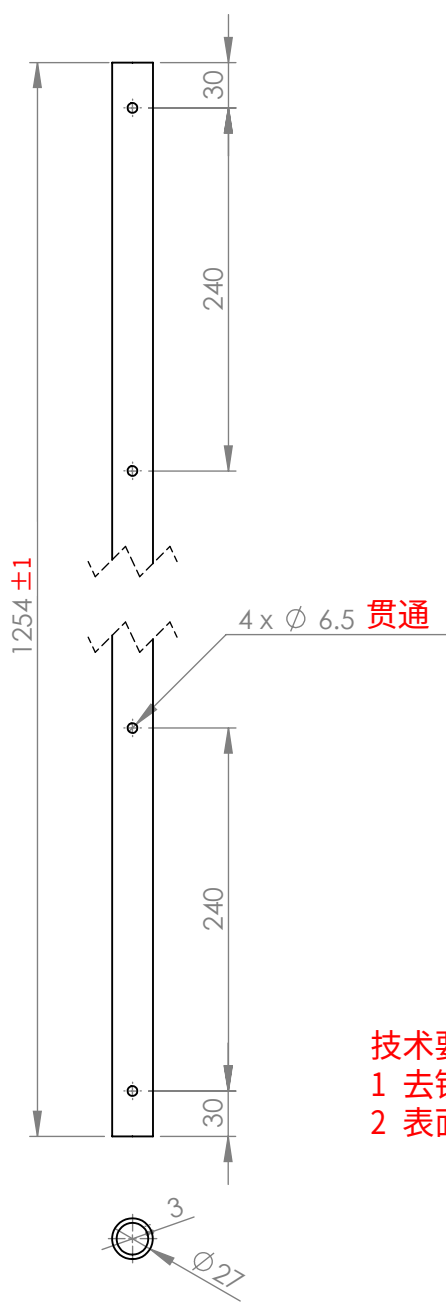


4	3	2	1
---	---	---	---

Tolerance class		Permissible deviations from the nominal value d (in mm)							
Type	Description	0,5<d<3	3<d<6	6<d<10	10<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

Tube Ø27x2

Table 1. Tolerances for linear dimensions, except rounded edges



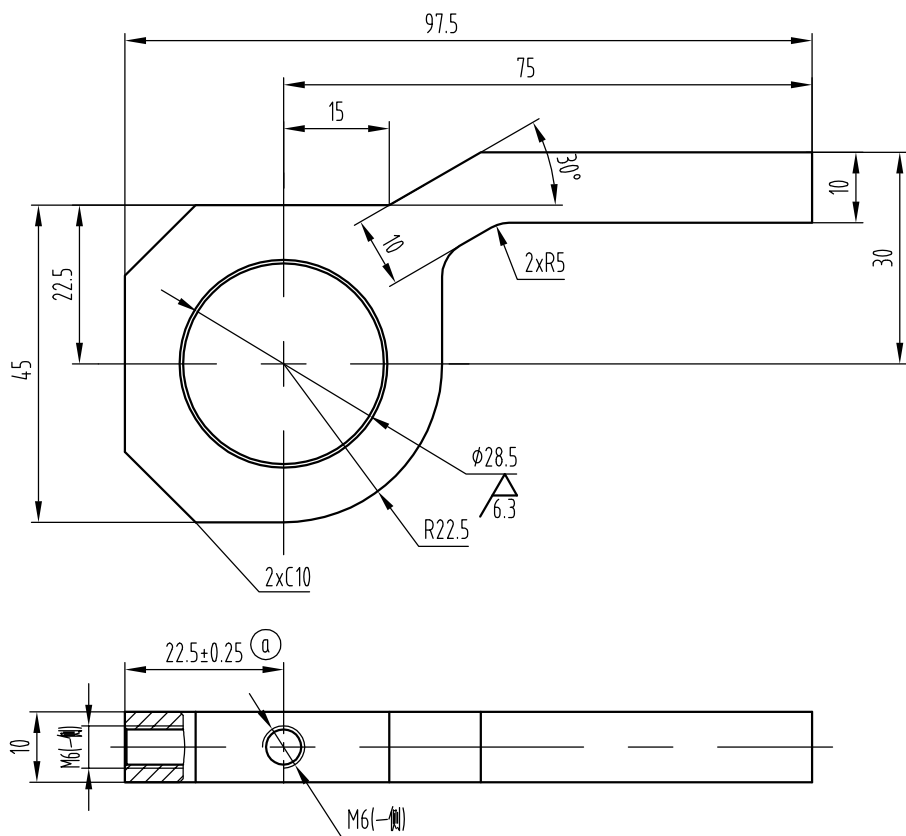
技术要求：
1 去锐角毛刺；
2 表面白锌。

1件/套

材料：钢管27x3 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 1:5			
Material: Perfil acero UNE-EN 10025-2 S235JR							
Title sincron bar (提拉杆) AODEPU OX-210B. OKFIT CF				File. 文件 VL07100002			
							
