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SAM/01.01 Edition: 00

Tolerance class		Permissible deviations from the nominal value d (in mm)							
Type	Description	0,5<d≤3	3<d≤6	6<d≤30	30<d≤120	120<d≤400	400<d≤1000	1000<d≤2000	2000<d≤4000
f	thin	±0,05	±0,05	±0,1	±0,15	±0,2	±0,3	±0,5	-
m	medium	±0,1	±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2
c	thick	±0,2	±0,3	±0,5	±0,8	±1,2	±2	±3	±4
v	very thick	-	±0,5	±1	±1,5	±2,5	±4	±6	±8

Tolerancias ISO 2768

Table 1. Tolerances for linear dimensions, except rounded edges

12

六角法兰面螺母 GB/T 6177.1 M6

六角螺栓 GB/T 5783 M6x45

手动UKS

六角法兰面螺母 GB/T 6177.1 M12

六角螺栓 GB/T 5783 M12x25

平垫圈 GB/T 97.1 12

OX-210AT扭簧(左1右1)

1

4

2

9

3

6

7

11

5

10

Tube=1204

DBG=1130

1186

Item Nu.	Description	Quantity	Code	Weight
12	GBT6177.1_Flange_Hex_Nut_M06_8_Zn	2	Comercial	0.00
11	GB5783_Hex_bolt_M06x45_8.8_Zn	2	Comercial	0.01
10	Sincron Bush nylon,(提拉机构套管) VKS3Z306001. AODEPU OK-210B. OKFIT CF	2	Comercial	0.00
9	Switch (开关) UKS VKS3A016001	1	Comercial	
8	GBT6177.1_Flange_Hex_Nut_M12_8_Zn	4	Comercial	0.02
7	GB5783_Hex_bolt_M12x25_8.8_Zn	4	Comercial	0.04
6	GB97_Flat_Wash_DT12_Zn	4	Comercial	0.01
5	Spring (弹簧) OX210AT-3	2	Comercial	
4	Sincro. switch stop. VKS3Z302001 (开关打板) AODEPU OX-210B. OKFIT CF	1	Comercial	0.13
3	sincron bar (提拉杆) AODEPU OX-210B. OKFIT CF450-630	1	VL07100002 / VKS3Z301C01	2.13
2	Sincron. Side brace W-Assy. (提拉机构联动件) AODEPU OX-210B. OKFIT CF	2	VL07120000 / VKS3Z303001	0.48
1	Sincron. Plate AODEPU OX-210B. (提拉机构支架). OKFIT CF	2	VL07100001 / VKS3Z300001	0.76

Item Nu.	Description	Quantity	Code	Weight
00	05/07/2022	SAM	SAM	1ª ed. del plano
Rev.	Created Date	Creat By	Checked	Change Description
Finishing	---	Toler.: 5/ISO 2768-c (mm)	Format A3	Scale 1:5
Material:			File. 文件 VL071X0000	
Title	Sincron. SET (提拉机构) . AODEPU OX-210B, OKFIT CF450-630	Thick. 厚度 (mm)	Bending R 折弯半径 (mm)	Bend.Ded.(mm)
		Project 项目 T22030065c	Part Code. 部件件号 VL071X0000	Weight (kg) 5.33
				Sheet no. 1/1
				Rev.

8

7

6

5

4

3

2

1

F

E

D

C

B

A

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SAM/01/01 - Edition: 00

Tolerance class		Permissible deviations from the nominal value d (in mm)							
Type	Description	0,5<d≤3	3<d≤6	6<d≤30	30<d≤120	120<d≤400	400<d≤1000	1000<d≤2000	2000<d≤4000
f	thin	±0,05	±0,05	±0,1	±0,15	±0,2	±0,3	±0,5	-
m	medium	±0,1	±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2
c	thick	±0,2	±0,3	±0,5	±0,8	±1,2	±2	±3	±4
v	very thick	-	±0,5	±1	±1,5	±2,5	±4	±6	±8

