

WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
- LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
- ANY CONTINUOUS WELDS GREATER THAN 6" SHOULD REFER TO WELDING NOTE OR DESIGN SOURCE.
- PRODUCTION RACKS MUST BE COMPLETELY FREE OF WELD SPLATTER, SHARP EDGES, BURRED EDGES, RUSTED OR RUSTING AREAS ON RACK, PRIOR TO FINAL DELIVERY.

PAINT

- PAINT COLOR: -SEE TABLE-
- FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
- ALL STAINLESS/GALVANIZED STEEL SHOULD BE MASKED PRIOR TO PAINT.
- DUNNAGE OR AREAS CONTACTING COMMODITY CONTAINER IS CARRYING SHOULD BE PAINT FREE.
- PAINT QUALITY IS TO MINIMIZE DRIP OR RUNS.
- COAT THICKNESS SHOULD BE SO THERE IS NO "BLEED THROUGH" OF FABRICATION.

FASTENERS/SPRING PINS

- VENDOR TO USE GRADE "B" HEX HEAD CAP SCREW AND GRADE "C" PREVAILING TORQUE HEX NUT.
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- ALL SCREWS, NUTS, WASHERS, ETC ARE TO BE ZINC PLATED.
- FASTENERS SHOULD BE FREE OF PAINT.
- GREASE ALL ZERK FITTINGS AFTER ASSEMBLY AND BEFORE SHIPPING.
- GAS SPRINGS ARE TO BE "ROD DOWN" UNLESS OTHERWISE SPECIFIED.

INSPECTION

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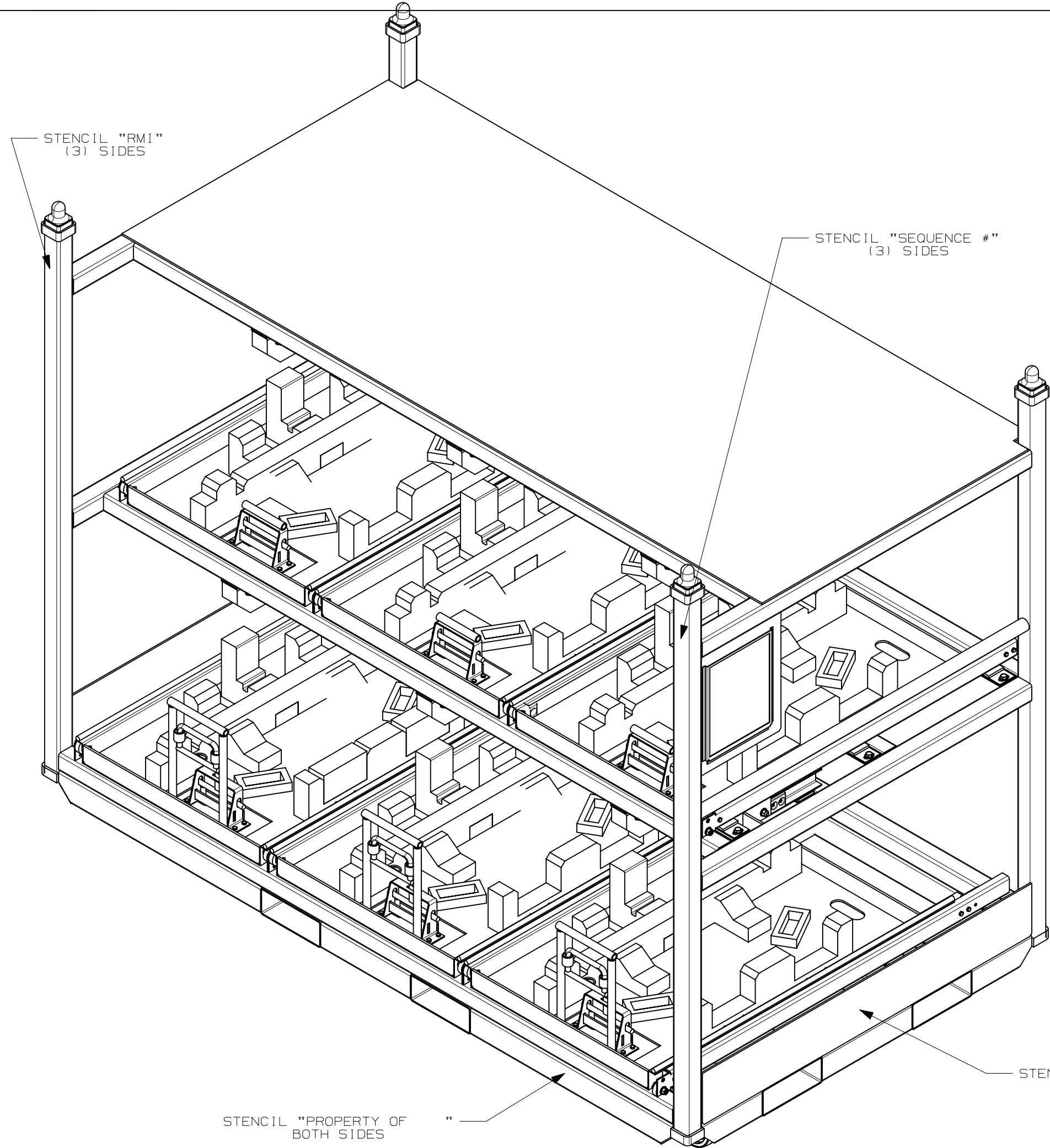
TOLERANCES

STANDARD TOL. ± DECIMALS ANGLES

- .0 ± 0.12 X ± 1.0
- .00 ± 0.06 X.X ± 0.5
- .000 ± 0.03 X.XX ± 0.1

CONFIDENTIAL: THIS DRAWING IS PROPERTY OF

DRAWN	DS	12/04/17	ADJUSTABLE CANTILEVER RACK			
CHECKED						
QA						
MFG						
APPROVED						
			SIZE	DWG NO		REV
			B	XX-XXX		
			SCALE			
						SHEET 1 OF 11



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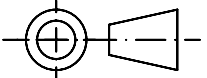
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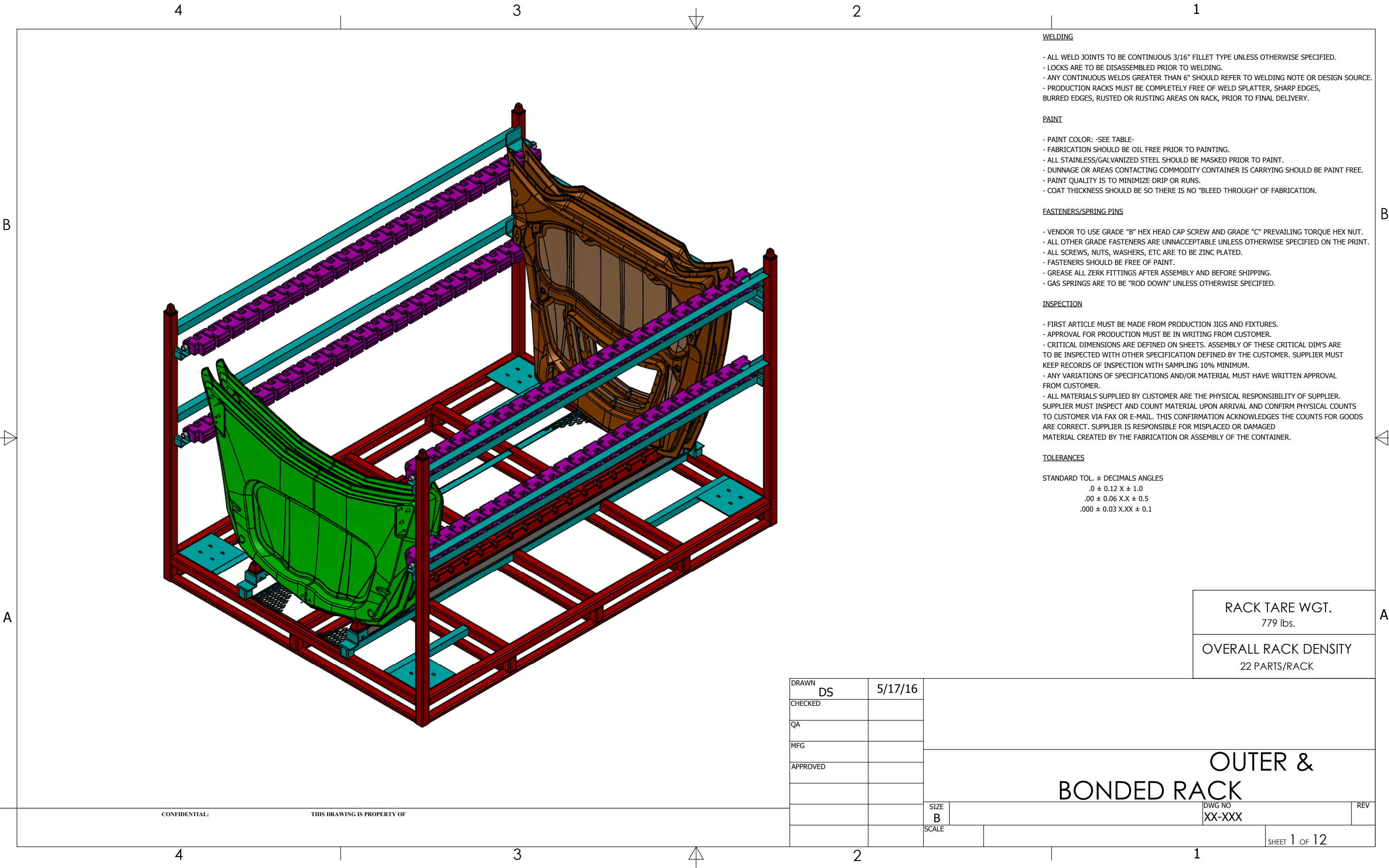
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3RD ANGLE PROJ DIMENSIONS
ARE IN MILLIMETERS

PART MUST COMPLY WITH MATERIAL SPECIFICATION
WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH,
SAFETY AND THE ENVIRONMENT

CUSTOMER	REF FILE #:		
	HVAC SHIPPING RACK		
DESIGN PSS	PART NAME		
ENGINEER PSS	PART NUMBER	REV 001	SHOWN
SCALE N/A	DIVISION AUTOMOTIVE	PLANT	SHT 1 OF 25