Thick. 厚度 (mm) 2		Bending R 折弯半径 (mm)		Bend.Ded. (mm)	Weight (kg) 2.22	Sheet no. 1/1	Rev.
Project 项目 T22030066.a				Part Code. 部件件号 VL07100002 / VKS3Z301C01			

4	3	2	1
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1件/套

技术要求

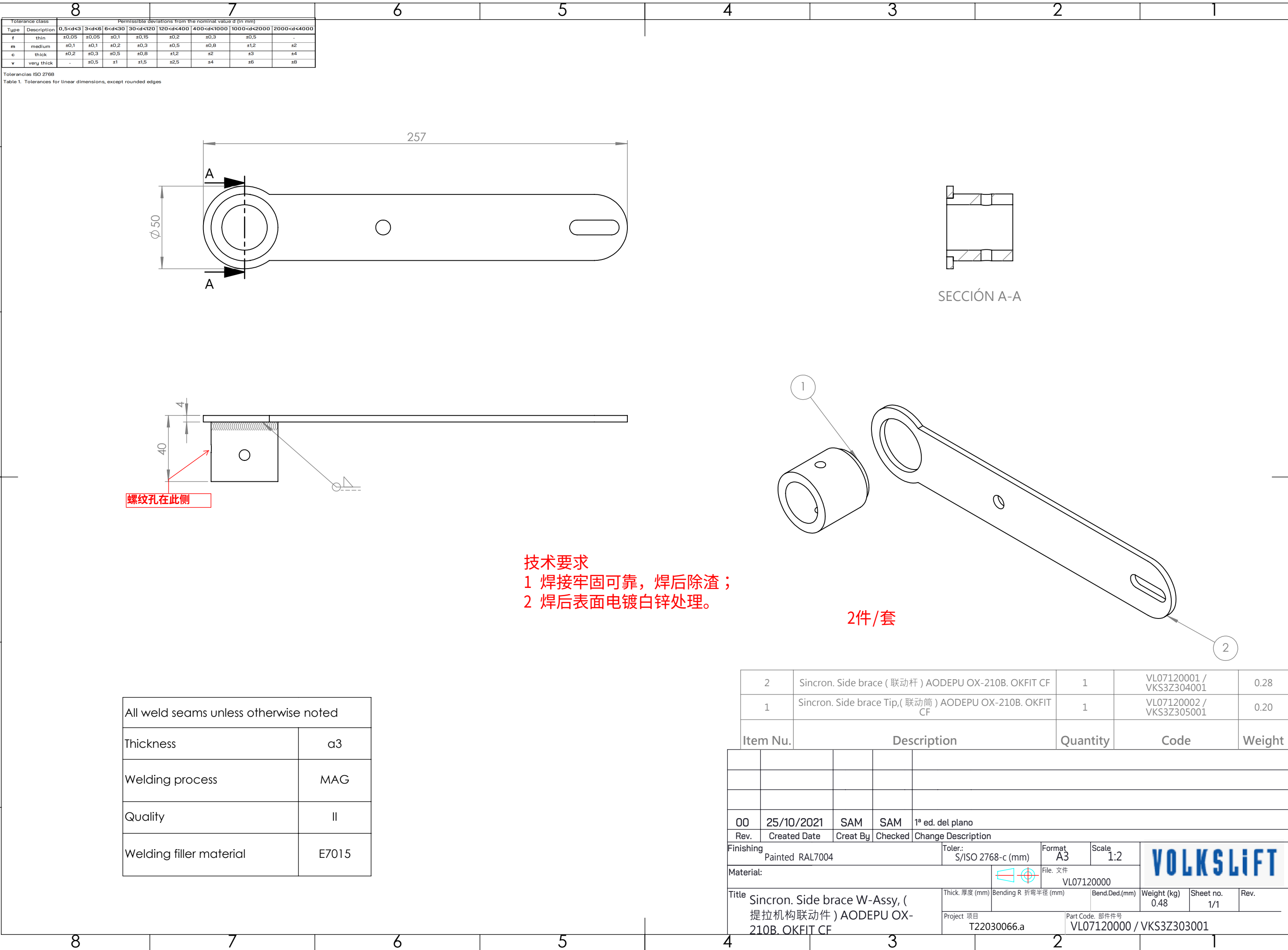
- 1 本开关打杆浇铸成型，旧牌号为ZG35；
- 2 表面不得有裂纹、砂眼、变形等缺陷；
- 3 内孔 $\phi 28.5$ 两侧倒角C0.5；
- 4 表面（电）镀白锌处理，锌层厚度不小于 $8\mu m$ 。