Tolerancias ISO 2768

Table 1. Tolerances for linear dimensions, except rounded edges

V=4 R=5

技术要求：

1 去锐角毛刺；

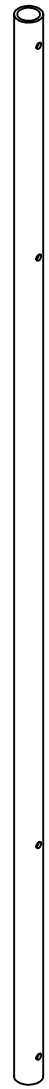
2 表面白锌。

2件/套

材料：钢板 Q235

00	25/10/2021	SAM	SAM	1ª ed. del plano
Rev.	Created Date	Creat. By	Checked	Change Description
Finishing: Painted RAL7004		Toler.: S/ISO 2768-c (mm)		Format: A4
Material: Steel sheet UNE-EN 10025-2 S235JR		File. 文件: VL07100001		Scale: 1:3
Title: Sincron. Plate AODEPU OX-210B. (提拉机构支架). OKFIT CF		Thick. 厚度 (mm): 5	Bending R 折弯半径 (mm): 5	Bend.Ded. (mm): 9
Project 项目: T22030065c		Weight (kg): 0.76		
Part Code. 部件件号: VL07100001 / VKS3Z300001		Sheet no.: 1/1		
		Rev.		

2	1
Tube Ø27x3	

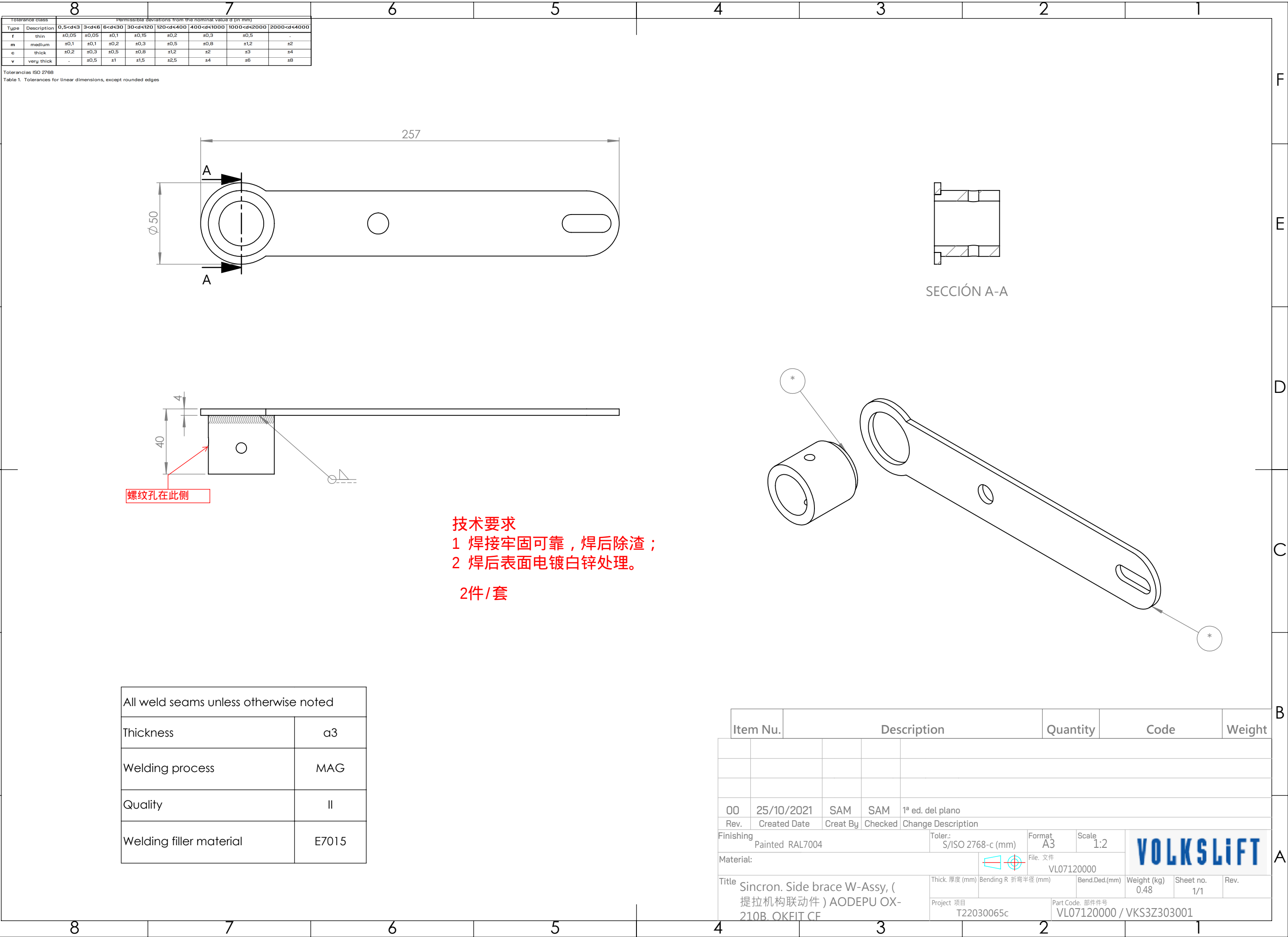


2768-c (mm)		Format A4	Scale 1:5	VOLKSLIFT		
		File. 文件 VL07100002				
Bending R 折弯半径 (mm)		Bend.Ded. (mm)	Weight (kg) 2.13	Sheet no. 1/1	Rev.	
目 T22030065c		Part Code. 部件件号 VL07100002 / VKS3Z301C01				

2	1
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SAM/01.01 Edition: 00



Tolerance class		Permissible deviations from the nominal value a (in mm)							
Type	Description	0,5<d≤3	3<d≤6	6<d≤30	30<d≤120	120<d≤400	400<d≤1000	1000<d≤2000	2000<d≤4000
f	thin	±0,05	±0,05	±0,1	±0,15	±0,2	±0,3	±0,5	-
m	medium	±0,1	±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2
c	thick	±0,2	±0,3	±0,5	±0,8	±1,2	±2	±3	±4
v	very thick	-	±0,5	±1	±1,5	±2,5	±4	±6	±8

Tolerancias ISO 2768
Table 1. Tolerances for linear dimensions, except rounded edges

螺纹孔在此侧

技术要求
1 焊接牢固可靠，焊后除渣；
2 焊后表面电镀白锌处理。

2件/套

All weld seams unless otherwise noted	
Thickness	a3
Welding process	MAG
Quality	II
Welding filler material	E7015