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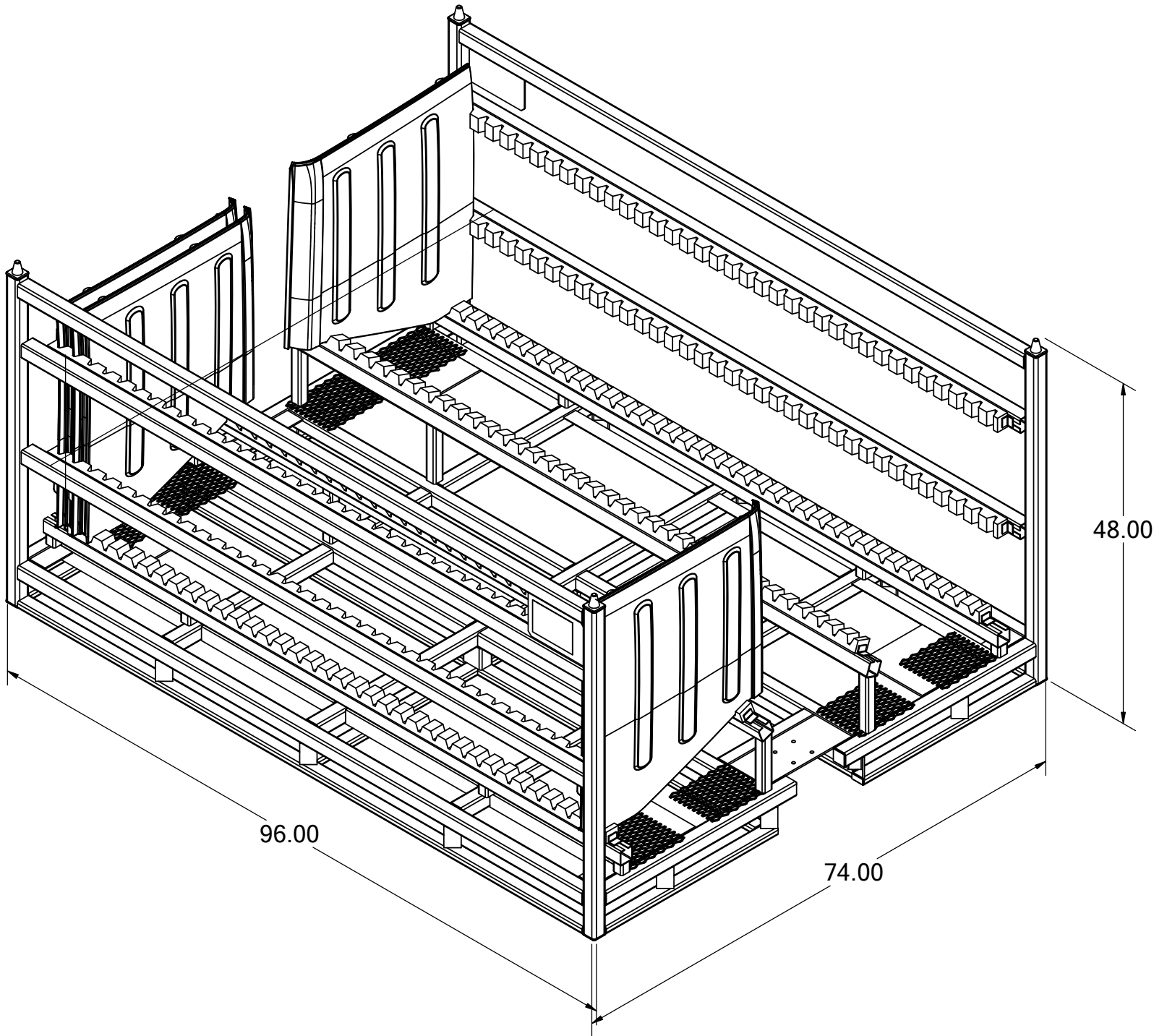
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.0 ± 0.12 X ± 1.0
.00 ± 0.06 X.X ± 0.5
.000 ± 0.03 X.XX ± 0.1

RACK TARE WGT.
779 lbs.

OVERALL RACK DENSITY
22 PARTS/RACK



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DECIMALS	ANGLES
.0 ± 0.12	X ± 1.0
.00 ± 0.06	X.X ± 0.5
.000 ± 0.03	X.XX ± 0.1

STANDARD TOL ±

- ALL BOXED DIMENSIONS TO BE HELD WITH +/- .06 RELATIVE TO THE ASSOCIATED DATUM FEATURE.

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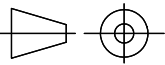
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RACK TARE WGT. 725 LBS.
OVERALL RACK DENSITY VARIOUS PARTS/RACK

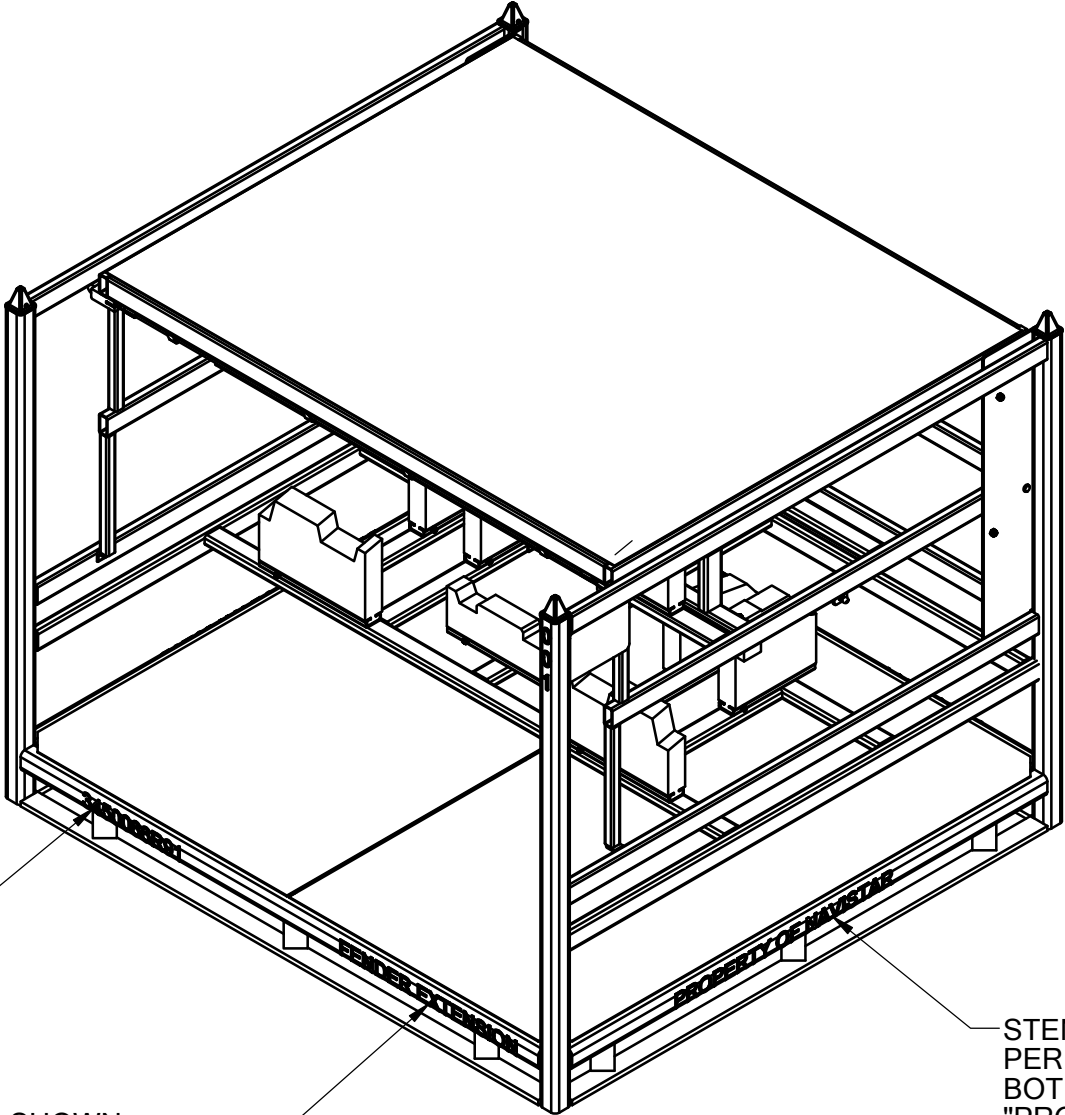
PART NO.	DESCRIPTION	RACK COLOR	STENCIL COLOR
- - -	FREEDOM PANEL	SAFETY ORANGE	BLACK
- - -		SAFETY ORANGE	

P2	CHANGE DUNNAGE SPACING	6/8/2017
P1	RELEASE FOR PROTOTYPE	4/20/2017
CHG	DESCRIPTION	DATE
DRAWING SET REL. LVL/DATE		P2/6-8-17

 THIRD ANGLE PROJECTION		
	NAME	DATE
DRAWN	CHL	4/20/17
CHECKED	- - -	- - -
CUSTOMER		/ /

PART NO: - - -		
DESCRIPTION: FREEDOM PANEL JL WIP RACK		
DO NOT SCALE DRAWING		SHEET 1 OF 13

DET	DESCRIPTION	QTY
1	2.00 x 1.00 x 11 GA(.12) x 61.00 LG. - STR. TUBE	2
2	2.00 x 1.00 x 11 GA(.12) x 56.00 LG. - STR. TUBE	2
3	2.00 x 1.00 x 11 GA(.12) x 33.31 LG. - STR. TUBE	2
4	2.00 x 1.00 x 11 GA(.12) x 19.75 LG. - STR. TUBE	2
5	2.00 x 1.00 x 11 GA(.12) x 16.31 LG. - STR. TUBE	8
6	LOW PROFILE STEEL DUNNAGE BAR x 12.56 LG.	6
7	LOW PROFILE STEEL DUNNAGE BAR x 9.56 LG.	8
8	2.00 x 1.00 x 11 GA(.12) x 58.50 LG. - STR. TUBE	1
9	LOW PROFILE STEEL DUNNAGE BAR x 47.50 LG.	2
10	2.00 x 1.00 x 11 GA(.12) x 18.50 LG. - STR. TUBE	2
11	2.00 x 1.00 x 11 GA(.12) x 5.69 LG. - STR. TUBE	2
12	FOAM - CLOSE-OFF	2
13	FOAM - REAR RIGHT	4
14	FOAM - REAR LEFT	4
15	FOAM - MIDDLE	2
16	FOAM - FRONT LEFT	2
17	FOAM - FRONT RIGHT	2
18	1/4 x 1.00" LG. - SELF DRILLING (TEK) SCREW	32



STENCIL AS SHOWN
PER NOTE ON SHEET 1
FRONT/BACK OF RACK
RACK NO.

STENCIL AS SHOWN
PER NOTE ON SHEET 1
FRONT/BACK OF RACK
DESRPTION

STENCIL AS SHOWN
PER NOTE ON SHEET 1
BOTH SIDES OF RACK
"PROPERTY OF " "

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DECIMALS	ANGLES
0 ± 0.12	X ± 1.0
.00 ± 0.06	X.X ± 0.5
.000 ± 0.03	X.XX ± 0.1

- TOLERANCES**
- STANDARD TOL ±
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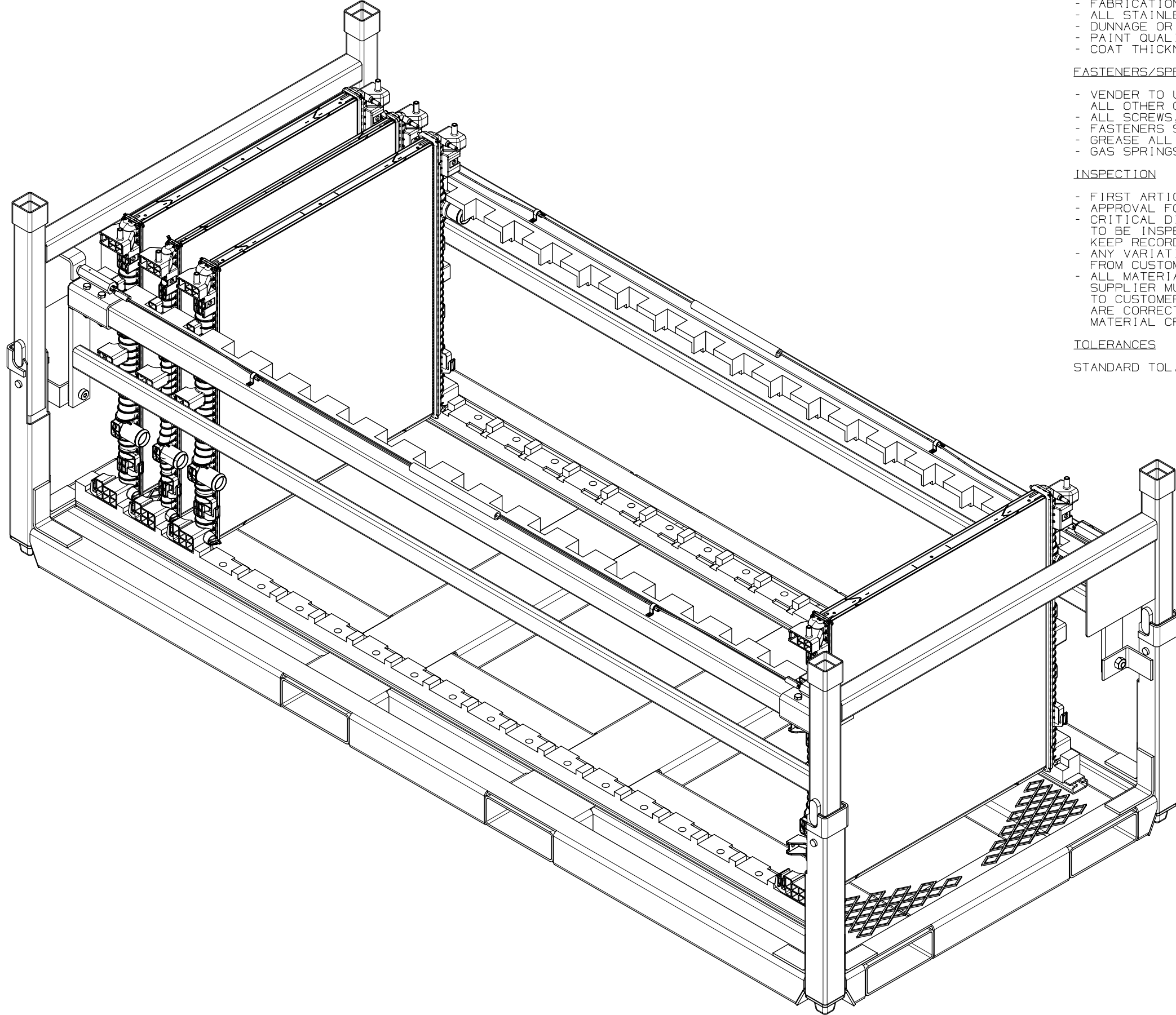
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RACK TARE WGT. 575 LBS
OVERALL RACK DENSITY 4 PARTS/RACK

