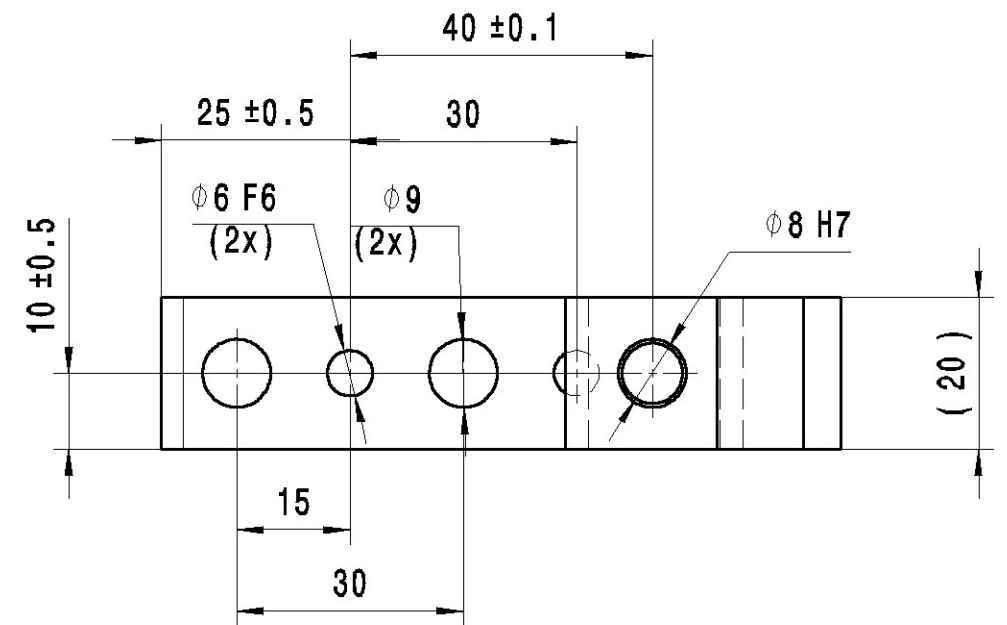
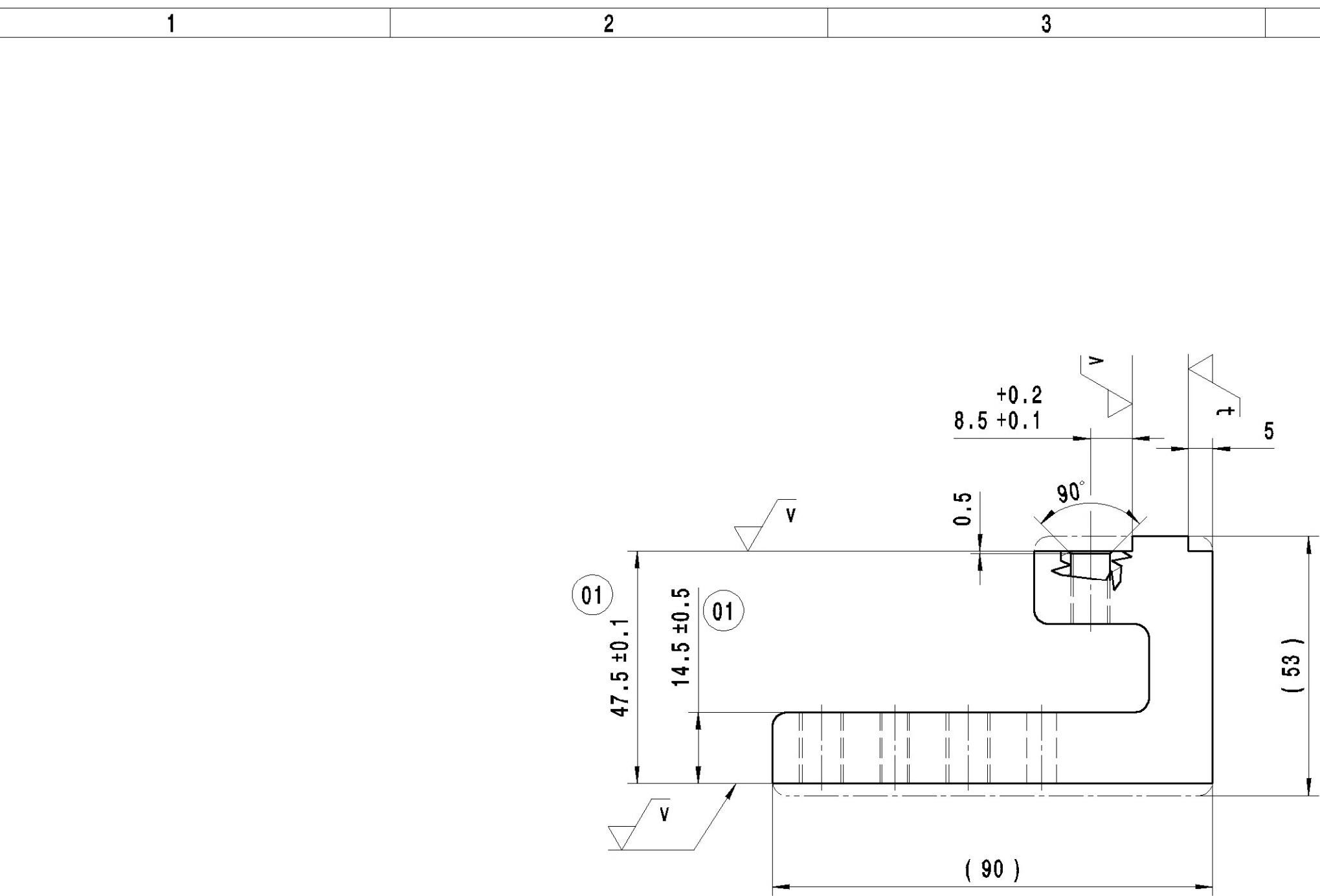




