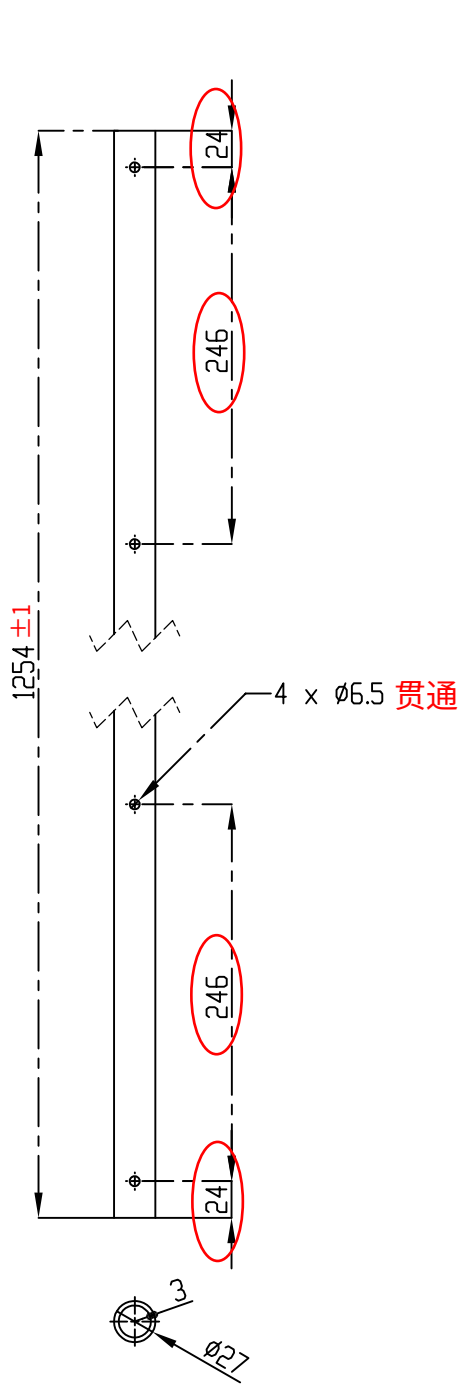


Tolerance class		Permissible deviations from the nominal value d (in mm)							
Type	Description	0,5<d≤3	3<d≤6	6<d≤10	10<d≤12	12<d≤40	40<d≤100	100<d≤200	200<d≤400
f	thin	±0,05	±0,05	±0,1	±0,15	±0,2	±0,3	±0,5	-
m	medium	±0,1	±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2
c	thick	±0,2	±0,3	±0,5	±0,8	±1,2	±2	±3	±4
v	very thick	-	±0,5	±1	±1,5	±2,5	±4	±6	±8

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

Tube Ø27x2



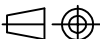
技术要求：
1 去锐角毛刺；
2 表面白锌。

1件/套

材料：钢管27x3 Q235

扭簧见零件图

备注：此提拉杆同时配一套弹簧，左右件各一件，件号如下：
PVKS3Z198001/V20E000105，
PVKS3Z198002/V20E000105。

00	25/10/2021	SAM	SAM	1º ed. del plano
Rev.	Created Date	Creat. By	Checked	Change Description
Finishing ---				Toler. S/150 2768-c (mm)
Material: Perfil acero UNE-EN 10025-2 S235JR				Format A4
				Scale 1:5
				VOLKSLIFT
Title sincron bar (提拉杆) AODEPU OX-210B. OKFIT CF				File.文件 VL07100002
Thick.厚度 (mm) 2				Bending 折弯半径 (mm)
Bend.Ded. (mm)				Weight (kg) 2.22
Sheet no. 1/1				Rev.
Project项目 T22030066.a				Part Code零件号 VL07100002 / VKS3Z301C01