PART NO.	DESCRIPTION	RACK COLOR	STENCIL COLOR
N/A	FENDER EXTENSION	TURBINE BLUE - SW #4064	WHITE

P3	RELEASE FOR PROTO	1/28/2016
CHG	DESCRIPTION	DATE
DRAWING SET REL. LVL/DATE		P3/1-28-16

<div><div>PSS</div><div>PACKAGING SOLUTIONS & SYSTEMS (248) 269-0455 WWW.PSSRACK.COM</div></div>			<div><div><div><div></div><div></div></div><div>THIRD ANGLE PROJECTION</div></div></div>		
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES			PART NO: N/A		
TOLERANCES: ANGULAR: ± 1 DEG. ONE PLACE DECIMAL ± .12 TWO PLACE DECIMAL ± .06 THREE PLACE DECIMAL ± .03			DESCRIPTION: FENDER EXTENSION		
DRAWN CHL 1/28/2016			DO NOT SCALE DRAWING		
CHECKED - - - - - -			SHEET 1 OF 12		
CUSTOMER / /					



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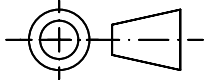
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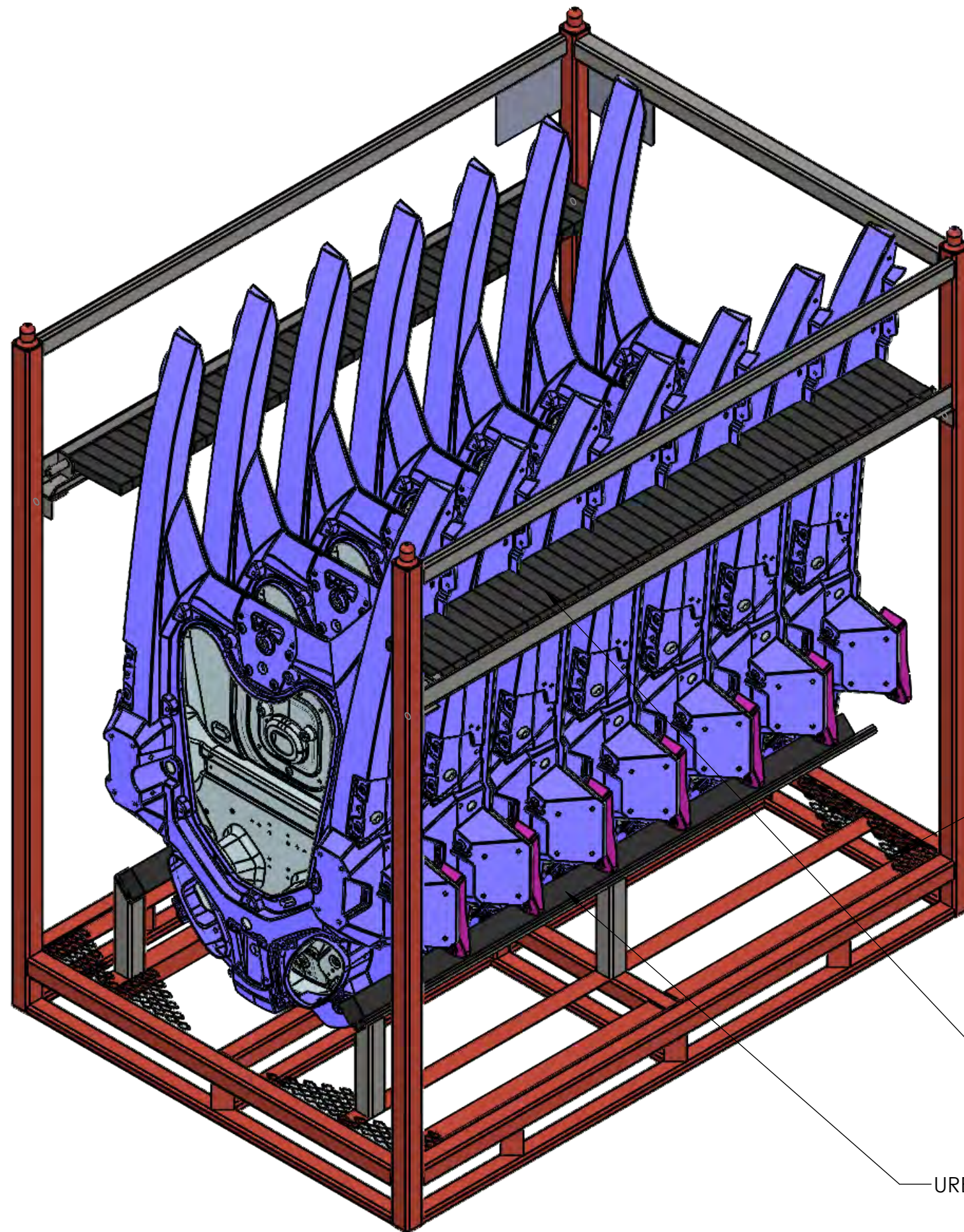
CD6 RADIATORS - 4 MODELS
RACK SIZE 96.38" X 42" X 35.56"
(19) PARTS PER RACK
EMPTY RACK WEIGHT = 605 POUNDS



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PART MUST COMPLY WITH MATERIAL SPECIFICATION
WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH,
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CUSTOMER	REF FILE #:		
	SHIPPING RACK		
DESIGN PSS	PART NAME RADIATORS		
ENGINEER PSS	PART NUMBER	REV 001	SHOWN
SCALE N/A	DIVISION AUTOMOTIVE	PLANT	SHT 1 OF 15



ESTIMATED DENSITY: 7

EXPANDED METAL ENTIRE BASE

FLIPPERS

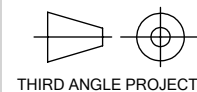
URETHANE DUNNAGE

PSS

PACKAGING SOLUTIONS &
SYSTEMS
(248) 269-0455
WWW.PSSRACK.COM

DATE

12/27/17



THIRD ANGLE PROJECTION

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WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH,
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CUSTOMER REF FILE #:

NA

MFG
DESIGN

PART NAME

PSS

FRONT END ASM

ENGINEER

PART NUMBER

REV

CMM

XXXXXXXXXXXXX

000

SCALE

DIVISION

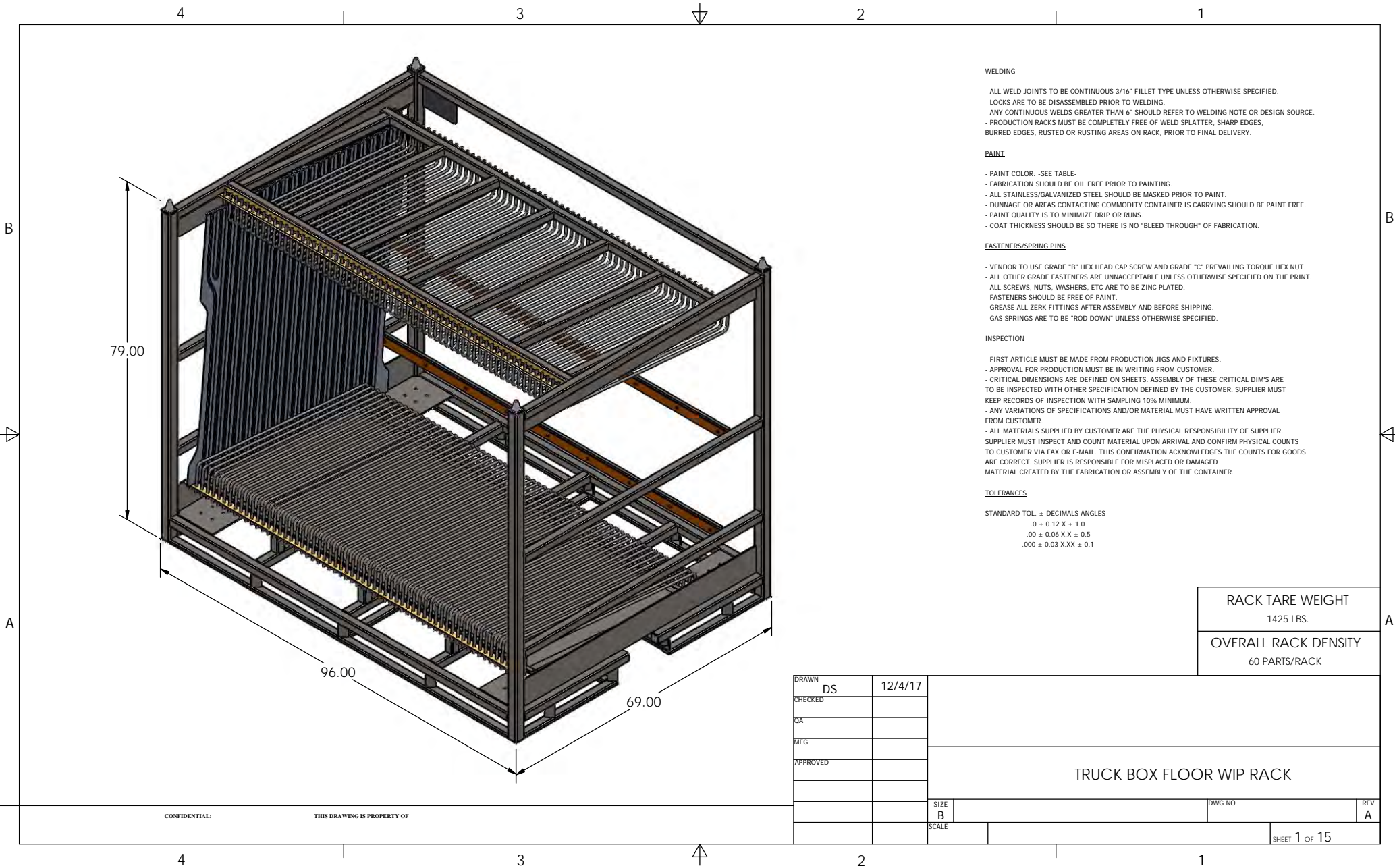
AUTOMOTIVE

N/A

PLANT

SHOWN

SHEET 1
OF 4



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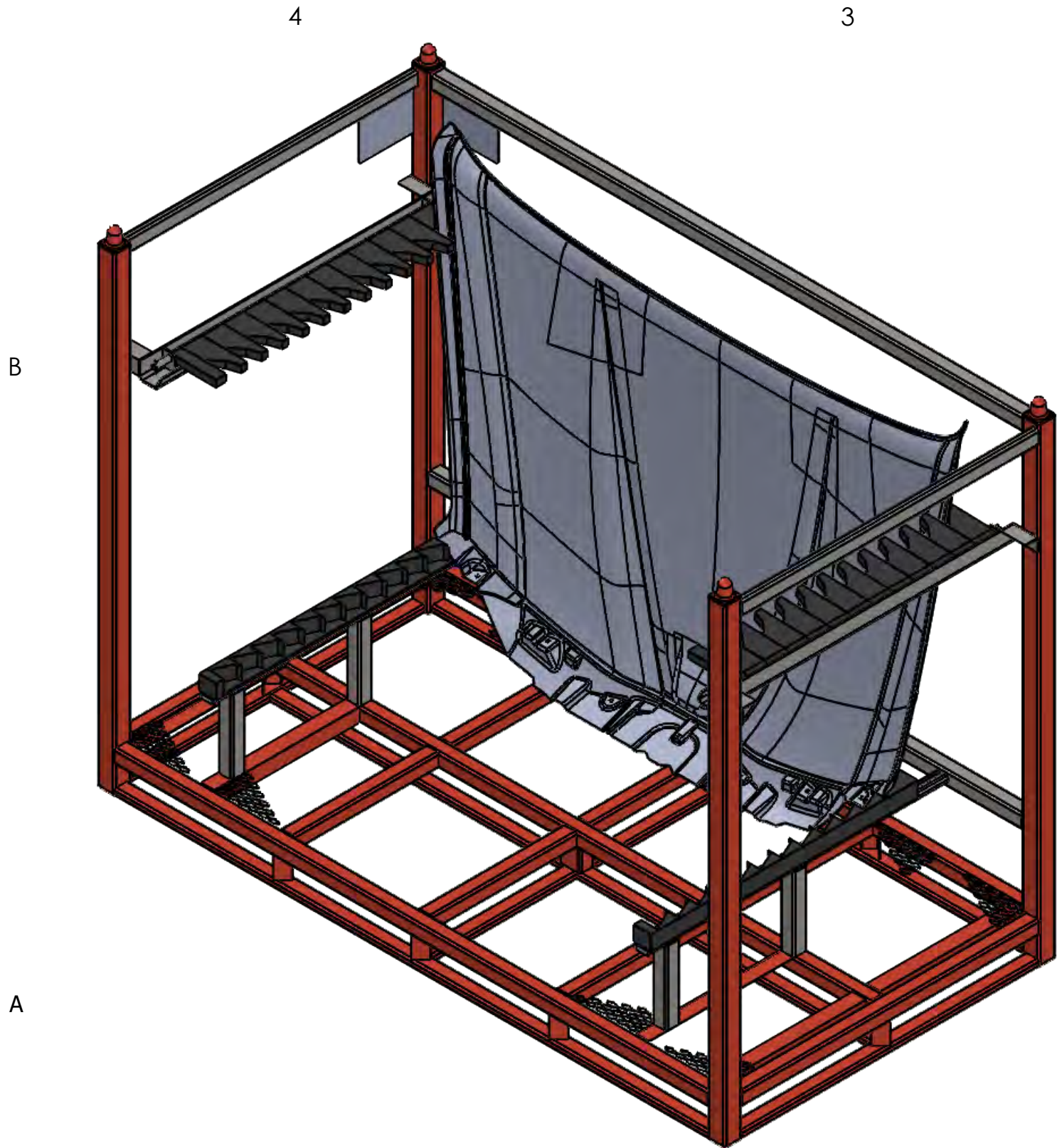
- FIRST ARTICLE MUST BE MADE FROM PRODUCTION JIGS AND FIXTURES.
- APPROVAL FOR PRODUCTION MUST BE IN WRITING FROM CUSTOMER.
- CRITICAL DIMENSIONS ARE DEFINED ON SHEETS. ASSEMBLY OF THESE CRITICAL DIM'S ARE TO BE INSPECTED WITH OTHER SPECIFICATION DEFINED BY THE CUSTOMER. SUPPLIER MUST KEEP RECORDS OF INSPECTION WITH SAMPLING 10% MINIMUM.
- ANY VARIATIONS OF SPECIFICATIONS AND/OR MATERIAL MUST HAVE WRITTEN APPROVAL FROM CUSTOMER.
- ALL MATERIALS SUPPLIED BY CUSTOMER ARE THE PHYSICAL RESPONSIBILITY OF SUPPLIER. SUPPLIER MUST INSPECT AND COUNT MATERIAL UPON ARRIVAL AND CONFIRM PHYSICAL COUNTS TO CUSTOMER VIA FAX OR E-MAIL. THIS CONFIRMATION ACKNOWLEDGES THE COUNTS FOR GOODS ARE CORRECT. SUPPLIER IS RESPONSIBLE FOR MISPLACED OR DAMAGED MATERIAL CREATED BY THE FABRICATION OR ASSEMBLY OF THE CONTAINER.

TOLERANCES

STANDARD TOL. ± DECIMALS ANGLES
.0 ± 0.12 X ± 1.0
.00 ± 0.06 X.X ± 0.5
.000 ± 0.03 X.XX ± 0.1

RACK TARE WEIGHT
1425 LBS.
OVERALL RACK DENSITY
60 PARTS/RACK

DRAWN	DS	12/4/17	TRUCK BOX FLOOR WIP RACK		
CHECKED					
QA					
MFG					
APPROVED					
			SIZE	DWG NO	REV
			B		A
			SCALE		
					SHEET 1 OF 15



- WELDING**
- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
 - LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
 - ANY CONTINUOUS WELDS GREATER THAN 6" SHOULD REFER TO WELDING NOTE OR DESIGN SOURCE.
 - PRODUCTION RACKS MUST BE COMPLETELY FREE OF WELD SPLATTER, SHARP EDGES, BURRED EDGES, RUSTED OR RUSTING AREAS ON RACK, PRIOR TO FINAL DELIVERY.

- PAINT**
- PAINT COLOR: -SEE TABLE-
 - FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
 - ALL STAINLESS/GALANIZED STEEL SHOULD BE MASKED PRIOR TO PAINT.
 - DUNNAGE OR AREAS CONTACTING COMMODITY CONTAINER IS CARRYING SHOULD BE PAINT FREE.
 - PAINT QUALITY IS TO MINIMIZE DRIP OR RUNS.
 - COAT THICKNESS SHOULD BE SO THERE IS NO "BLEED THRU" OF FABRICATION.

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STANDARD TOL. ±	DECIMALS	ANGLES
	.0 ± 0.12	X ± 1.0
	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

RACK DIMENSIONS: 91" X 48" X 70.25"

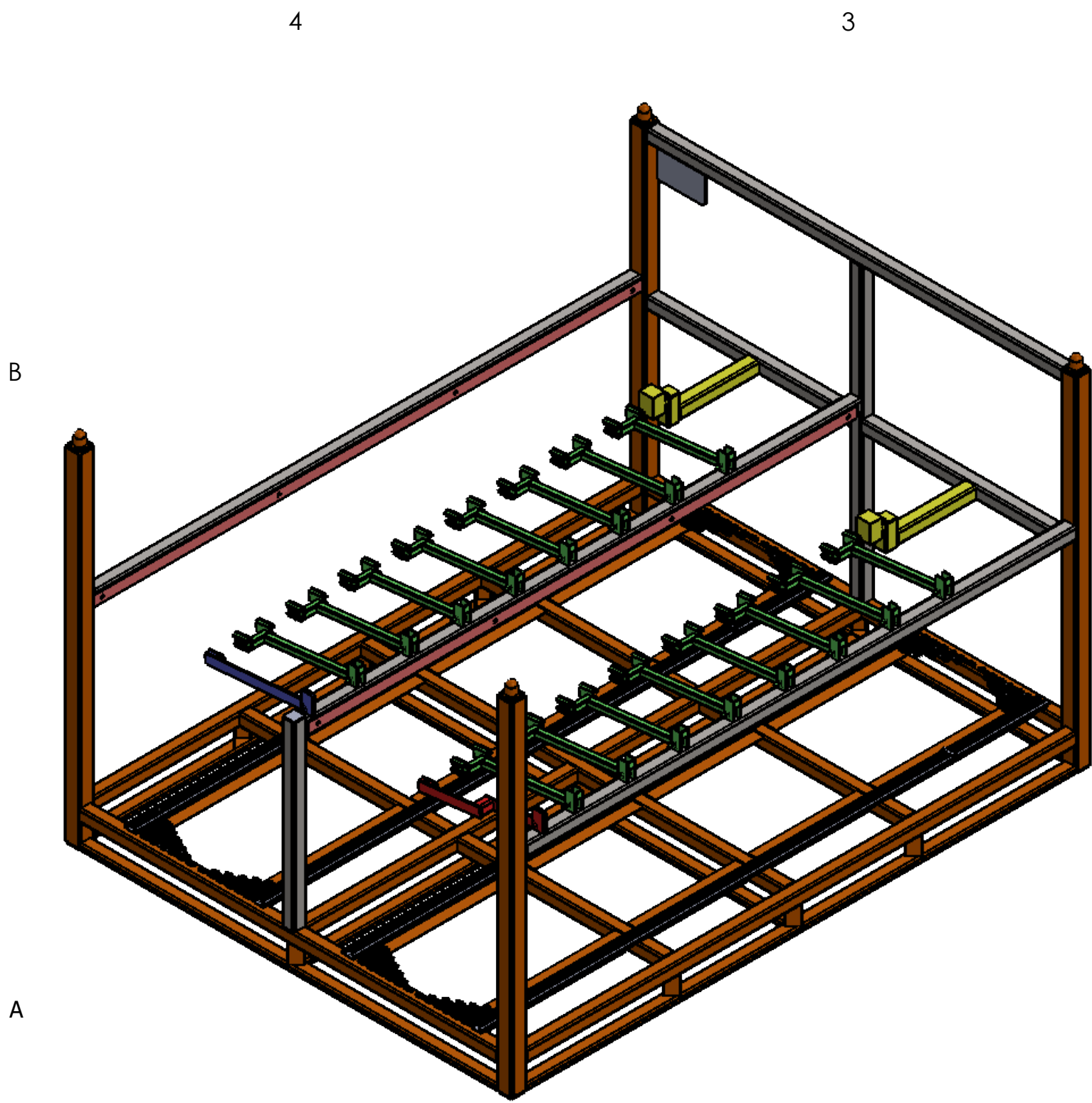
DENSITY = 12

ESTIMATED WEIGHT = 423lbs

RACK COLOR: TBD

DRAWN
CMM 12/1/17
CHECKED
QA
MFG
APPROVED

HOOD CENTER WIP RACK



WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
- LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
- ANY CONTINUOUS WELDS GREATER THAN 6" SHOULD REFER TO WELDING NOTE OR DESIGN SOURCE.
- PRODUCTION RACKS MUST BE COMPLETELY FREE OF WELD SPLATTER, SHARP EDGES, BURRED EDGES, RUSTED OR RUSTING AREAS ON RACK, PRIOR TO FINAL DELIVERY.