KANTEN GEBROCHEN
Smoothed Edges
MESSKANTEN ENTGRÄTET
Measuring edges deburred

Lackierung der Bauteile/ Component painting	X3	Brünieren / Burnishing
--	----	------------------------

Werkstoff / MATERIAL	L1	L2	L3
EN10029-B1.20A-S235JR	90	53	---

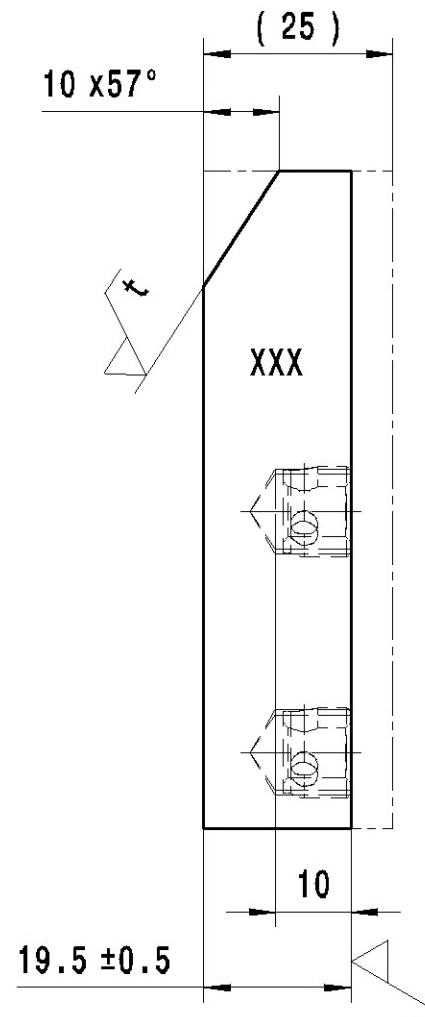
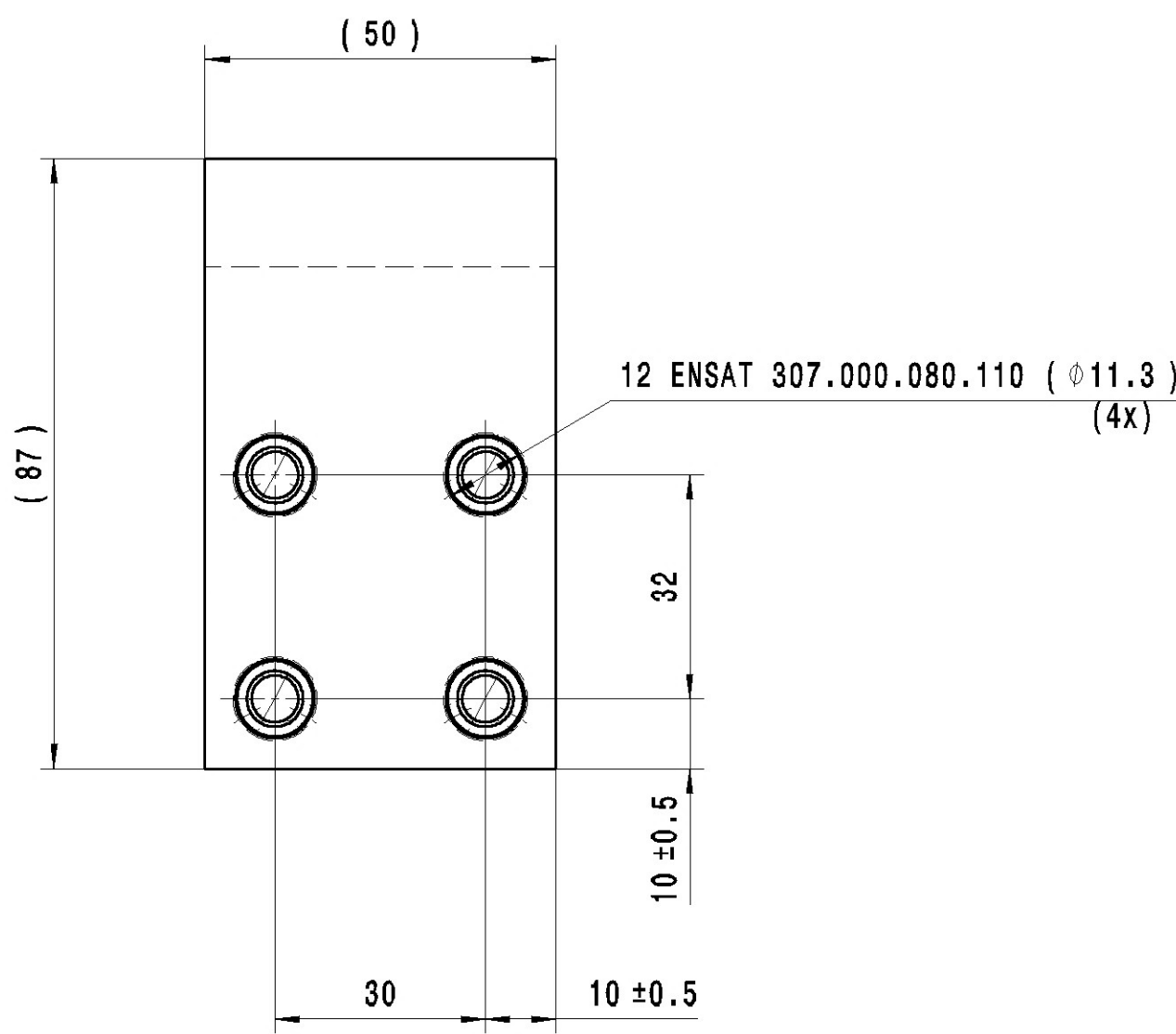
Stichmasztoleranz / Center-to-center dimension tolerance
Für Stiftlöcher / for pin holes $\pm 0,02$ ✓
Für Schraublöcher / to all screw holes $\pm 0,2$ ✓

Winkelmasztoleranz / Angular dimension tolerance $\pm 30^\circ$

Stichmasztoleranz von Flächen zu Stiftlöcher/
Tolerance of pin hole-center to surface distance $\pm 0,05$