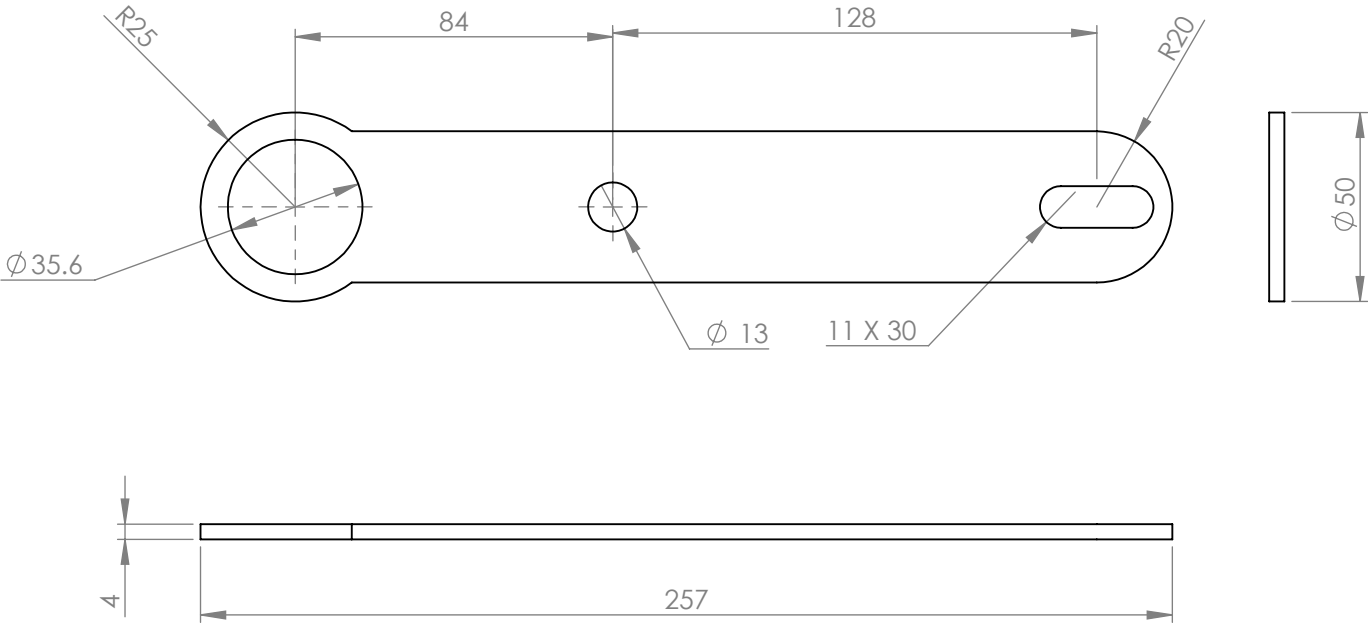
Item Nu.	Description				Quantity	Code	Weight
00	25/10/2021	SAM	SAM	1ª ed. del plano			
Rev.	Created Date	Creat By	Checked	Change Description			
Finishing	Painted RAL7004			Toler.: S/ISO 2768-c (mm)	Format A3	Scale 1:2	VOLKSLIFT
Material:					File. 文件	VL07120000	
Title	Sincron. Side brace W-Assy, (提拉机构联动件) AODEPU OX-210B. OKFIT CF			Thick. 厚度 (mm)	Bending R 折弯半径 (mm)	Bend.Ded.(mm)	Weight (kg) 0.48
	Project 项目 T22030065c					Part Code. 部件件号 VL07120000 / VKS3Z303001	Sheet no. 1/1
							Rev.

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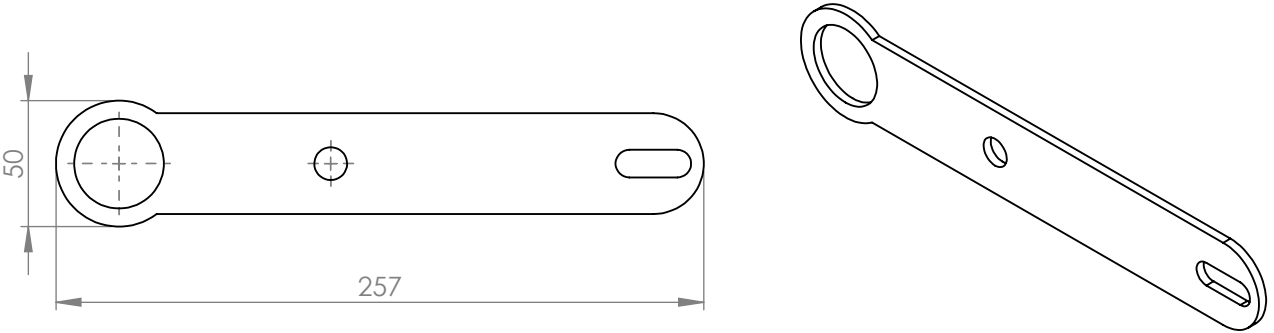
Tolerance class		Permissible deviations from the nominal value d (in mm)							
Type	Description	0,5<d≤3	3<d≤6	6<d≤30	30<d≤120	120<d≤400	400<d≤1000	1000<d≤2000	2000<d≤4000
f	thin	±0,05	±0,05	±0,1	±0,15	±0,2	±0,3	±0,5	-
m	medium	±0,1	±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2
c	thick	±0,2	±0,3	±0,5	±0,8	±1,2	±2	±3	±4
v	very thick	-	±0,5	±1	±1,5	±2,5	±4	±6	±8