PAINT

- PAINT COLOR: -SEE TABLE-
- FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
- ALL STAINLESS/GALANIZED STEEL SHOULD BE MASKED PRIOR TO PAINT.
- DUNNAGE OR AREAS CONTACTING COMMODITY CONTAINER IS CARRYING SHOULD BE PAINT FREE.
- PAINT QUALITY IS TO MINIMIZE DRIP OR RUNS.
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INSPECTION

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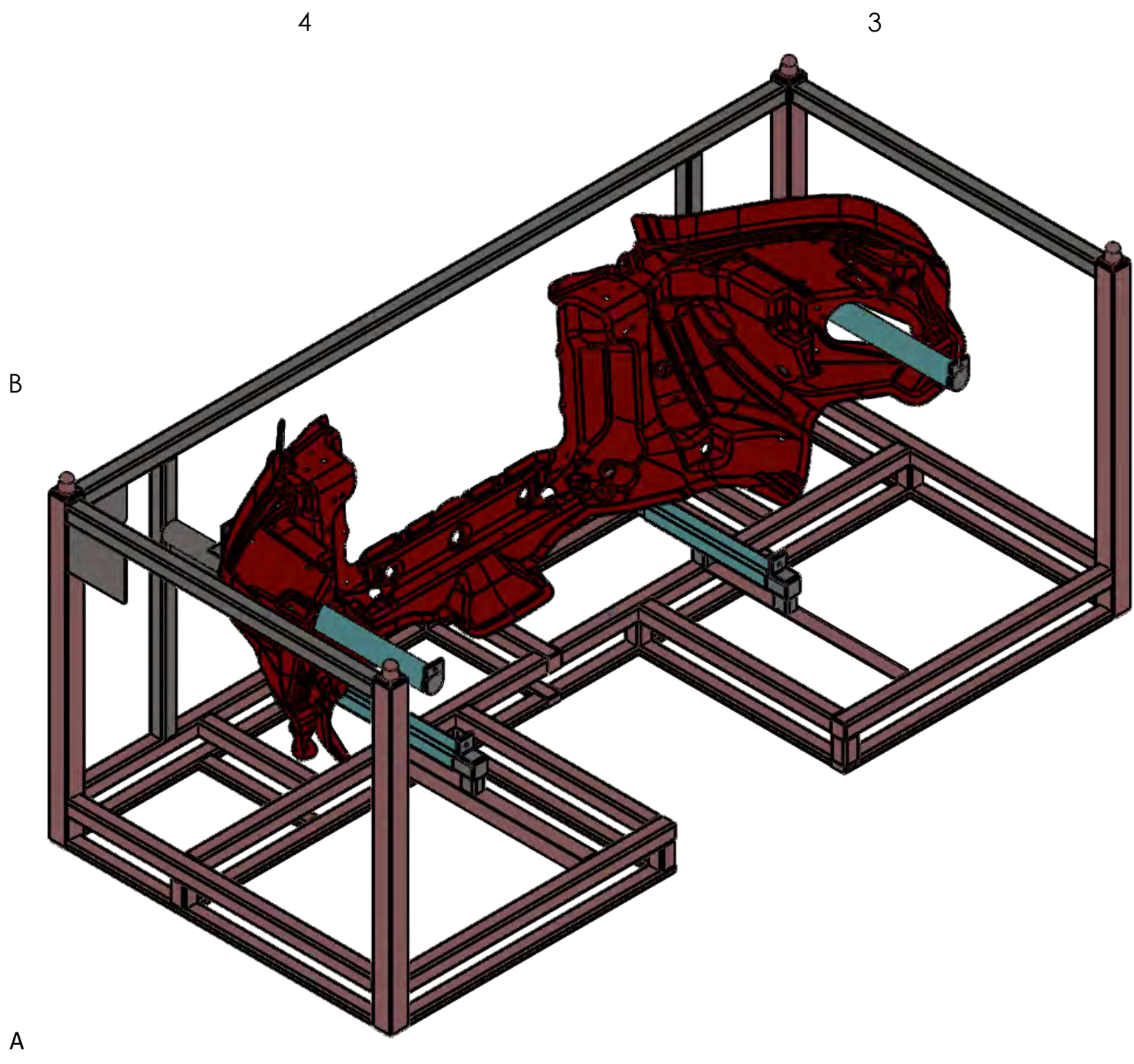
TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
.0 ±	0.12	X ± 1.0
.00 ±	0.06	X.X ± 0.5
.000 ±	0.03	X.XX ± 0.1

RACK DIMENSIONS: 96" X 74" X 59"
ESTIMATED DENSITY = 9 PER SIDE
ESTIMATED WEIGHT = 625 lbs
RACK COLOR: TBD

DRAWN
CMM 12/4/17
CHECKED
QA
MFG
APPROVED

HOOD FENDER EXT WIP RACK



WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
- LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
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TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
.0 ±	0.12	X ± 1.0
.00 ±	0.06	X.X ± 0.5
.000 ±	0.03	X.XX ± 0.1

RACK DIMENSIONS: 96" X 48" X 44.5"

ESTIMATED DENSITY = 7

ESTIMATED WEIGHT = 393lbs

RACK COLOR: TBD

DRAWN
CMM 11/8/17
CHECKED

QA

MFG

APPROVED

HOOD GOR WIP RACK

CONFIDENTIAL:

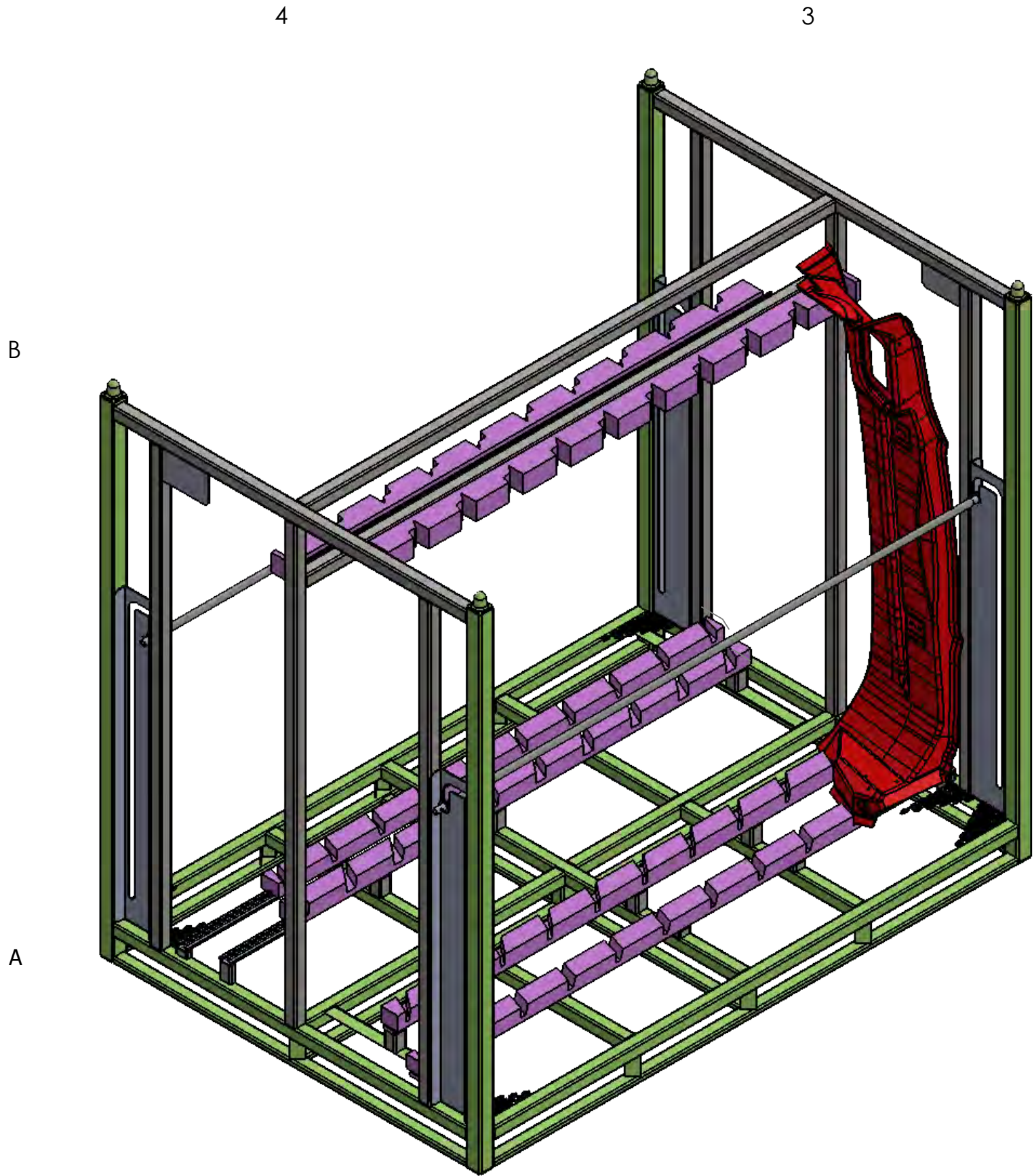
THIS DRAWING IS PROPERTY OF

SIZE
B
SCALE
N/A

DWG NO

REV
A

SHEET 1 OF 13



- WELDING**
- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
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TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
	.0 ± 0.12	X ± 1.0
	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

RACK DIMENSIONS: 96" X 66.25" X 86.5"

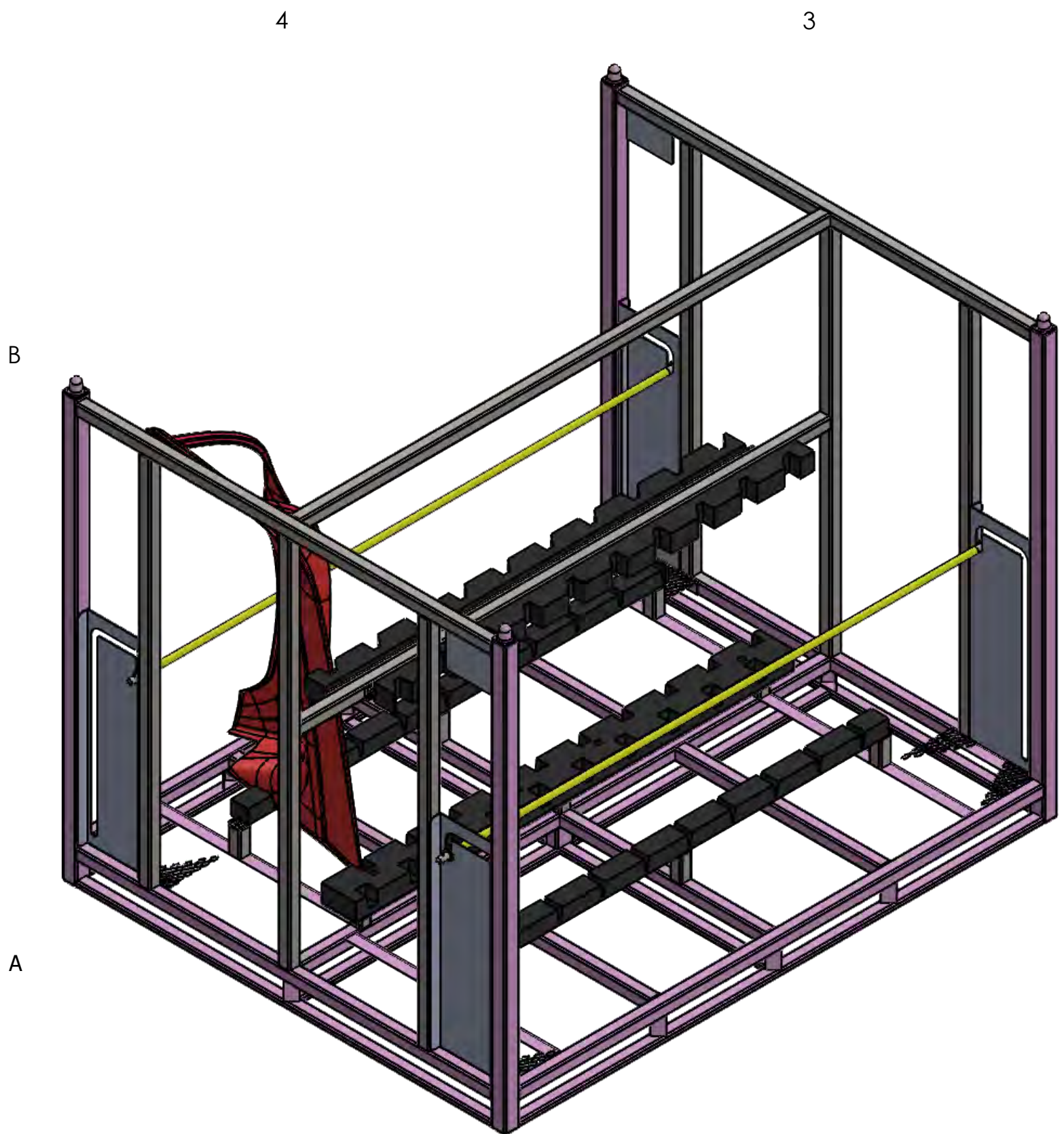
DENSITY = 10

ESTIMATED WEIGHT = 700lbs

RACK COLOR: TBD

DRAWN
CMM
CHECKED
12/4/17
QA
MFG
APPROVED

HOOD PLENUM WIP RACK



WELDING

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TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
.0 ±	0.12	X ± 1.0
.00 ±	0.06	X.X ± 0.5
.000 ±	0.03	X.XX ± 0.1