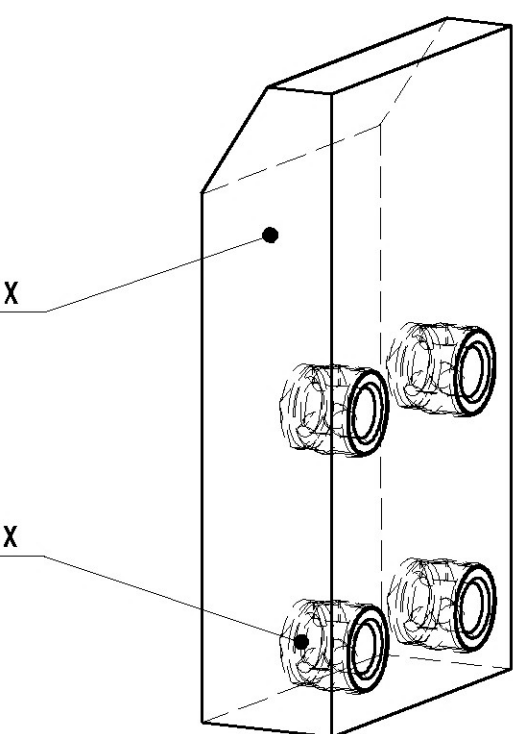
KUKA		ECN-Nr.: 1074157
RELEASE-Rev. 01		
Datum/Date: 05.03.2024		
DesignInformationDesk@kuka.com +49 821 797 5612		
Pos. 0013 geändert; Fräsen geändert		
Nach VW 10705 Acc. to VW 10705	roh ✓ s	Rz100 ✓ t
	Rz40 ✓ u	Rz25 ✓ v
	Rz10 ✓ w	Rz6,3 ✓ x
	Rz2,5 ✓ y	Rz1 ✓ z

Zul.Abweichung fuer Nennmaße ohne Toleranzangabe nach DIN ISO 2768-m (spanende Fertigung). Permissible deviation for nominal dimensions without tolerance specification acc.to DIN ISO 2768-m (machining operation).							
> 0,5 ≤ 6	> 6 ≤ 30	> 30 ≤ 120	> 120 ≤ 400	> 400 ≤ 1000	> 1000 ≤ 2000	> 2000 ≤ 4000	
± 0,1 ± 0,2	± 0,2 ± 0,3	± 0,3 ± 0,5	± 0,5 ± 0,8	± 0,8 ± 1,2	± 1,2 ± 2	± 2	
When tolerances are not stated, all parts must conform to tolerance specification DIN ISO 2768-m. Unless other specifications are stated, DIN ISO 2768-m shall apply to dimensions without tolerance specification.							
Bemerkung/ Note -							
Positionenr. / Item no.				Betriebsmittelnummer/ Operating equipment no.			
0013				PZ-38N 408473			
Haerten Hardening				Einsatzhärte tiefe Case depth			
ZSB-B1. 03 ASSY sheet				Vergueten Quenching and tempering			
Blatt 05 Sheet				Maszstab Scale			
1:1				Werkstoff Material			
S235JR							



P1.25;87x50
S-1000 black antistatic

307.000.080.110
Fa. KERB KONUS



KUKA		ECN-Nr.: -
RELEASE-Rev. -		
Datum/Date: -		
DesignInformationDesk@kuka.com +49 821 797 5612		

Nach VW 10705 Acc. to VW 10705	roh ✓ s	Rz100 ✓ t
	Rz40 ✓ u	Rz25 ✓ v
	Rz10 ✓ w	Rz6,3 ✓ x
	Rz2,5 ✓ y	Rz1 ✓ z

> 0,5 ≤ 6	> 6 ≤ 30	> 30 ≤ 120	> 120 ≤ 400	> 400 ≤ 1000	> 1000 ≤ 2000	> 2000 ≤ 4000	
± 0,1 ± 0,2	± 0,2 ± 0,3	± 0,3 ± 0,5	± 0,5 ± 0,8	± 0,8 ± 1,2	± 1,2 ± 2	± 2	
When tolerances are not stated, all parts must conform to tolerance specification DIN ISO 2768-m. Unless other specifications are stated, DIN ISO 2768-m shall apply to dimensions without tolerance specification.							
Bemerkung/ Note -							
Positionenr. / Item no.				Betriebsmittelnummer/ Operating equipment no.			
0015				PZ-38N 408473			
Haerten Hardening				Einsatzhärte tiefe Case depth			
ZSB-B1. 03 ASSY sheet				Vergueten Quenching and tempering			
Blatt 05 Sheet				Maszstab Scale			
1:1				Werkstoff Material			
S-1000 black antistatic							