A3



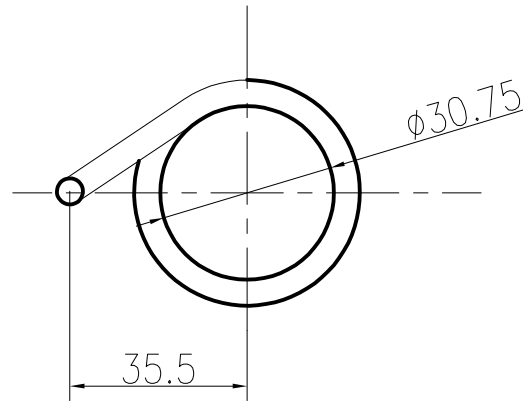
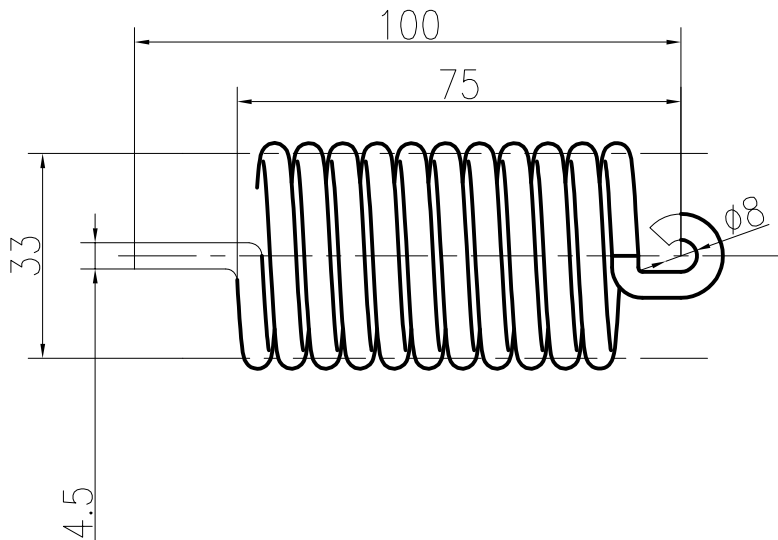
LENGTH/ DIAMETER	0.5-6	>6-30	>30-120	>120-400	>400-1000	>1000-2000	>2000-4000
TOLERANCE	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2

RADIUS/ CHAMFER	0.5-3	>3-6	>6
TOLERANCE	± 0.2	± 0.5	± 1

ANGLE (shorter side length)	0-10	>10-50	>50-120	>120-400	>400
TOLERANCE	± 1°	± 0.5°	± 0.3°	± 0.15°	± 0.1°

Z = LEG LENGTH
ANSI/ASME A2.4-98
WELDING SYMBOLS ARE
USED ON THIS DRAWING.
REFER TO DRAWING
MANUAL FOR CONVERSION
TO ISO SYMBOLS.

WELDS	
OTHER SIDE	ARROW SIDE



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		
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	绘图 DRAWN 张波	材料: 72B-φ4.5 MATERIAL:	首次下发版本 FIRST VERSION	重量 WEIGHT	比例 PROPORTION
						校对 CHK 闵传宏		9401		1:1
						批准 APPD 徐勇				
						日期 DATE 2019.04.23		SHEETS 2	1	SHEET

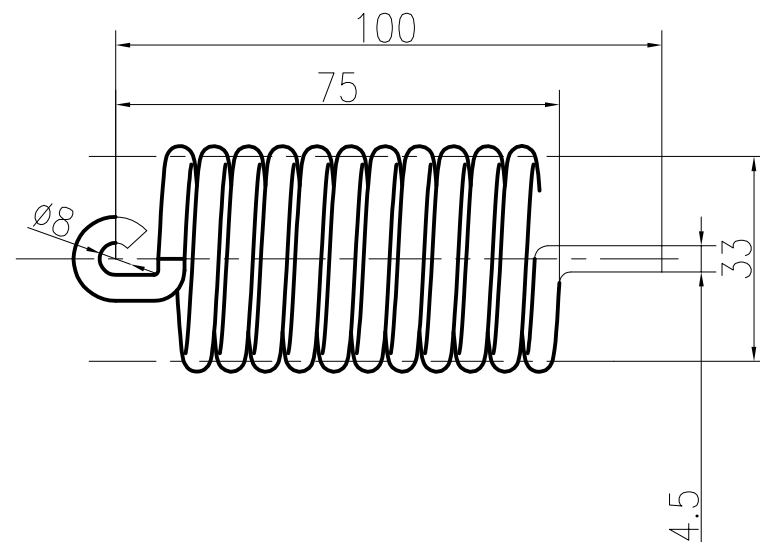
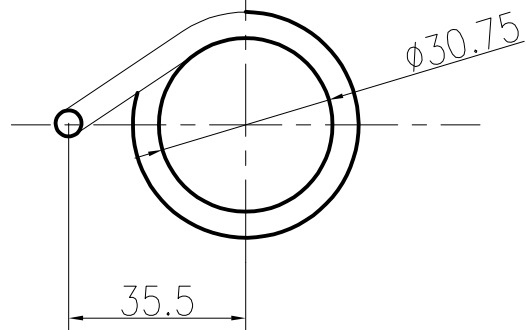
LENGTH/ DIAMETER	0.5-6	>6-30	>30-120	>120-400	>400-1000	>1000-2000	>2000-4000
TOLERANCE	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2