RACK DIMENSIONS: 96" X 77" X 75.5"

DENSITY = 10 PER SIDE

ESTIMATED WEIGHT = 760lbs

RACK COLOR = TBD

DRAWN
CMM 11/30/17
CHECKED
QA
MFG
APPROVED

HOOD RH SIDE OUTER WIP RACK

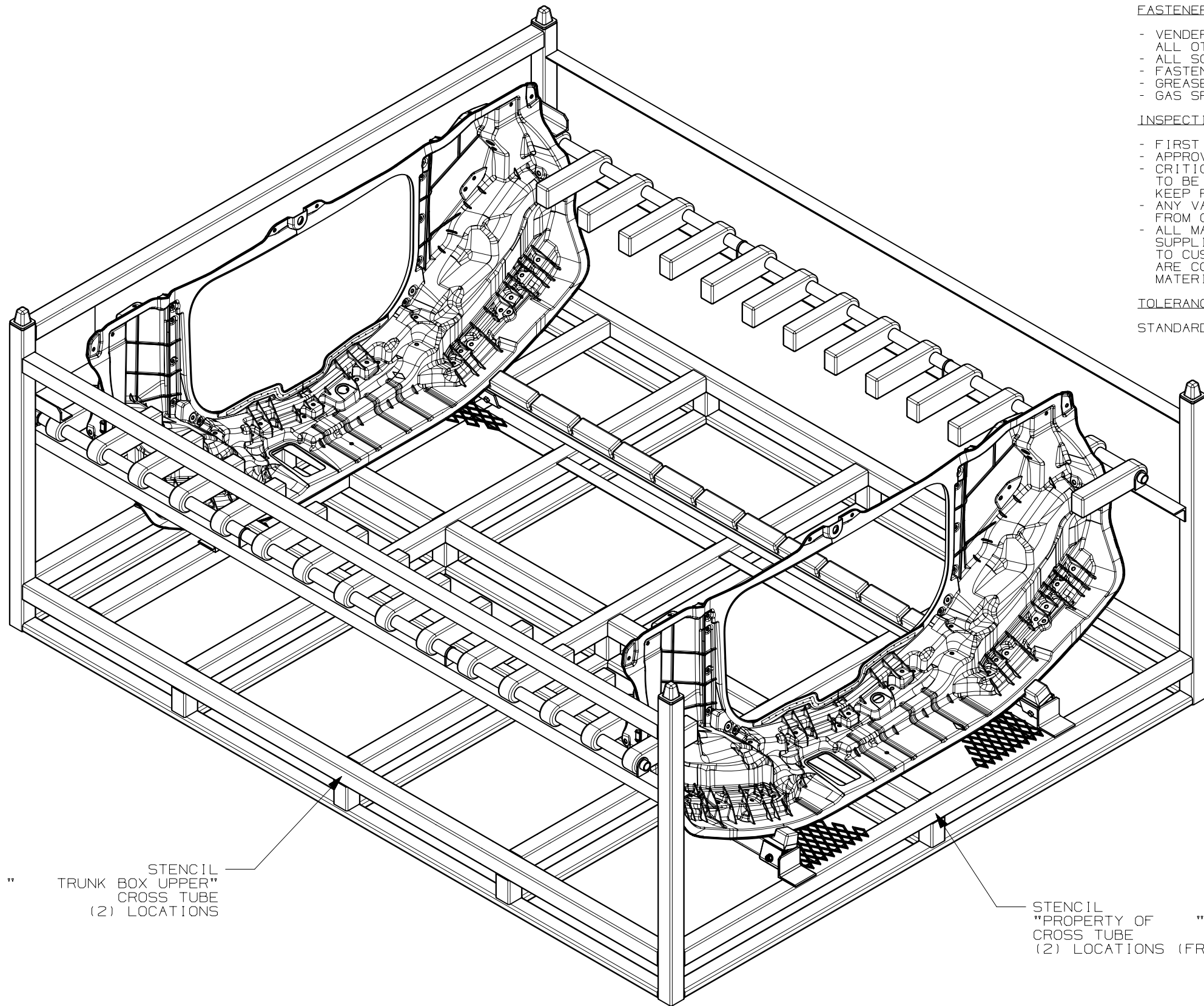
CONFIDENTIAL:

THIS DRAWING IS PROPERTY OF

SIZE
B
SCALE

DWG NO

REV
A



STENCIL
"TRUNK BOX UPPER"
CROSS TUBE
(2) LOCATIONS

STENCIL
"PROPERTY OF
CROSS TUBE
(2) LOCATIONS (FRONT & REAR)

WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
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- COAT THICKNESS SHOULD BE SO THERE IS NO "BLEED THRU" OF FABRICATION.

FASTENERS/SPRING PINS

- VENDER TO USE GRADE "8" HEX HEAD CAP SCREW AND GRADE "C" PREVAILING TORQUE HEX NUT.
- ALL OTHER GRADE FASTENERS ARE UNACCEPTABLE UNLESS OTHERWISE SPECIFIED ON THE PRINT.
- ALL SCREWS, NUTS, WASHERS, ETC ARE TO BE ZINC PLATED.
- FASTENERS SHOULD BE FREE OF PAINT.
- GREASE ALL ZERK FITTINGS AFTER ASSEMBLY AND BEFORE SHIPPING.
- GAS SPRINGS ARE TO BE "ROD DOWN" UNLESS OTHERWISE SPECIFIED.

INSPECTION

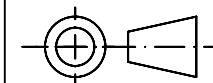
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TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
.0	± 0.12	X ± 1.0
.00	± 0.06	X.X ± 0.5
.000	± 0.03	X.XX ± 0.1

NOTE :

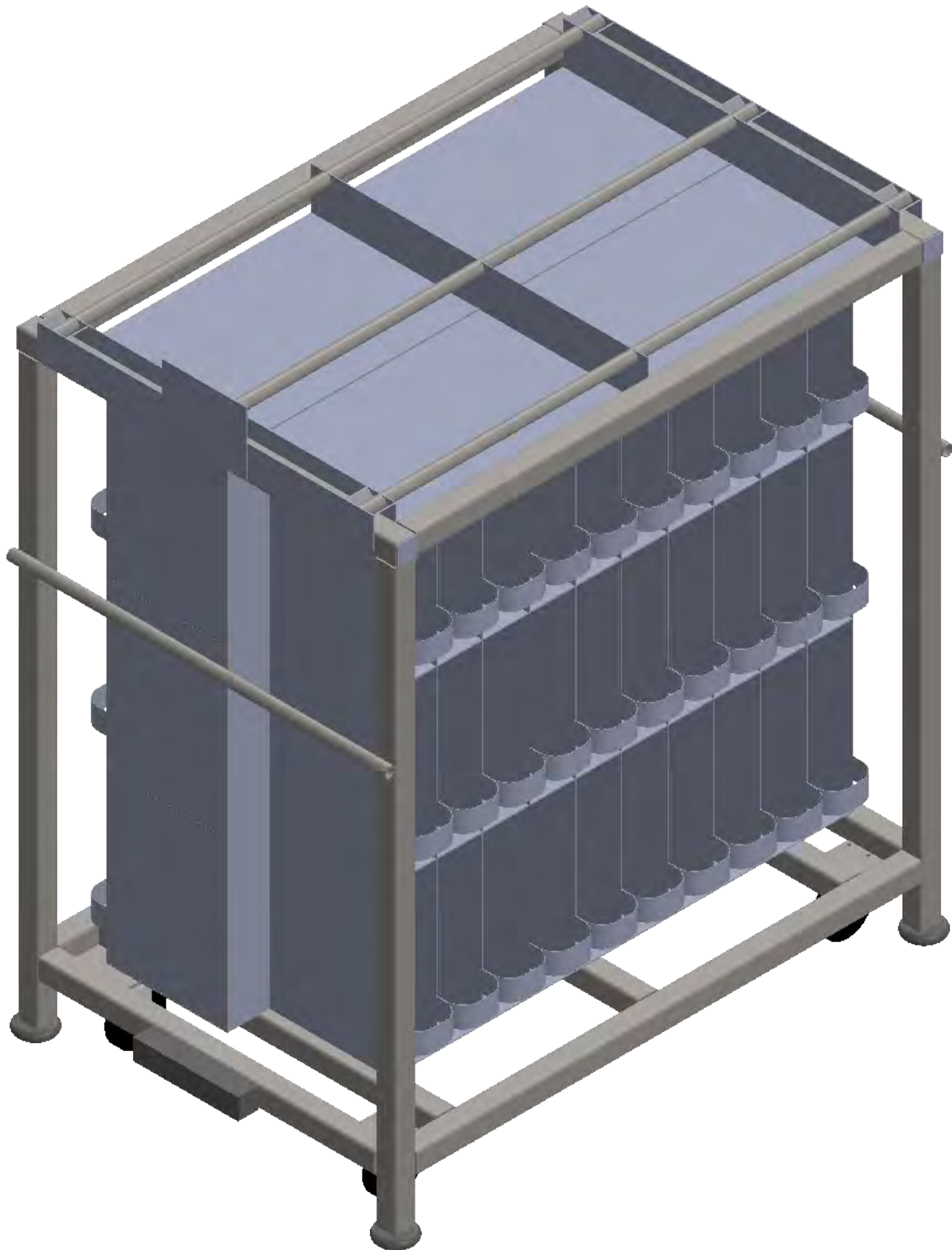
(14) PARTS PER RACK
RACKS WEIGHT = 441 POUNDS
RACK COLOR LIGHT GREEN (NPVP 7.5GY 8/4)
WITH BLACK STENCILS



3RD ANGLE PROJ DIMENSIONS
ARE IN MILLIMETERS

PART MUST COMPLY WITH MATERIAL SPECIFICATION
WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH,
SAFETY AND THE ENVIRONMENT

CUSTOMER	REF FILE #:		
	PRODUCTION WIP RACK DESIGN		
DESIGN	PART NAME		
	TRUNK BOX UPPER SHELL		
ENGINEER	DATE	REV	SHOWN
BL	3-17-2015	003	
SCALE	DIVISION		
N/A	AUTOMOTIVE		
	PLANT		
		SHT 1	OF 11



WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
- LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
- ANY CONTINUOUS WELDS GREATER THAN 6" SHOULD REFER TO WELDING NOTE OR DESIGN SOURCE.
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TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
.0 ±	0.12	X ± 1.0
.00 ±	0.06	X.X ± 0.5
.000 ±	0.03	X.XX ± 0.1