G01	开关打杆
G00	名称

						AODEPU® 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		
						AX210AT102		

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SAM/01.01 Edition: 00



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。

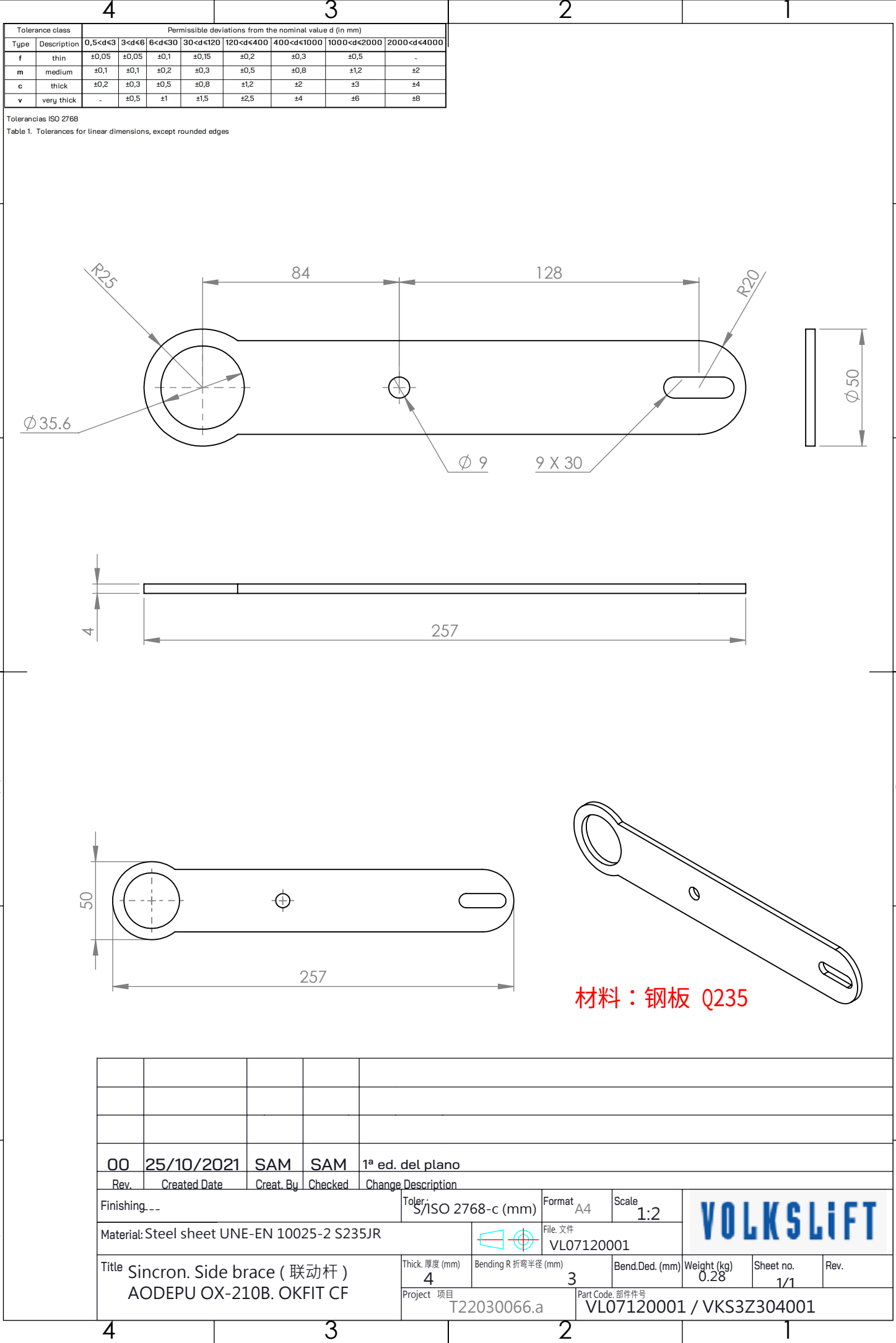
2件/套

All weld seams unless otherwise noted	
Thickness	α3
Welding process	MAG
Quality	II
Welding filler material	E7015

2	Sincron. Side brace (联动杆) AODEPU OX-210B. OKFIT CF				1	VL07120001 / VKS3Z304001		0.28	
1	Sincron. Side brace Tip,(联动筒) AODEPU OX-210B. OKFIT CF				1	VL07120002 / VKS3Z305001		0.20	
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)	Sheet no.	Rev.
				Project 项目 T22030066.a		Part Code. 部件件号 VL07120000 / VKS3Z303001			