RADIUS/ CHAMFER	0.5-3	>3-6	>6
TOLERANCE	± 0.2	± 0.5	± 1

ANGLE (shorter side length)	0-10	>10-50	>50-120	>120-400	>400
TOLERANCE	$\pm 1^\circ$	$\pm 0.5^\circ$	$\pm 0.3^\circ$	$\pm 0.15^\circ$	$\pm 0.1^\circ$

Z = LEG LENGTH
ANSI/AWS A2.4-98
WELDING SYMBOLS ARE
USED ON THIS DRAWING.
REFER TO DRAWING
AAA26ADJ FOR CONVERSION
TO ISO SYMBOLS.

WELDS	
OTHER SIDE	ARROW SIDE



线径 d	中径 d	总圈数	有效圈数
4.5	33	11	11

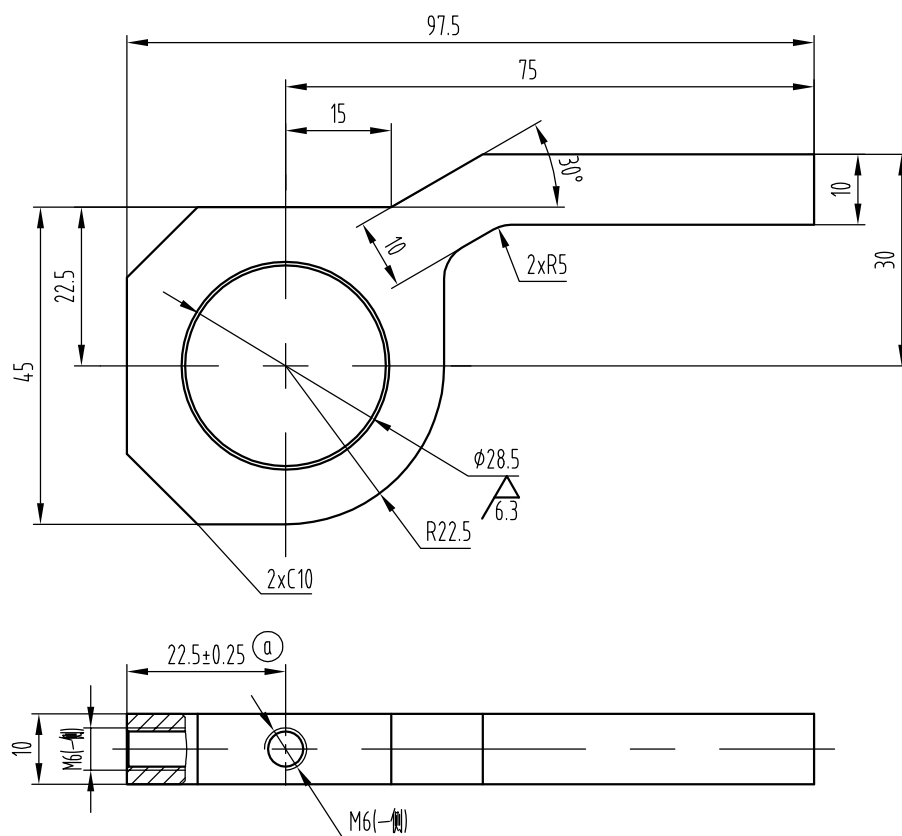
用0X-210A扭簧代替
镀白锌
1件/套

技术要求:

