

EO Number EO-1015106	
Drawn/Changed CHB	Date (DD/MM/YY) 29/08/14
Approved LRH	Date (DD/MM/YY) 02/09/14

EDGE PREPERATION REQUIREMENTS FOR FABRICATED METAL PARTS

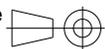
BACKGROUND:

CORROSION CONTROL IS PRIMARILY A FUNCTION OF HOW WELL AIR AND MOISTURE ARE KEPT AWAY FROM A SURFACE. MANY SYSTEMS ARE AVAILABLE TO MEET THIS GOAL. HOWEVER, NONE WILL ADHERE WELL TO, OR BUILD FILM THICKNESS ON SHARP CORNERS. ALSO, METAL OXIDE RESIDUES FROM CUTTING PROCESSES DO NOT ADHERE WELL TO THE PARENT MATERIAL. WHEN THESE RESIDUES FLAKE OR PEEL OFF THE EDGE, THE COATING IS ALSO REMOVED, WHICH ALLOWS AIR AND MOISTURE TO THE SUBSTRATE.

EDGE PREPERATION OF FABRICATED PARTS

1. THE FABRICATOR IS RESPONSIBLE FOR ADHERENCE TO THIS STANDARD.
2. ALL EDGES ARE TO BE MECHANICALLY DEBURRED.
3. ALL METAL OXIDE RESIDUES FROM CUTTING PROCESSES ARE TO BE MECHANICALLY REMOVED. CHEMICAL PROCESSES ARE NOT ACCEPTABLE AS THEY HAVE BEEN SHOWN TO BE UNRELIABLE.
4. ALL CORNERS AND EDGES ARE TO BE BE GROUND TO A 0.015 INCH [0.38mm] MINIMUM RADIUS. IN THE CASE OF WELDMENTS, ONLY EXPOSED CORNERS NEED TO BE GROUND. IT IS UP TO THE FABRICATOR TO DETERMINE A STRATEGY THAT YIELDS THE REQUIRED RESULT.

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Approved by LRH	Date (DD/MM/YY) 02/09/14	 HJAB · KALMAR · MACGREGOR	Name
Drawn by CPB	Date (DD/MM/YY) 29/08/14		Third angle projection 

EDGE PREPERATION REQUIREMENTS FOR FABRICATED METAL PARTS

Mass (Unit) 0.0 lb	Sheet (# / #) 1 / 1	Revision A
Drawing Number ESN0060		

All metal parts shall have burrs removed from all interior and exterior edges. All metal oxide residues from a cutting process shall be removed from all cut surfaces. All edges shall be ground to a minimum 0.015 [0.4] radius.