Tolerancias ISO 2768

Table 1. Tolerances for linear dimensions, except rounded edges



材料：钢板 Q235



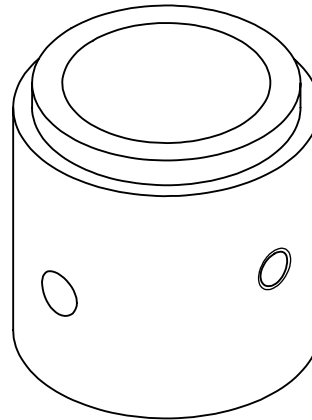
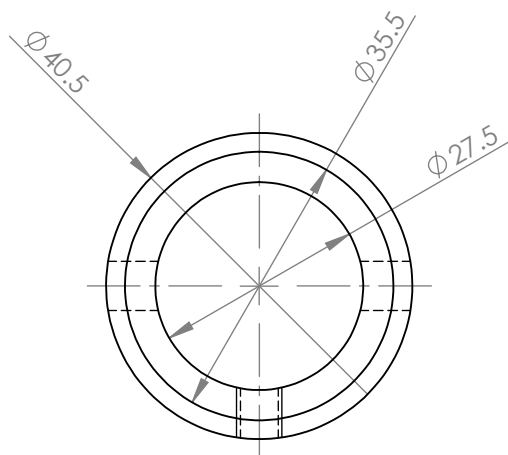
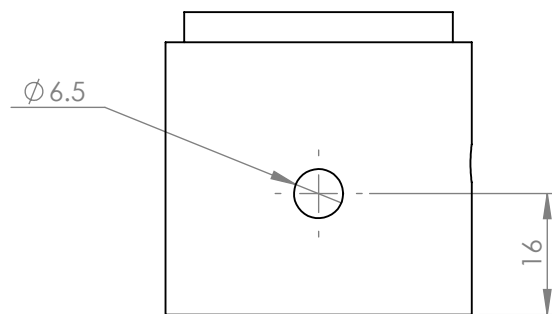
00	25/10/2021	SAM	SAM	1ª ed. del plano
Rev.	Created Date	Creat. By	Checked	Change Description
Finishing...				Toler. S/ISO 2768-c (mm)
Material: Steel sheet UNE-EN 10025-2 S235JR				Format A4
Title Sincron. Side brace (联动杆)				Scale 1:2
AODEPU OX-210B. OKFIT CF				File. 文件 VL07120001
Thick. 厚度 (mm) 4		Bending R 折弯半径 (mm) 3		Bend.Ded. (mm)
Project 项目 T22030065c		Part Code. 部件件号 VL07120001 / VKS3Z304001		Weight (kg) 0.28
				Sheet no. 1/1
				Rev.