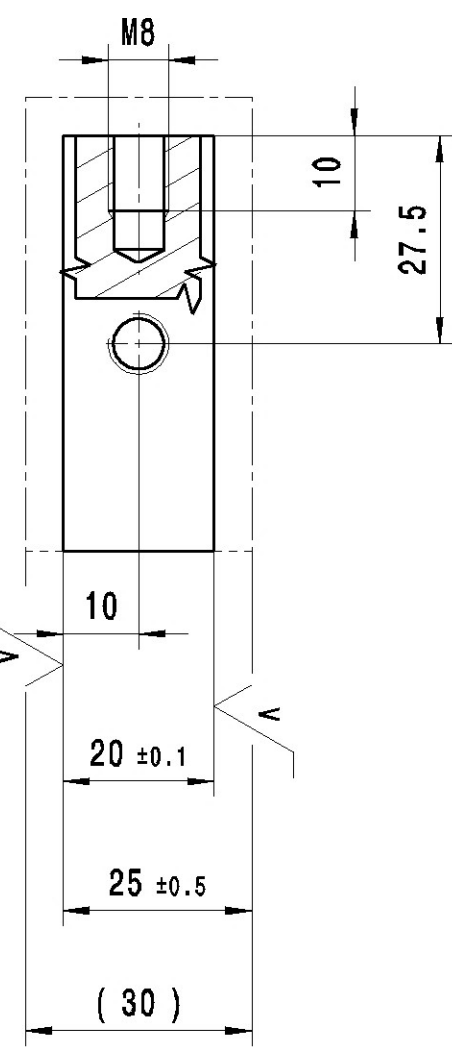
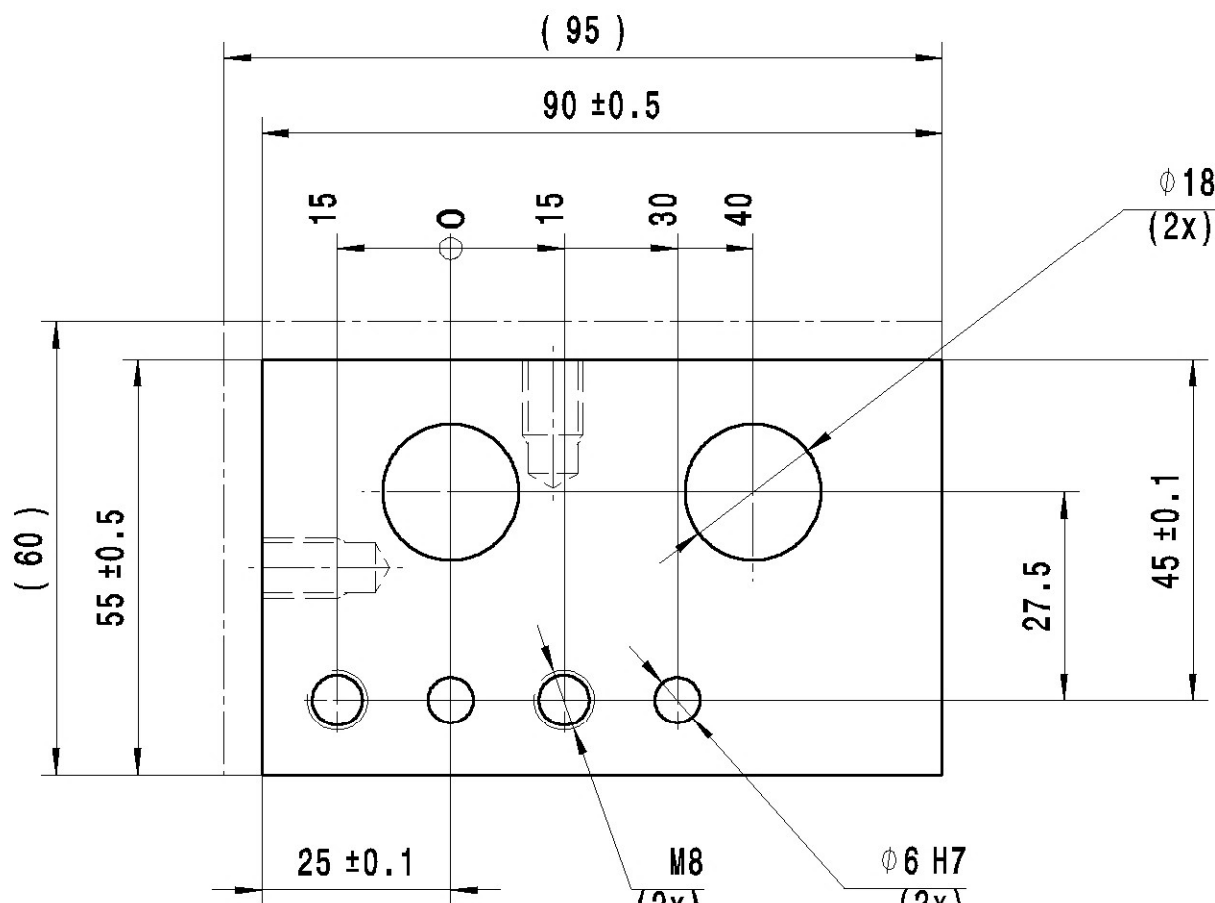
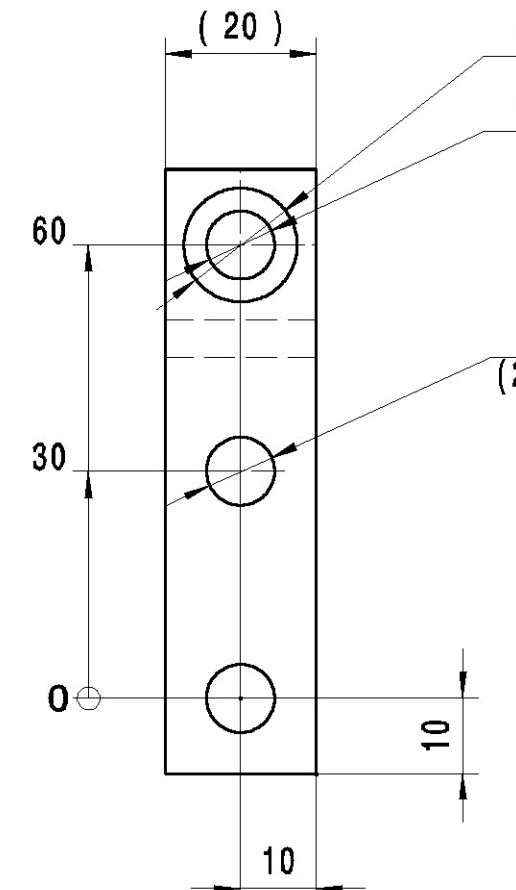