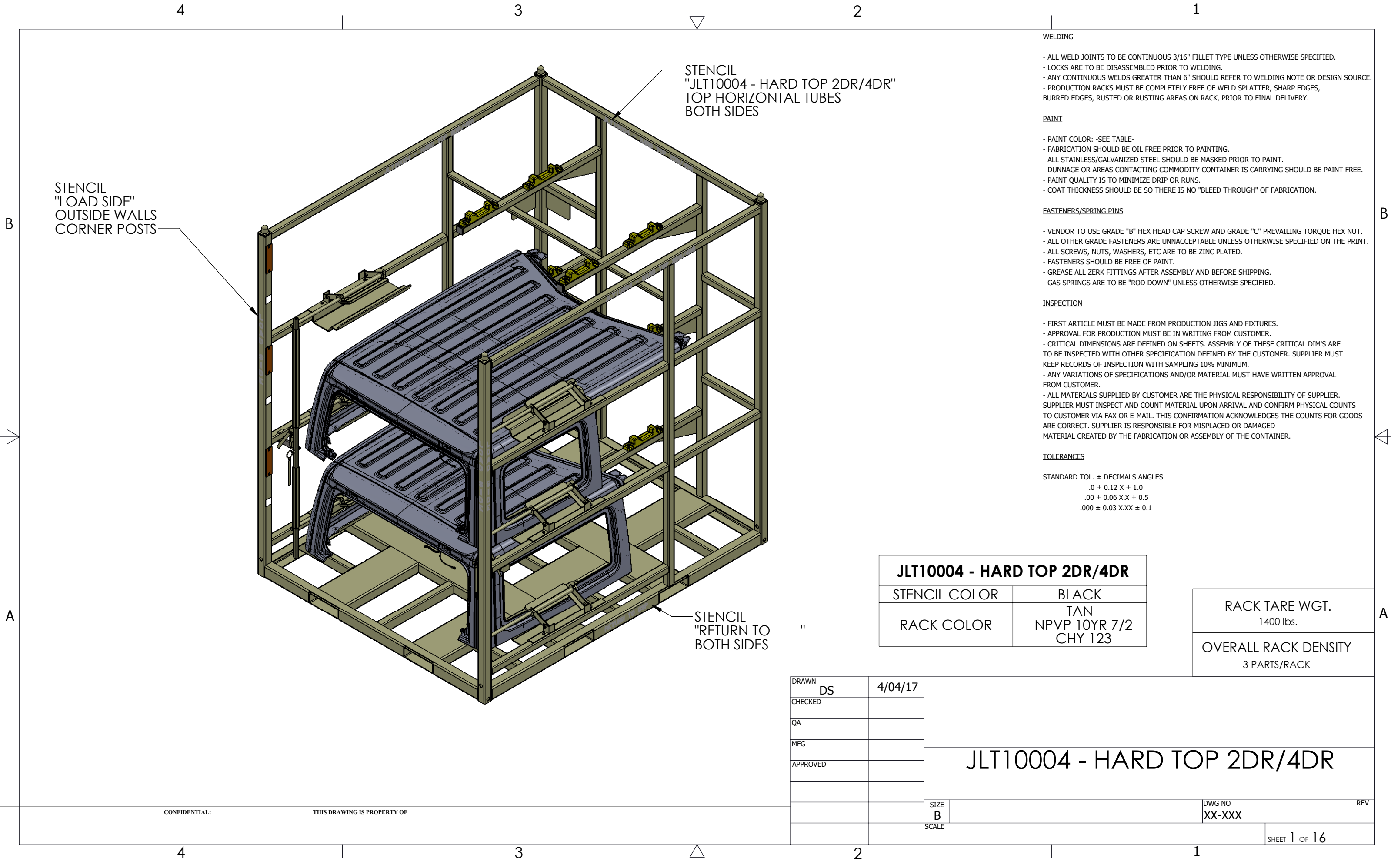
RACK DIMENSIONS: 64.84" X 56" X 37.75"

DENSITY = 30 PER SIDE

ESTIMATED WEIGHT = 305LBS

RACK COLOR: TBD

<div><div>PSS</div><div>PACKAGING SOLUTIONS & SYSTEMS (248) 269-0455 WWW.PSSRACK.COM</div></div>	
DATE	12/27/17
<div><div><div><div></div><div></div></div><div>THIRD ANGLE PROJECTION</div></div><div>3RD ANGLE PROJ DIMENSIONS ARE IN INCHES</div></div>	
PART MUST COMPLY WITH MATERIAL SPECIFICATION WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT	
CUSTOMER	REF FILE #:
MAHLE DESIGN	WIP DOLLY DESIGN
PSS	PART NAME
ENGINEER	PART NUMBER
CMM	XXXXXXXXXXXXXX
SCALE	DIVISION
N/A	AUTOMOTIVE
REV	000
SHOWN	SHEET 1 OF 9



WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
- LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
- ANY CONTINUOUS WELDS GREATER THAN 6" SHOULD REFER TO WELDING NOTE OR DESIGN SOURCE.
- PRODUCTION RACKS MUST BE COMPLETELY FREE OF WELD SPLATTER, SHARP EDGES, BURRED EDGES, RUSTED OR RUSTING AREAS ON RACK, PRIOR TO FINAL DELIVERY.

PAINT

- PAINT COLOR: -SEE TABLE-
- FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
- ALL STAINLESS/GALVANIZED STEEL SHOULD BE MASKED PRIOR TO PAINT.
- DUNNAGE OR AREAS CONTACTING COMMODITY CONTAINER IS CARRYING SHOULD BE PAINT FREE.
- PAINT QUALITY IS TO MINIMIZE DRIP OR RUNS.
- COAT THICKNESS SHOULD BE SO THERE IS NO "BLEED THROUGH" OF FABRICATION.

FASTENERS/SPRING PINS

- VENDOR TO USE GRADE "B" HEX HEAD CAP SCREW AND GRADE "C" PREVAILING TORQUE HEX NUT.
- ALL OTHER GRADE FASTENERS ARE UNACCEPTABLE UNLESS OTHERWISE SPECIFIED ON THE PRINT.
- ALL SCREWS, NUTS, WASHERS, ETC ARE TO BE ZINC PLATED.
- FASTENERS SHOULD BE FREE OF PAINT.
- GREASE ALL ZERK FITTINGS AFTER ASSEMBLY AND BEFORE SHIPPING.
- GAS SPRINGS ARE TO BE "ROD DOWN" UNLESS OTHERWISE SPECIFIED.

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TOLERANCES

STANDARD TOL. ± DECIMALS ANGLES

.0 ± 0.12 X ± 1.0

.00 ± 0.06 X.X ± 0.5

.000 ± 0.03 X.XX ± 0.1

JLT10004 - HARD TOP 2DR/4DR	
STENCIL COLOR	BLACK
RACK COLOR	TAN NPVP 10YR 7/2 CHY 123

RACK TARE WGT. 1400 lbs.
OVERALL RACK DENSITY 3 PARTS/RACK

DRAWN DS	4/04/17	JLT10004 - HARD TOP 2DR/4DR		
CHECKED				
QA				
MFG				
APPROVED				
		SIZE B	DWG NO XX-XXX	REV
		SCALE		
		SHEET 1 OF 16		

4

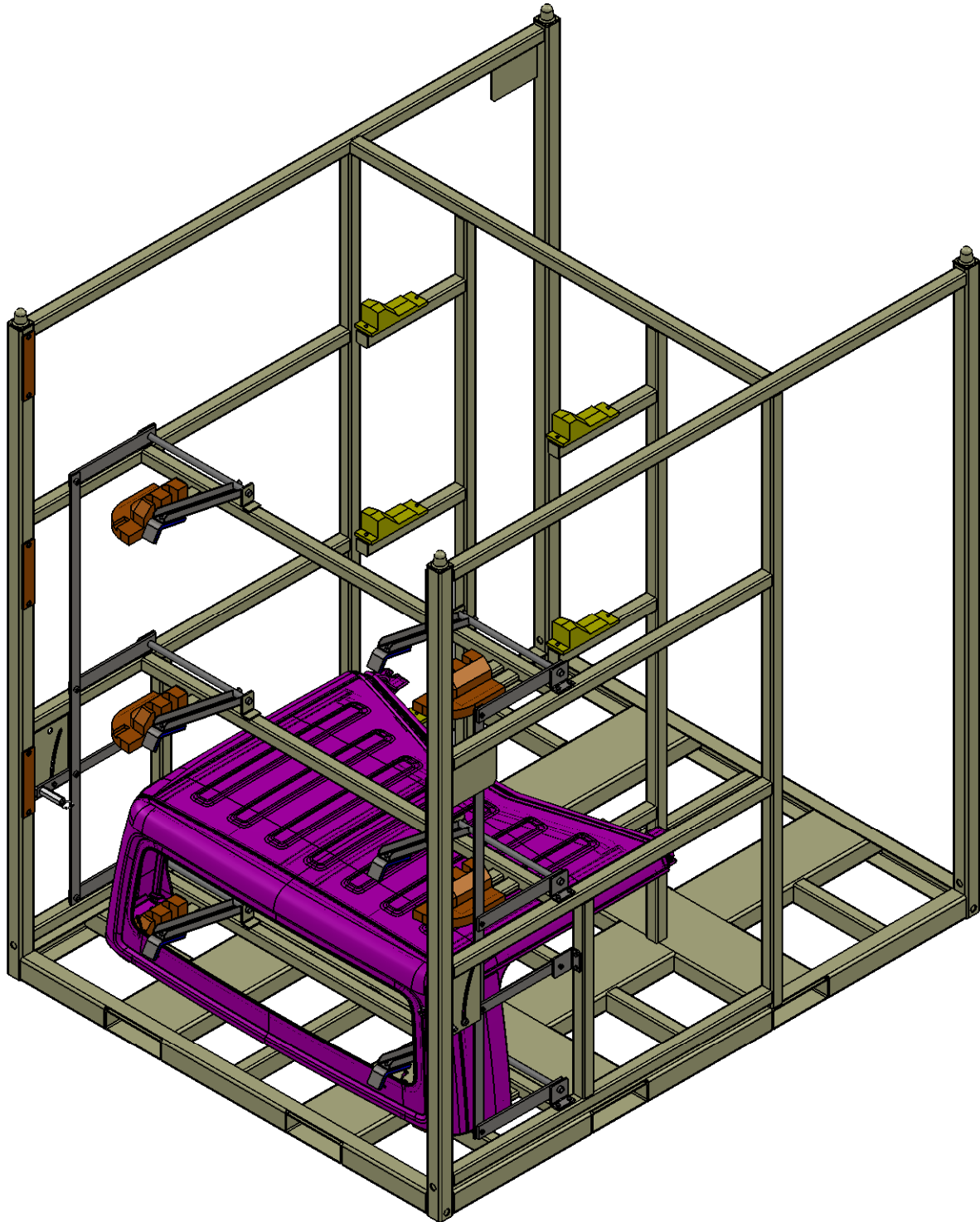
3

2

1

B

A



WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
- LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
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PAINT

- PAINT COLOR: -SEE TABLE-
- FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
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- DUNNAGE OR AREAS CONTACTING COMMODITY CONTAINER IS CARRYING SHOULD BE PAINT FREE.
- PAINT QUALITY IS TO MINIMIZE DRIP OR RUNS.
- COAT THICKNESS SHOULD BE SO THERE IS NO "BLEED THROUGH" OF FABRICATION.

FASTENERS/SPRING PINS

- VENDOR TO USE GRADE "B" HEX HEAD CAP SCREW AND GRADE "C" PREVAILING TORQUE HEX NUT.
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- FASTENERS SHOULD BE FREE OF PAINT.
- GREASE ALL ZERK FITTINGS AFTER ASSEMBLY AND BEFORE SHIPPING.
- GAS SPRINGS ARE TO BE "ROD DOWN" UNLESS OTHERWISE SPECIFIED.

INSPECTION

- FIRST ARTICLE MUST BE MADE FROM PRODUCTION JIGS AND FIXTURES.
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TOLERANCES

STANDARD TOL. ± DECIMALS ANGLES
.0 ± 0.12 X ± 1.0
.00 ± 0.06 X.X ± 0.5
.000 ± 0.03 X.XX ± 0.1

RACK TARE WGT.
1250 lbs.