VOLKSLIFT

Tolerancias ISO 2768

Table 1. Tolerances for linear dimensions, except rounded edges

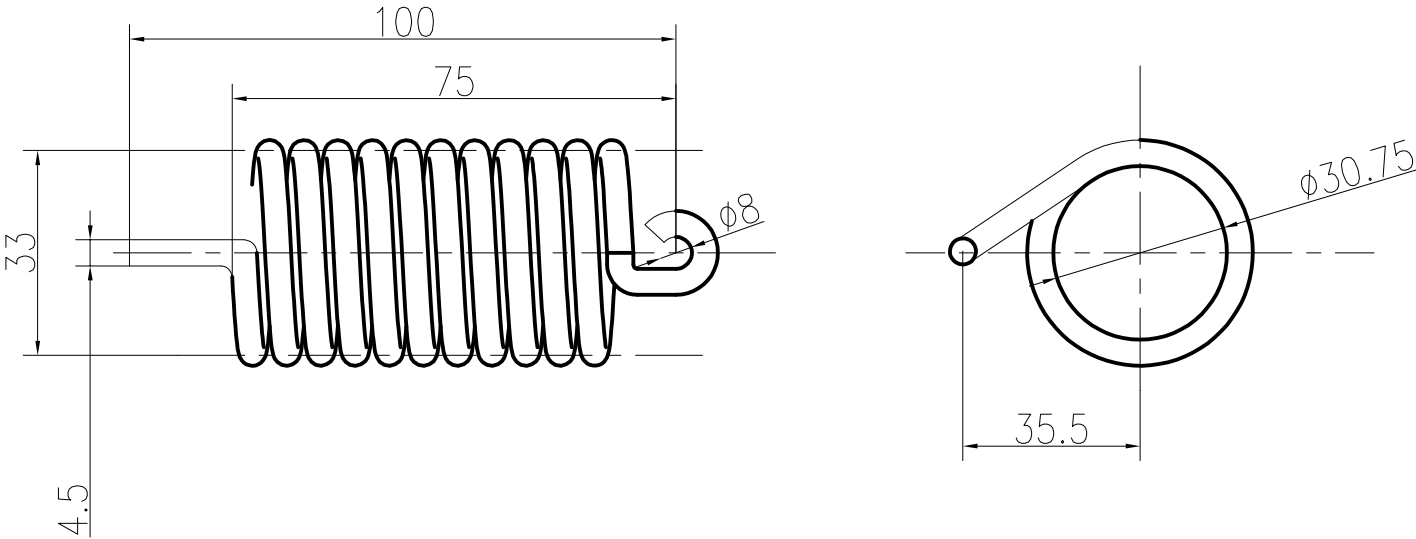
Table 1. Tolerances for linear dimensions, except rounded edges



材料：钢管 42x8 Q235

00	25/10/2021	SAM	SAM	1ª ed. del plano			
Rev.	Created Date	Creat. By	Checked	Change Description			
Finishing. _ _				Toler. S/ISO 2768-c (mm)			
				Format A4			
				Scale 1:1			
Material: Steel UNE-EN-ISO 683-1 C45 (+N)							
Title Sincron. Side brace Tip,(联动筒) AODEPU OX-210B. OKFIT CF				File. 文件 VL07120002			
Thick. 厚度 (mm) _		Bending R 折弯半径 (mm)		Bend.Ded. (mm)	Weight (kg) 0.20	Sheet no. 1/1	Rev.
Project 项目 T22030065c		Part Code 零件号 VL07120002 / VKS3Z305001					

A3		LENGTH/ DIAMETER							RADIUS/ CHAMFER			ANGLE (shorter side length)							
		0.5-6	>6-30	>30-120	>120-400	>400-1000	>1000-2000	>2000-4000	0.5-3	>3-6	>6	0-10	>10-50	>50-120	>120-400	>400			
		TOLERANCE							TOLERANCE			TOLERANCE							
		± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2	± 0.2	± 0.5	± 1	± 1°	± 0.5°	± 0.3°	± 0.15°	± 0.1°			



