2020.09.18	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

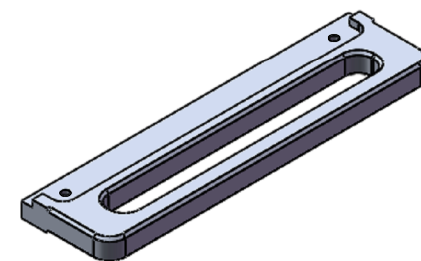
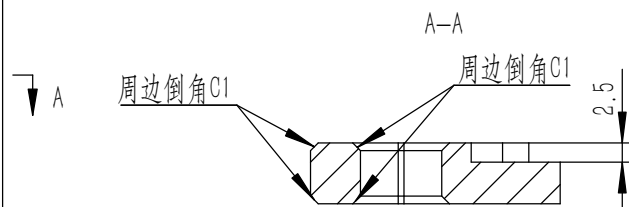
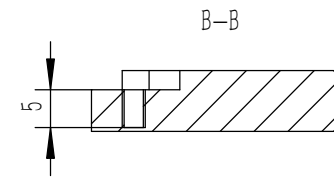
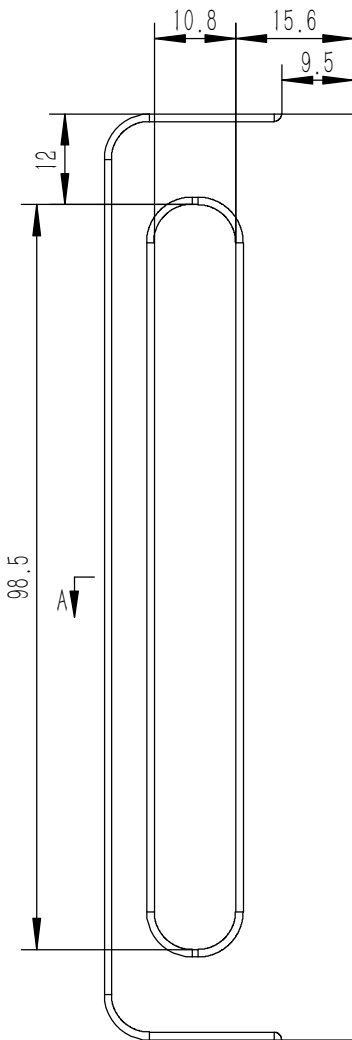
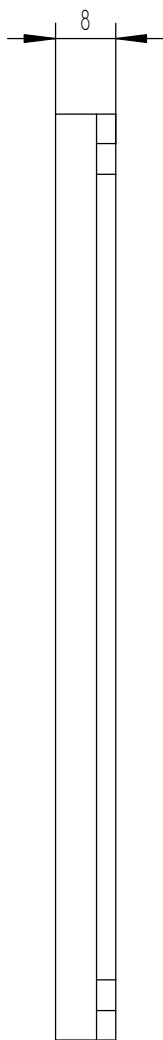
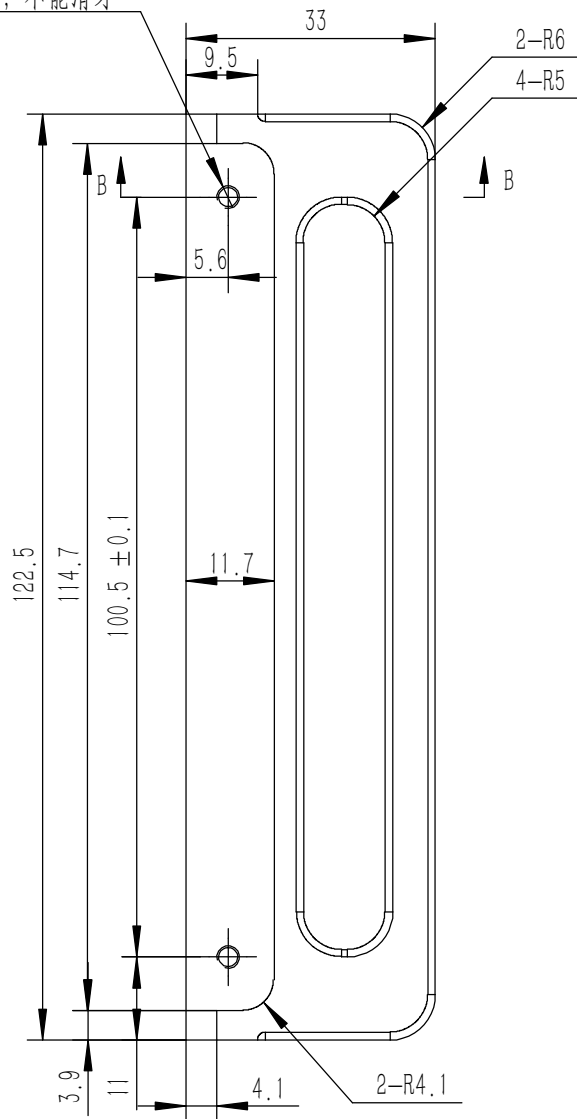


