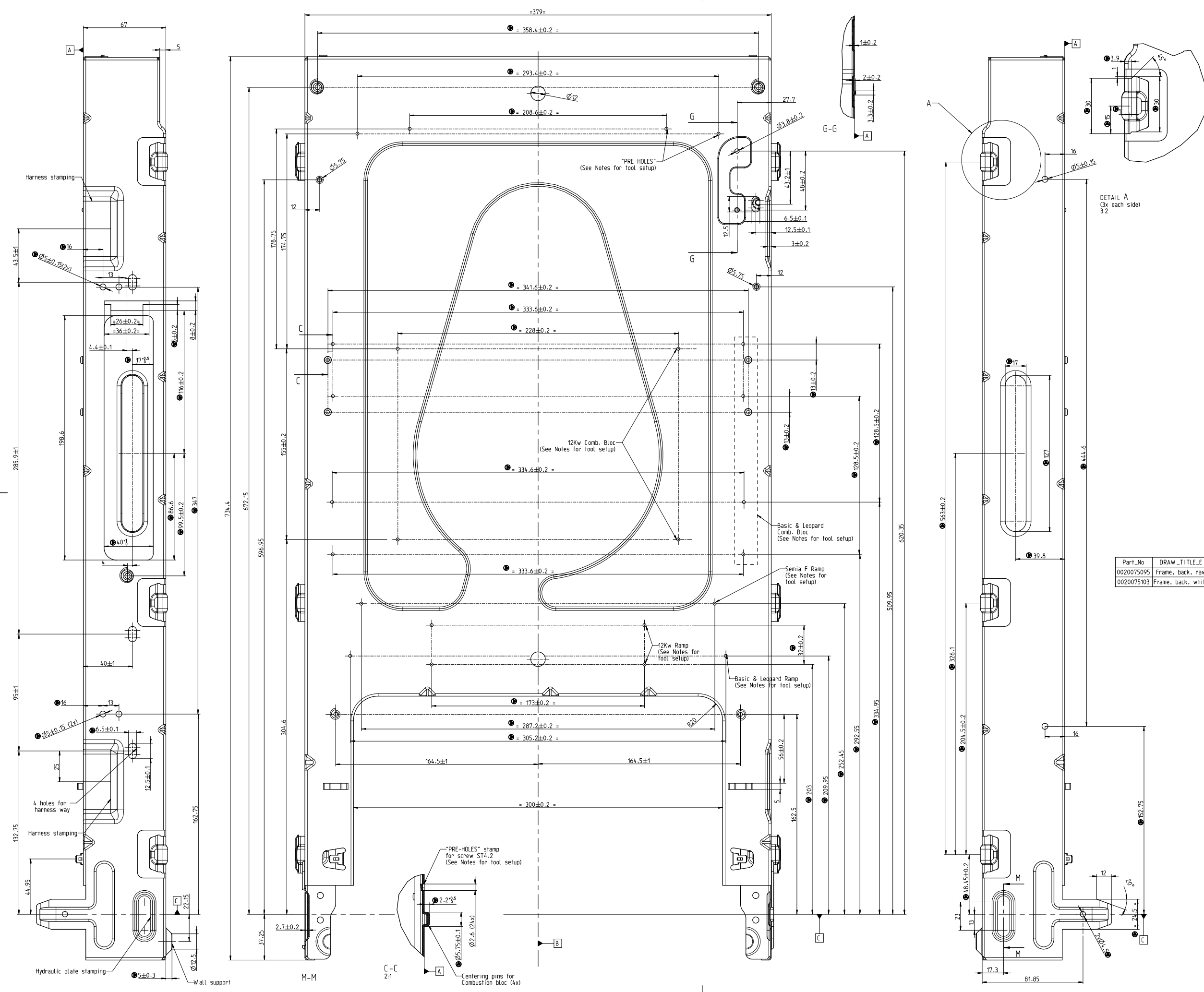


No	Date	Description of modification	Date	Modified by	Checked by	Approved by	Rev.
1	22	Drawing update following supplier remark & modification of "pre-holes" note	23	Eguli	Tsilo	Rbot	3.0
2	22	change of material to DC03	-	-	-	-	-
3	24	added family table with painted part	24.10.2009	Tsilo	Eguli	Rbot	4.0



BON POUR EXECUTION
/ Production Release

Part_No	DRAW_TITLE_E	DRAW_TITLE_L	SURF_TREATMENT	SURFACE_DM.2
0020075095	Frame, back, raw	Ram, zadny, netak.	-	70.5
0020075103	Frame, back, white	Ram, zadny, biely painted in white	NCS 005 R80 B	70.5

NOTA:
-PRE-TROU POUR VIS ST4.2
(POUR LA MISE AU POINT ET LA VALIDATION DE L'OUTILLAGE CES PRE-TROUS SERONT DES PRESTOLES)
-EMPREINTE DE VIS ST4.2
COUPLE D'AMORCAGE DE VISSAGE-2Nm
LES VIS DEVRONT RESISTER A 10 VISSAGES/DEVISSAGES SUCCESSIFS AVEC UN COUPLE DE BLOCAGE A 2.2Nm.
LES PRESTOLES SONT DEFINIES SELON LA ST N°1538.

NOTES:
-PRE-HOLES" stamp for screw ST4.2
(for the tool setup and validation, these "pre-holes" will be "prestoles" screw stamp)
-Screw stamp ST4.2
Beginning threaded joint moment < 2 Nm.
Screws must stand up at 10 successive screwings/unscrawings with a freezing moment of 2.2Nm.

NOTES COMPLEMENTAIRES POUR PIECES DE TOLERIE
Additional notes for sheet metal parts
BAVANS / Barbs : CLASSE B NORME NFE 8180
RAYON INTERIEUR DE PLIAGE / Internal bending radius : 1.2 mm
Poids / Weight : 2.104 Kg VOLUME : 279999 mm3

NOTA : ● : Cote fonctionnelle / Functional dimension

This Drawing is only valid with following specification		Specification no.:	
Title:	Frame back	Part product:	P 0.2x...
Material no.:	Material: Tole DC03 EP=0.8	Part treatment:	Remarks/color: see table
Drawing File:	Frame back	No. of cont.:	1017748
Local File:	Ram zadny	Drawing modification:	0020075095
Drawn by:	Eguli	Production:	4.0
Checked by:	Tsilo	Drawn by:	Eguli
Appr. by:	Rbot	Mod. title:	0020075095
For Release document no.:	1017748	Mod. status:	Production
Drawing date:	2009-10-23	Scale:	1:1
Drawn by:	Eguli	Sheet:	1/2

Vaillant Group
 11, Rue de la Petite Baratte
 4475 NANTES CEDEX 3 France
 Téléphone: +33 (0)2 40 00 80 00
 Fax: +33 (0)2 40 00 80 00
 E-mail: info@vaillant.fr
 Member of the Vaillant Group