- 1、表面电镀白锌
- 2、该件为右旋

件号: PVKS3Z198002/V20E000105

						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:	9401		1:1	
								SHEETS 2		2	SHEET	



1件/套

技术要求

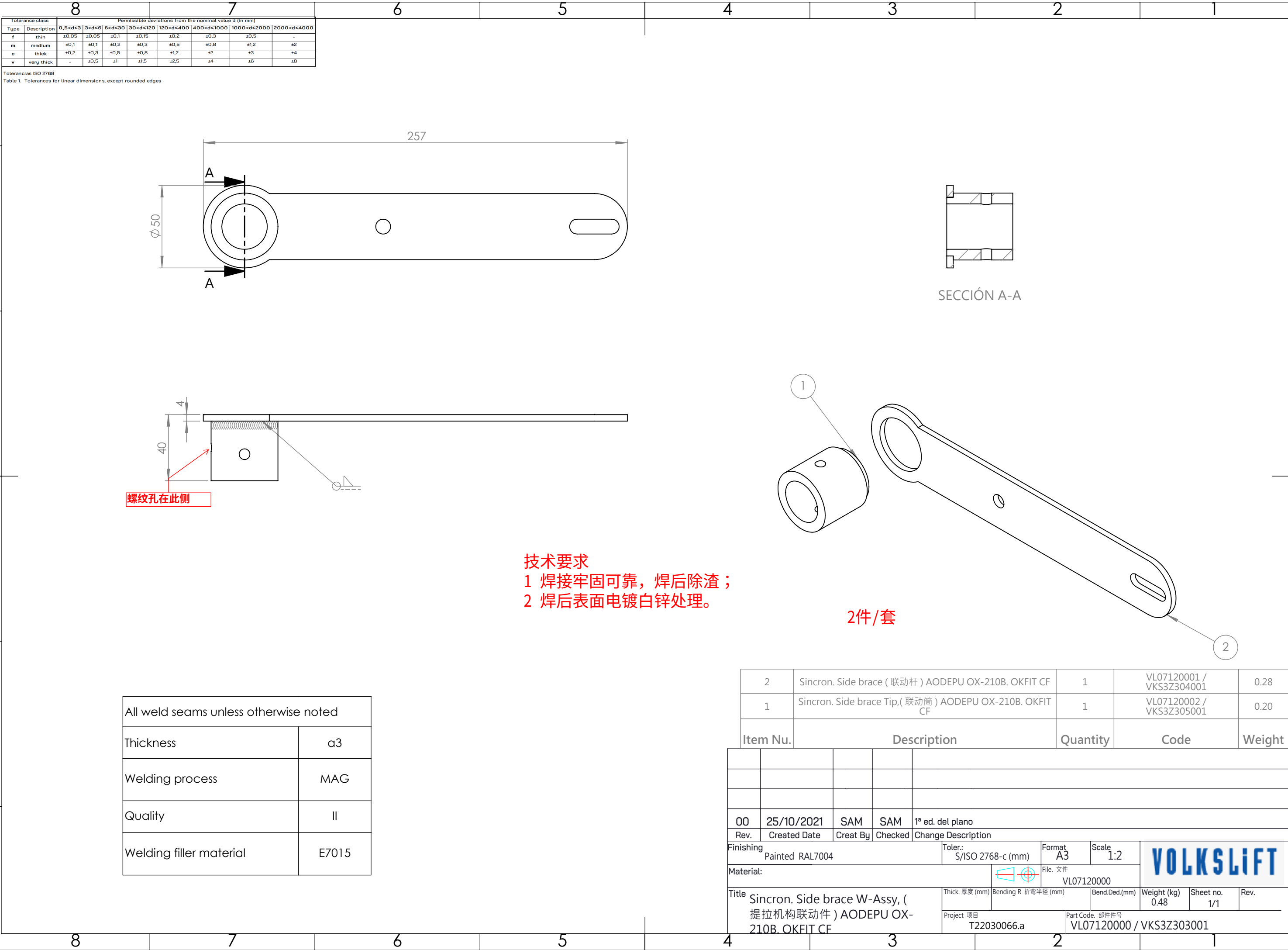
- 1 本开关打杆浇铸成型, 旧牌号为ZG35;
- 2 表面不得有裂纹、砂眼、变形等缺陷;
- 3 内孔 $\phi 28.5$ 两侧倒角C0.5;
- 4 表面(电)镀白锌处理, 镀层厚度不小于8 μm 。