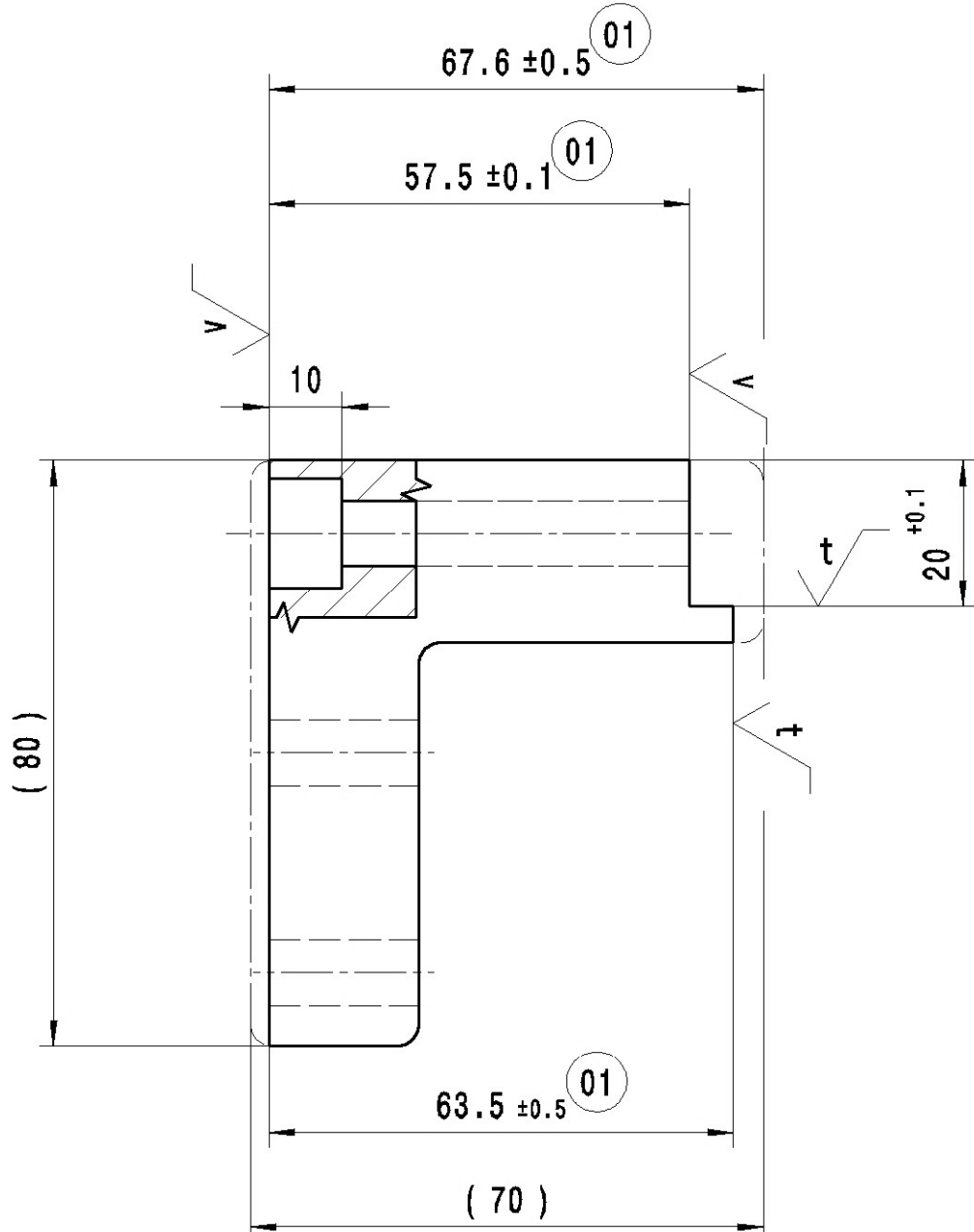
Stichmasztoleranz / Center-to-center dimension tolerance
Für Stiftlöcher / for pin holes $\pm 0,02$ ✓
Für Schraublöcher / to all screw holes $\pm 0,2$ ✓