技术要求:

- 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):	0.867					
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-TY-A12-011			
	Position tolerances (未注位置公差): ± 0.05	Part Name (零/部件名称): 前后面板-3U					
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):	2020.05.18	Size: (图幅):	A1	Sheet (页数): 1 / 1
	Signature by (批准):		Date (日期):		Scale (比例):	1:1	
	Revision (版本):	A1					

2-M3 5不能钻穿, 不能滑牙

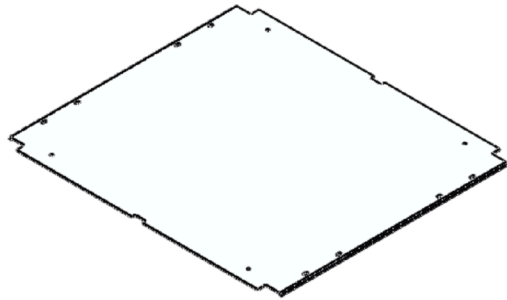
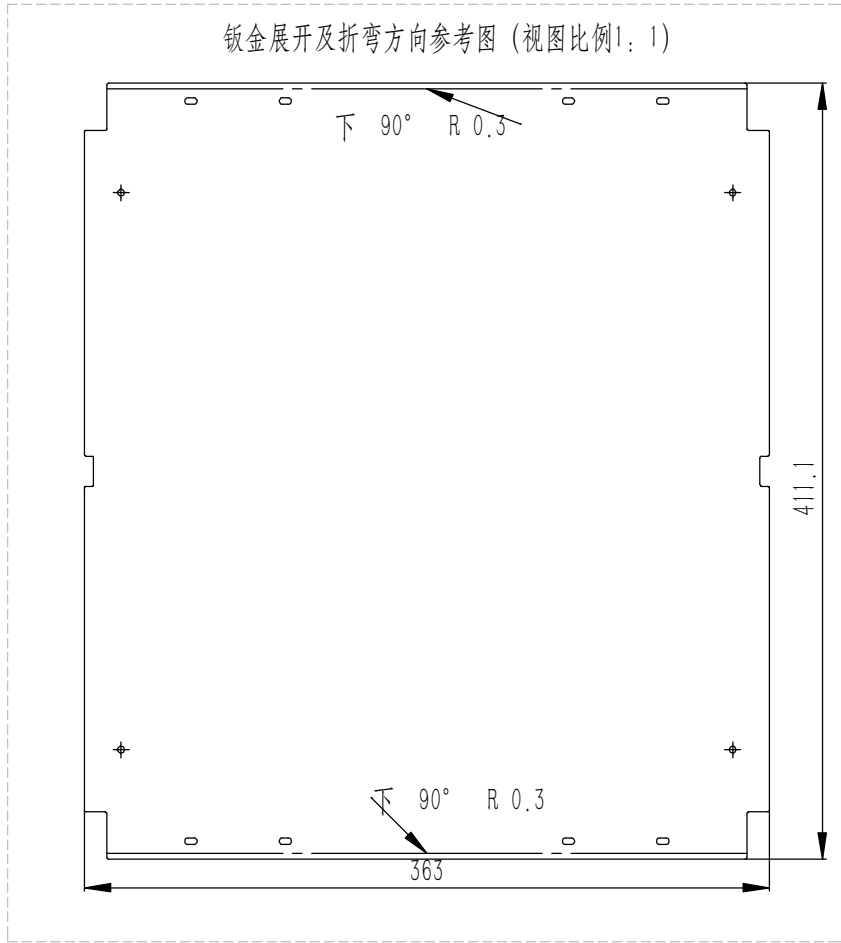


技术要求:

- 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。

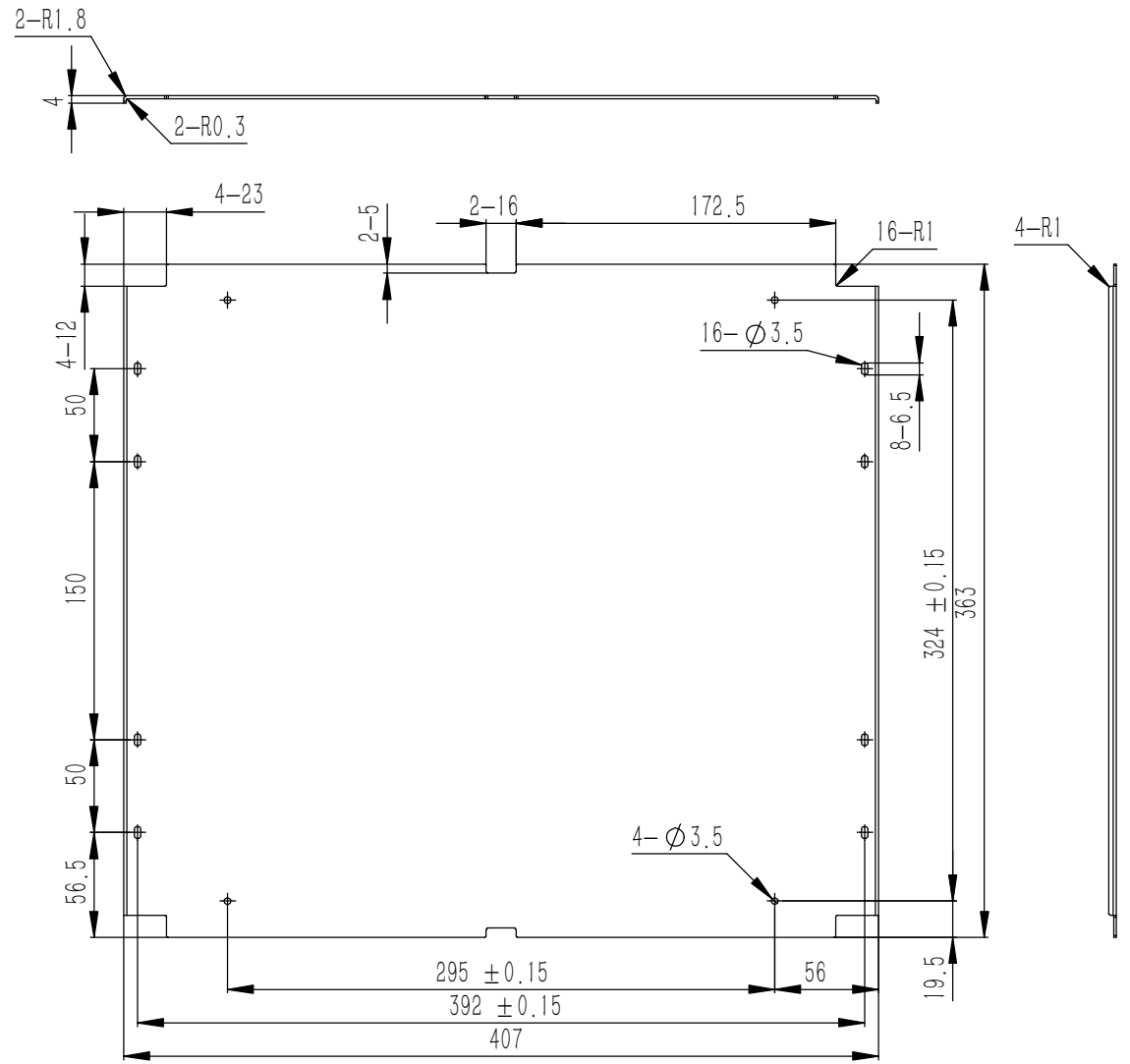
Tolerances (未注公差): 0.5 to 6 ± 0.1 6 to 30 ± 0.2 30 to 120 ± 0.3 120 to 400 ± 0.4	Material (材料):	5052-H32		YONGU 永固
	Weight: (重量) (Kg)	0.054		
Break sharp edges (未注锐边倒角): Ch 0.05 to 0.25 x45°	Protection: (表面处理):			
	Position tolerances (未注位置公差): ±0.05	Part Name (零/部件名称):	后防护条-3U	
Angular tolerances (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-3U		Drawing Number (图号):
	Drawn by (绘图): 邓展锋	Date (日期): 2020.05.18	Scale (比例): 1:1	Sheet (页数):
	Check by (校对):	Date (日期):	Revision (版本): A1	1 / 1
	Signature by (批准):	Date (日期):		

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:

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):	0.594			
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-TY-A13-011	
	Part Name (零/部件名称):	A垫板			
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°	Drawn by (绘图): 许宏彬	Date (日期): 2020.09.17	Size (图幅): A0	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	