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			开关打杆
标记	处数	分区	更改文件号	签名	年、月、日				
设计			标准化			阶 段 标 记	重 量	比 例	
								1:1	AX210AT102
审核									
工 艺			批 准			共 2 张 第 1 页			

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SAM/01.01 Edition: 00



8				7					
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

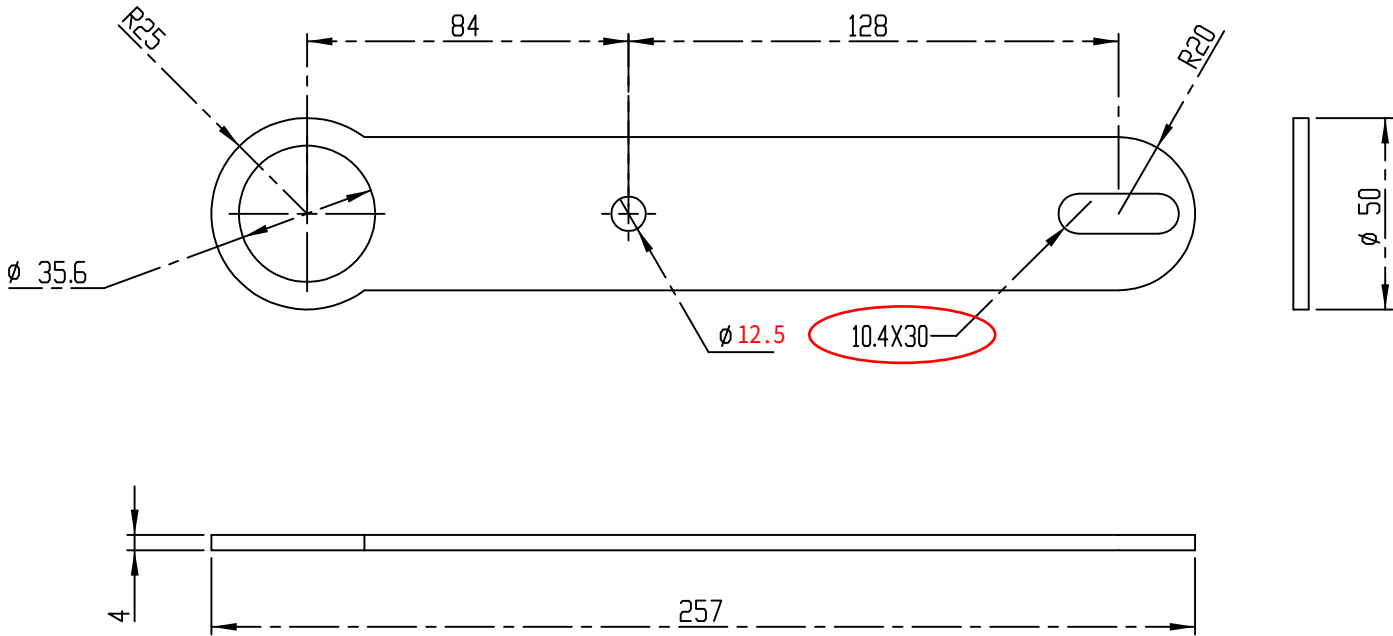
Tolerancias ISO 2768
Table 1. Tolerances for linear dimensions, except rounded edges

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) 0.48	Sheet no. 1/1	Rev.
				Project 项目 T22030066.a		Part Code. 部件件号 VL07120000 / VKS3Z303001			