Winkelmasztoleranz / Angular dimension tolerance $\pm 30^\circ$

Stichmasztoleranz von Flächen zu Stiftlöcher/
Tolerance of pin hole-center to surface distance $\pm 0,05$

KANTEN GEBROCHEN
Smoothed Edges
MESSKANTEN ENTGRÄTET
Measuring edges deburred

Kennzeichnung / DESIGNATION
gravieren bei XXX mit/engraving at XXX with:
PE-UHMW1000



Werkstoff / MATERIAL	L1	L2	L3
EN10058-F1.60x30-S355J2G3	95	---	---

KANTEN GEBROCHEN
Smoothed Edges
MESSKANTEN ENTGRÄTET
Measuring edges deburred

Stichmasztoleranz / Center-to-center dimension tolerance
Für Stiftlöcher / for pin holes $\pm 0,02$ ✓
Für Schraublöcher / to all screw holes $\pm 0,2$ ✓

Winkelmasztoleranz / Angular dimension tolerance $\pm 30^\circ$

Stichmasztoleranz von Flächen zu Stiftlöcher/
Tolerance of pin hole-center to surface distance $\pm 0,05$

KUKA		ECN-Nr.: -
RELEASE-Rev. -		
Datum/Date: -		
DesignInformationDesk@kuka.com +49 821 797 5612		
Nach VW 10705 Acc. to VW 10705	roh ✓ s	Rz100 ✓ t
	Rz40 ✓ u	Rz25 ✓ v
	Rz10 ✓ w	Rz6,3 ✓ x
	Rz2,5 ✓ y	Rz1 ✓ z