线径 d	中径 d	总圈数	有效圈数
4.5	33	11	11

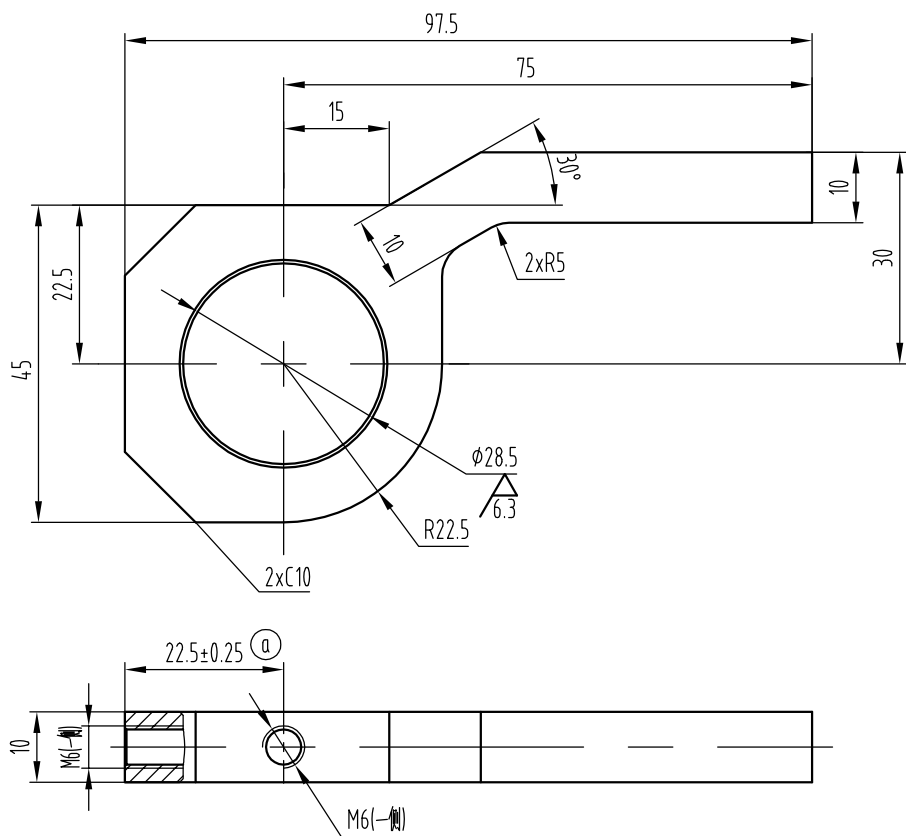
用OX-210A扭簧代替
镀白锌
1件/套

技术要求:
1、表面电镀白锌
2、该件为左旋

件号: PVKS3Z198001/V20E000105

ALL DIMENSIONS METRIC

						VOLKSLIFT		扭簧 Torsion Spring		VKS3Z198		
						绘图 DRAWN	张波	材料: 72B-φ4.5	首次下发版本 FIRST VERSION	重 量 WEIGHT	比 例 PROPORTION	
						校对 CHK	闵传宏					
						批准 APPD	徐 勇					
标记 MARK	更 改 原 因 及 说 明 CHANGE REASONS AND INSTRUCTIONS		更改日期 CHANGE DATE	更改 CHANGE	审查 CHECK	版本 VERSION	日期 DATE	2019.04.23	MATERIAL:	SHEETS 2	1	SHEET



1件/套

技术要求

- 1 本开关打杆浇铸成型，旧牌号为ZG35；
- 2 表面不得有裂纹、砂眼、变形等缺陷；
- 3 内孔 $\phi 28.5$ 两侧倒角C0.5；
- 4 表面（电）镀白锌处理，锌层厚度不小于8um。

G01	开关打杆
G00	名称

						 宁波奥德普电梯部件有限公司 NINGBO AODEPU ELEVATOR COMPONENTS CO., LTD.		
①	1					ZG270-500 GB/T 11352		
标记	处数	分区	更改文件号	签名	年、月、日	开关打杆		
设计			标准化			阶段标记	重量	比例
审核								1:1
工艺			批准			共 2 张 第 1 页		
						VKS3Z302001 AX210AT102		