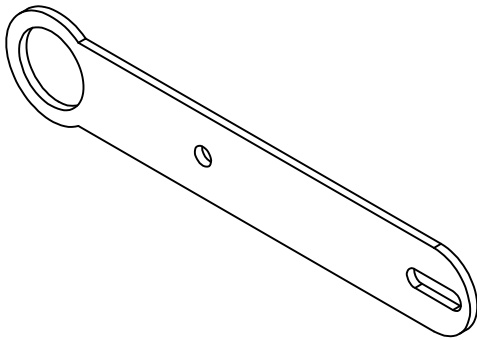
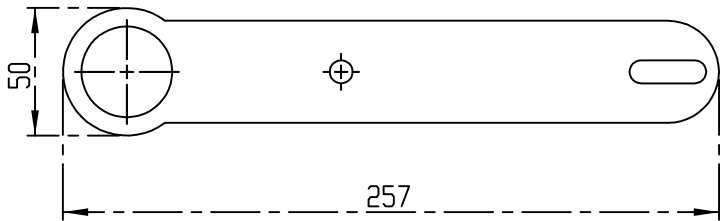
Tolerance class		Permissible deviations from the nominal value d (in mm)							
Type	Description	0,5<ds3	3<ds6	6<ds10	10<ds120	120<ds400	400<ds1000	1000<ds2000	2000<ds4000
f	thin	±0,05	±0,05	±0,1	±0,15	±0,2	±0,3	±0,5	-
m	medium	±0,1	±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2
c	thick	±0,2	±0,3	±0,5	±0,8	±1,2	±2	±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



非标要求：此物料每台共2件，左右各一件，其中一件上增加提拉头一个，见非标图纸VKS3A029

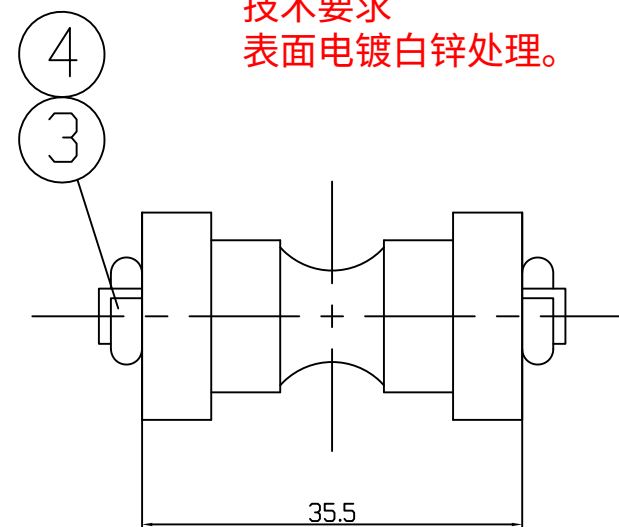
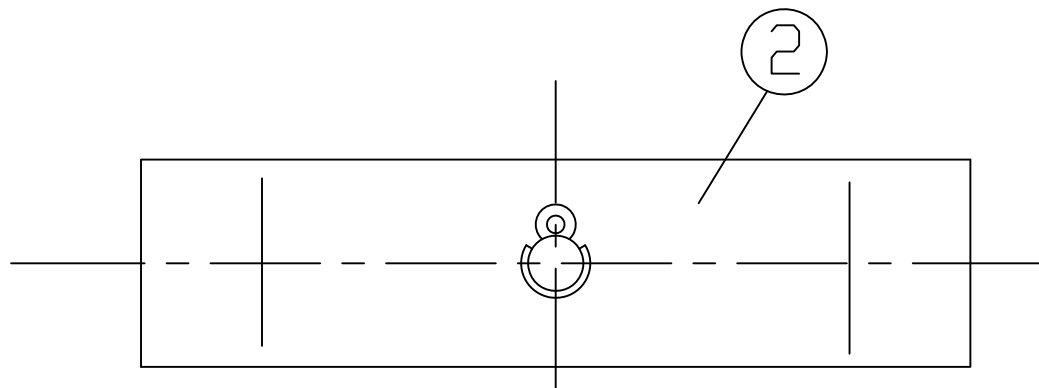
提拉头见零件图