> 0,5 ≤ 6	> 6 ≤ 30	> 30 ≤ 120	> 120 ≤ 400	> 400 ≤ 1000	> 1000 ≤ 2000	> 2000 ≤ 4000	
± 0,1 ± 0,2	± 0,2 ± 0,3	± 0,3 ± 0,5	± 0,5 ± 0,8	± 0,8 ± 1,2	± 1,2 ± 2	± 2	
When tolerances are not stated, all parts must conform to tolerance specification DIN ISO 2768-m. Unless other specifications are stated, DIN ISO 2768-m shall apply to dimensions without tolerance specification.							
Bemerkung/ Note -							
Positionenr. / Item no.				Betriebsmittelnummer/ Operating equipment no.			
0009				PZ-38N 408473			
Haerten Hardening				Einsatzhärte tiefe Case depth			
ZSB-B1. 03 ASSY sheet				Vergueten Quenching and tempering			
Blatt 05 Sheet				Maszstab Scale			
1:1				Werkstoff Material			
S355J2G3							

Lackierung der Bauteile/ Component painting	X3	Brünieren / Burnishing
--	----	------------------------

Stichmasztoleranz / Center-to-center dimension tolerance
Für Stiftlöcher / for pin holes $\pm 0,02$ ✓
Für Schraublöcher / to all screw holes $\pm 0,2$ ✓

Winkelmasztoleranz / Angular dimension tolerance $\pm 30^\circ$

Stichmasztoleranz von Flächen zu Stiftlöcher/
Tolerance of pin hole-center to surface distance $\pm 0,05$

BRENNSCHABLONE
BURNING TEMPLATE
B1./ SHEET: 06

KANTEN GEBROCHEN
Smoothed Edges
MESSKANTEN ENTGRÄTET
Measuring edges deburred

Werkstoff / MATERIAL	L1	L2	L3
EN10029-B1.20A-S235JR	80	70	---

Nach VW 10705 Acc. to VW 10705	roh ✓ s	Rz100 ✓ t
	Rz40 ✓ u	Rz25 ✓ v
	Rz10 ✓ w	Rz6,3 ✓ x
	Rz2,5 ✓ y	Rz1 ✓ z

> 0,5 ≤ 6	> 6 ≤ 30	> 30 ≤ 120	> 120 ≤ 400	> 400 ≤ 1000	> 1000 ≤ 2000	> 2000 ≤ 4000	
± 0,1 ± 0,2	± 0,2 ± 0,3	± 0,3 ± 0,5	± 0,5 ± 0,8	± 0,8 ± 1,2	± 1,2 ± 2	± 2	
When tolerances are not stated, all parts must conform to tolerance specification DIN ISO 2768-m. Unless other specifications are stated, DIN ISO 2768-m shall apply to dimensions without tolerance specification.							
Bemerkung/ Note -							
Positionenr. / Item no.				Betriebsmittelnummer/ Operating equipment no.			
0011				PZ-38N 408473			
Haerten Hardening				Einsatzhärte tiefe Case depth			
ZSB-B1. 03 ASSY sheet				Vergueten Quenching and tempering			
Blatt 05 Sheet				Maszstab Scale			
1:1				Werkstoff Material			
S235JR							

KUKA		ECN-Nr.: 1074157
RELEASE-Rev. 01		
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DesignInformationDesk@kuka.com +49 821 797 5612		

Pos. 0011 geändert; Fräsen geändert

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AP-System und Verwaltungssysteme/Vehicle and administration system

CATIA V5

Sicherh.-Dok.
Safety doc. -

Fahrzeugnummer/ Vehicle part number
024.915.591

K1

Auftraggebende Abteilung/ Ordering department
Porsche AG / PPK

Dokum.-Verantwortl.
Doc resp. -

Jürgen Wildenberger

Firma/ Company
KUKA Systems

PPK2

Telefon/ Phone
+49 170 911 6698

Dazugehörige Betriebsmittel
Associated resources
PZ-150 460311

Maschine/ Machine
Inventar-Nr./ Stock number
-

Benennung/ Title
ZENTRIERUNG

Format/ D. size
A0

Blatt/ Sheet
05

von/ of
06

Datum/ Date
15.05.2023

Kennzeichnung nach ISO 2308/ Marking acc. to ISO 2308

Toleranzangabe: Unabhängigkeitsprinzip nach VW 01054

Tolerancing: independency principle acc. to VW 01054