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SAM/01/01 - Edition: 00



00	25/10/2021	SAM	SAM	1ª ed. del plano					
Rev.	Created Date	Creat. By	Checked	Change Description					
Finishing...					Toler.	Format	Scale	VOLKSLIFT	
Material: Steel sheet UNE-EN 10025-2 S235JR					S/ISO 2768-c (mm)	A4	1:2		
Title Sincron. Side brace (联动杆) AODEPU OX-210B. OKFIT CF					Thick. 厚度 (mm)	Bending R 折弯半径 (mm)	Bend.Ded. (mm)	Weight (kg)	Rev.
					4	3		0.28	1/1
Project 项目					Part Code. 部件件号				
T22030066.a					VL07120001 / VKS3Z304001				



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	VOLKSLIFT			
Material: Steel UNE-EN-ISO 683-1 C45 (+N)				File. 文件 VL07120002						
Title Sincron. Side brace Tip,(联动筒) AODEPU OX-210B. OKFIT CF				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 T22030066.a					Part Code. 部件件号 VL07120002 / VKS3Z305001					

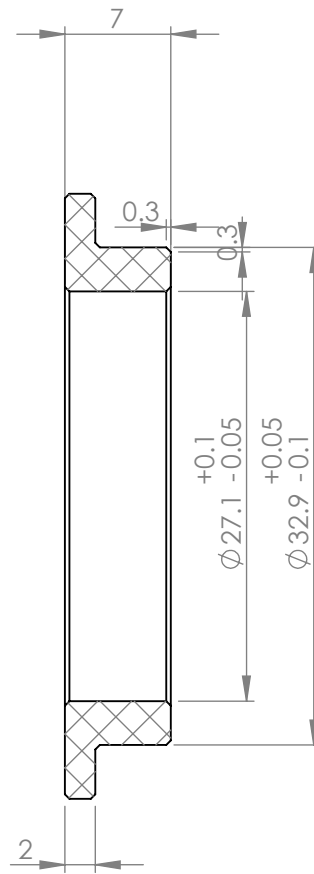
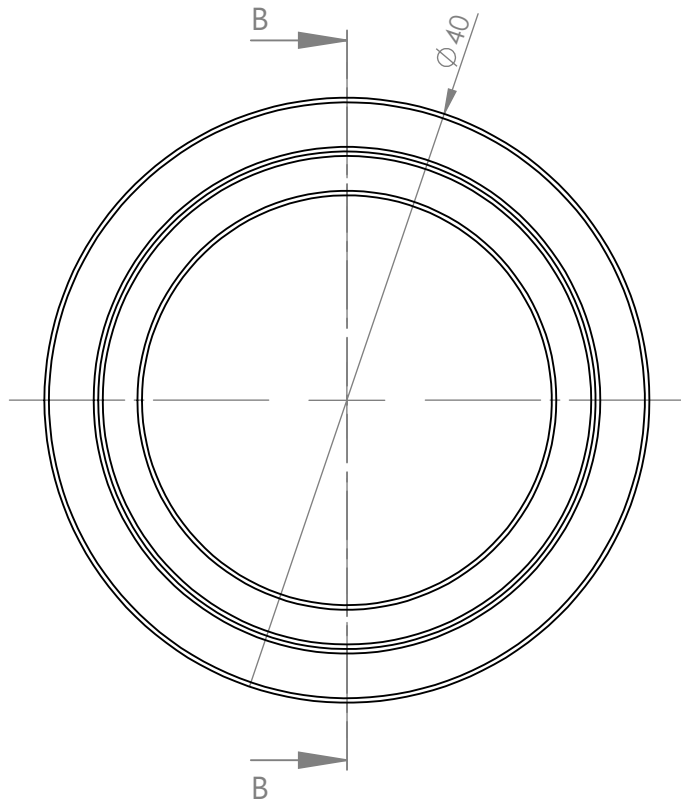
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SAM/01.01 - Edition: 00

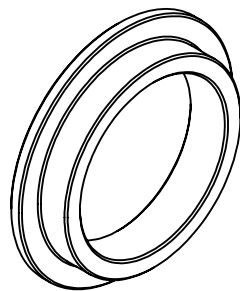
Tolerance class		Permissible deviations from the nominal value d (in mm)							
Type	Description	0,5<d≤3	3<d≤6	6<d≤30	30<d≤120	120<d≤400	400<d≤1000	1000<d≤2000	2000<d≤4000
f	thin	±0,05	±0,05	±0,1	±0,15	±0,2	±0,3	±0,5	-
m	medium	±0,1	±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2
c	thick	±0,2	±0,3	±0,5	±0,8	±1,2	±2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



SECCIÓN B-B



技术要求：
1 表面不得有裂纹，缺口；
2 未注倒角C0.3

2件/套

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