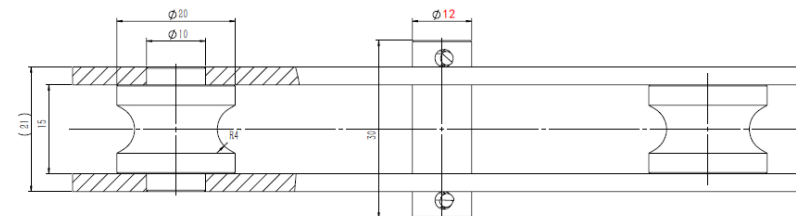
材料：钢板 Q235

00	25/10/2021	SAM	SAM	1º ed. del plano
Rev.	Created Date	Creat. By	Checked	Change Description
Finishing ---				Toler. 1/150 2768-c (mm)
Material: Steel sheet UNE-EN 10025-2 S235JR				Format A4
				Scale 1:2
				VOLKSLIFT
Title Sincron. Side brace (联动杆) AODEPU OX-210B. OKFIT CF				
Thick.厚度 (mm) 4				Bending 折弯半径 (mm) 3
Project项目 T22030066.a				File.文件 VL07120001
				Bend.Ded. (mm)
				Weight (kg) 0.28
				Sheet no. 1/1
				Rev.
				Part Code零件号 VL07120001 / VKS3Z304001

技术要求
表面电镀白锌处理。



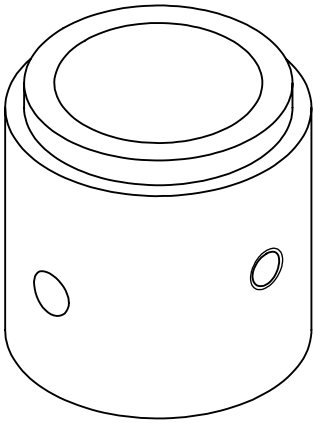
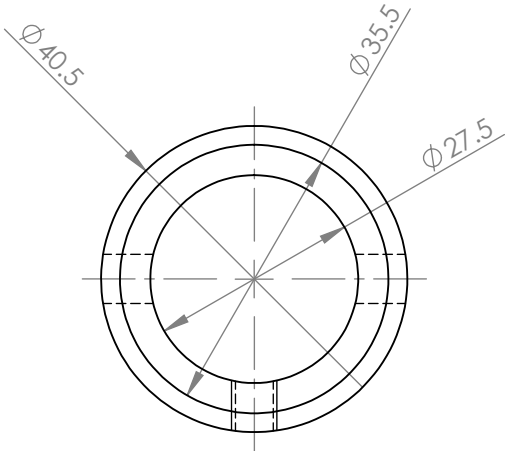
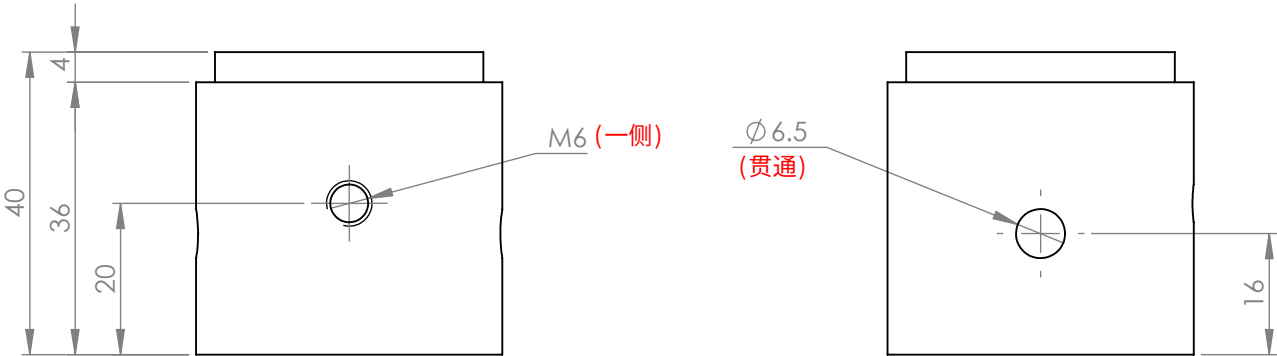
Technical drawing of a three-hole plate. The plate has a total width of 125 and a central hole diameter of 90. The central hole is surrounded by a raised flange. The drawing includes labels 1, 2, 3, and 4 pointing to specific features: 1 points to the top edge, 2 points to the left hole, 3 points to the central hole, and 4 points to the flange of the central hole.