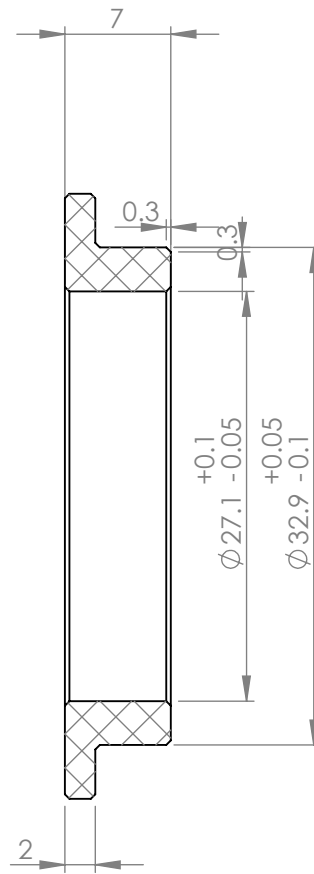
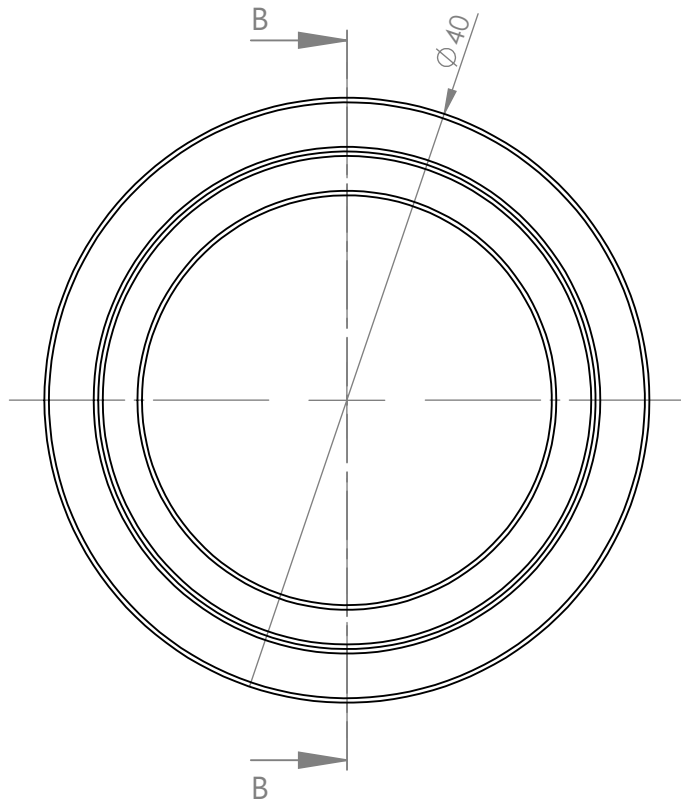
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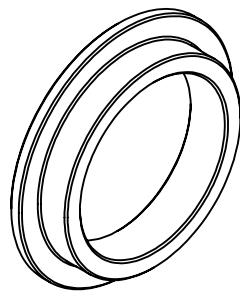
Tolerance class		Permissible deviations from the nominal value d (in mm)							
Type	Description	0,5<d≤3	3<d≤6	6<d≤30	30<d≤120	120<d≤400	400<d≤1000	1000<d≤2000	2000<d≤4000
f	thin	±0,05	±0,05	±0,1	±0,15	±0,2	±0,3	±0,5	-
m	medium	±0,1	±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2
c	thick	±0,2	±0,3	±0,5	±0,8	±1,2	±2	±3	±4
v	very thick	-	±0,5	±1	±1,5	±2,5	±4	±6	±8

Tolerancias ISO 2768

Table 1. Tolerances for linear dimensions, except rounded edges



SECCIÓN B-B



技术要求：
1 表面不得有裂纹，缺口；
2 未注倒角C0.3

材料：尼龙棒 PA6

00	16/12/2021	SAM	SAM	1ª ed. del plano
Rev.	Created Date	Creat. By	Checked	Change Description
Finishing...				Toler. S/ISO 2768-c (mm)
Material: Poliamide PA-6				Format A4
Title Sincron Bush nylon,(提拉机构套管) AODEPU OK- 210B. OKFIT CF				Scale 2:1
Thick. 厚度 (mm)				File. 文件 VL07120003
Bending R 折弯半径 (mm)				Weight (kg) 0.00
Bend.Ded. (mm)				Sheet no. 1/1
Project 项目 T22030066.a				Rev.
Part Code. 部件件号 VL07120003 / VKS3Z306001				

VOLKSLIFT