④						VOLKSLIFT	提拉头	VKS3A029			
③								图样标记	数量	重量	比例
②								S	1		1:1
①								共 1 张		第 1 张	
记号处数	更改原因及说明		更改日期	更改者	审查者	SB 编号	材料	沃克斯电梯(中国)有限公司			

4				3					
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	±0,03	±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

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)				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	

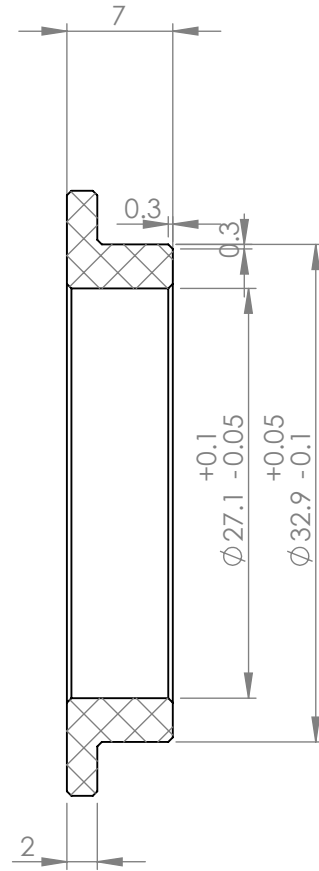
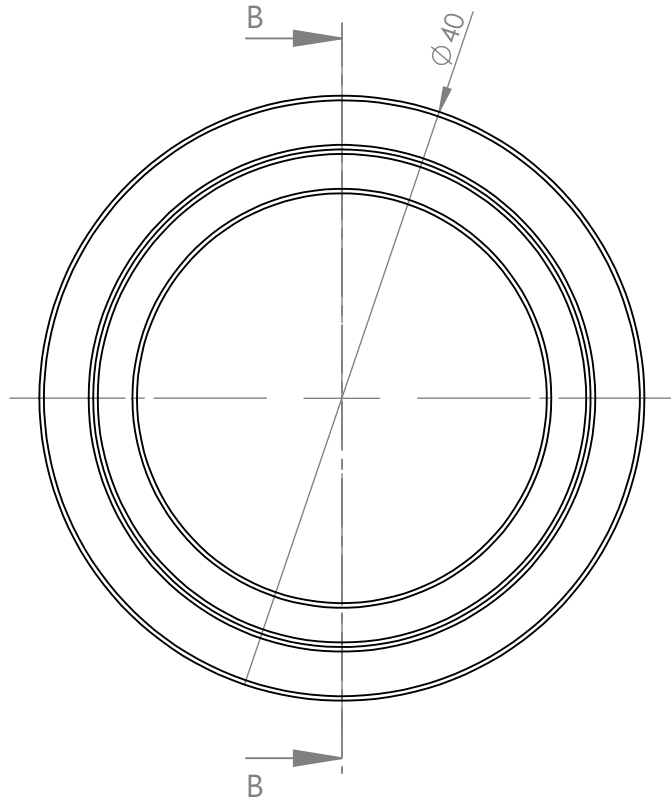
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SAM/01.01 - Edition: 00

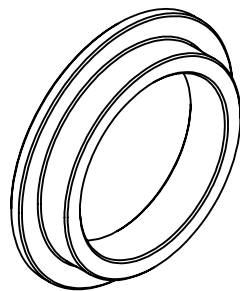
Tolerance class		Permissible deviations from the nominal value d (in mm)							
Type	Description	0,5<d≤3	3<d≤6	6<d≤30	30<d≤120	120<d≤400	400<d≤1000	1000<d≤2000	2000<d≤4000
f	thin	±0,05	±0,05	±0,1	±0,15	±0,2	±0,3	±0,5	-
m	medium	±0,1	±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2
c	thick	±0,2	±0,3	±0,5	±0,8	±1,2	±2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