OVERALL RACK DENSITY
3 PARTS/RACK

DRAWN	DS	12/18/17	JT TRUCK - 3 HARD TOP RACK				
CHECKED							
QA							
MFG							
APPROVED							
			SIZE B		DWG NO XX-XXX		REV
			SCALE				SHEET 1 OF 17

CONFIDENTIAL:

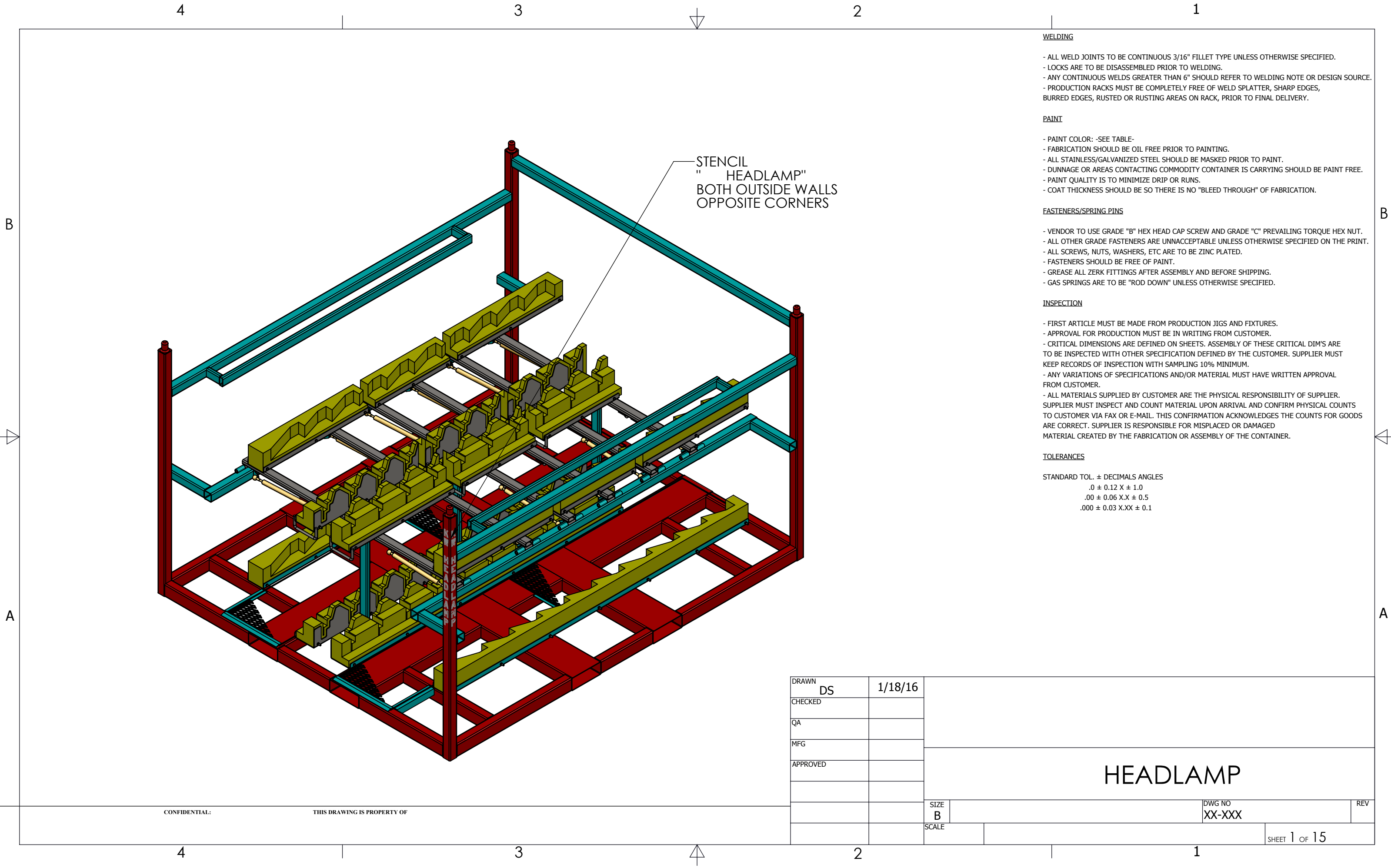
THIS DRAWING IS PROPERTY OF

4

3

2

1



WELDING

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INSPECTION

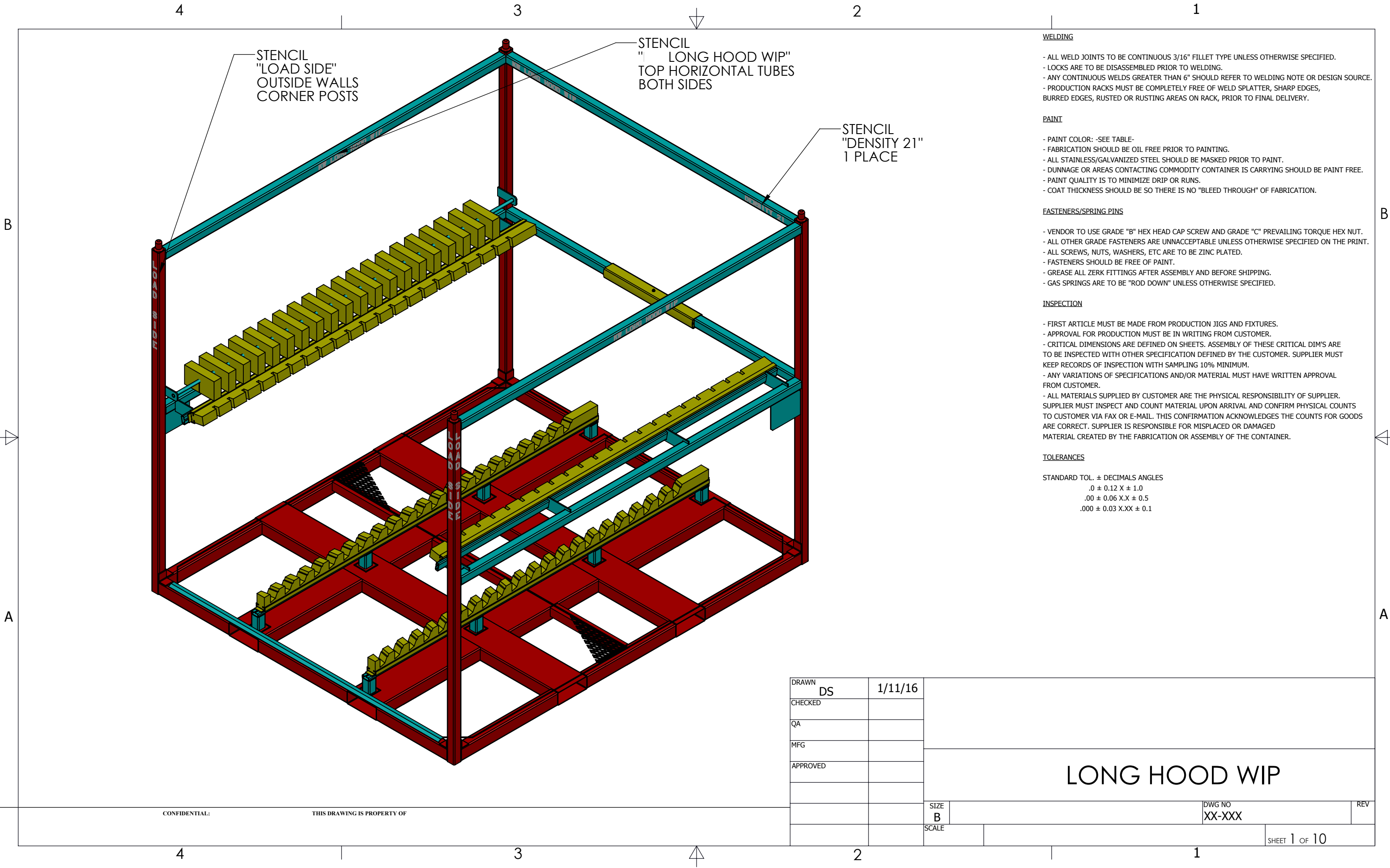
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.0 ± 0.12 X ± 1.0
.00 ± 0.06 X.X ± 0.5
.000 ± 0.03 X.XX ± 0.1

DRAWN	DS	1/18/16	HEADLAMP		
CHECKED					
QA					
MFG					
APPROVED					
			SIZE	DWG NO	REV
			B	XX-XXX	
			SCALE		
			SHEET 1 OF 15		

CONFIDENTIAL: THIS DRAWING IS PROPERTY OF



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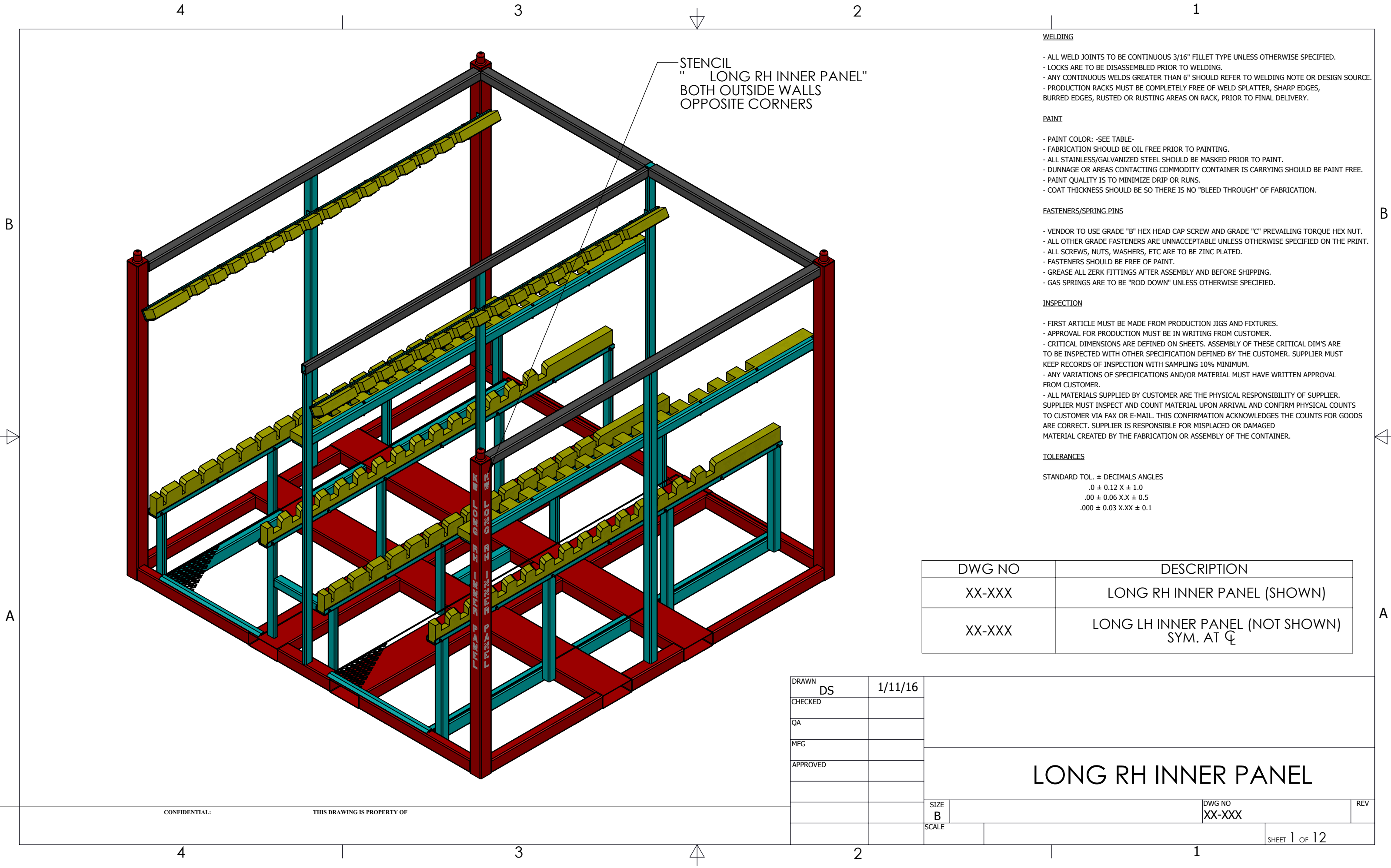
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.0 ± 0.12 X ± 1.0
.00 ± 0.06 X.X ± 0.5
.000 ± 0.03 X.XX ± 0.1

DRAWN	DS	1/11/16	LONG HOOD WIP			
CHECKED						
QA						
MFG						
APPROVED						
			SIZE	DWG NO	REV	
			B	XX-XXX		
			SCALE			
						SHEET 1 OF 10



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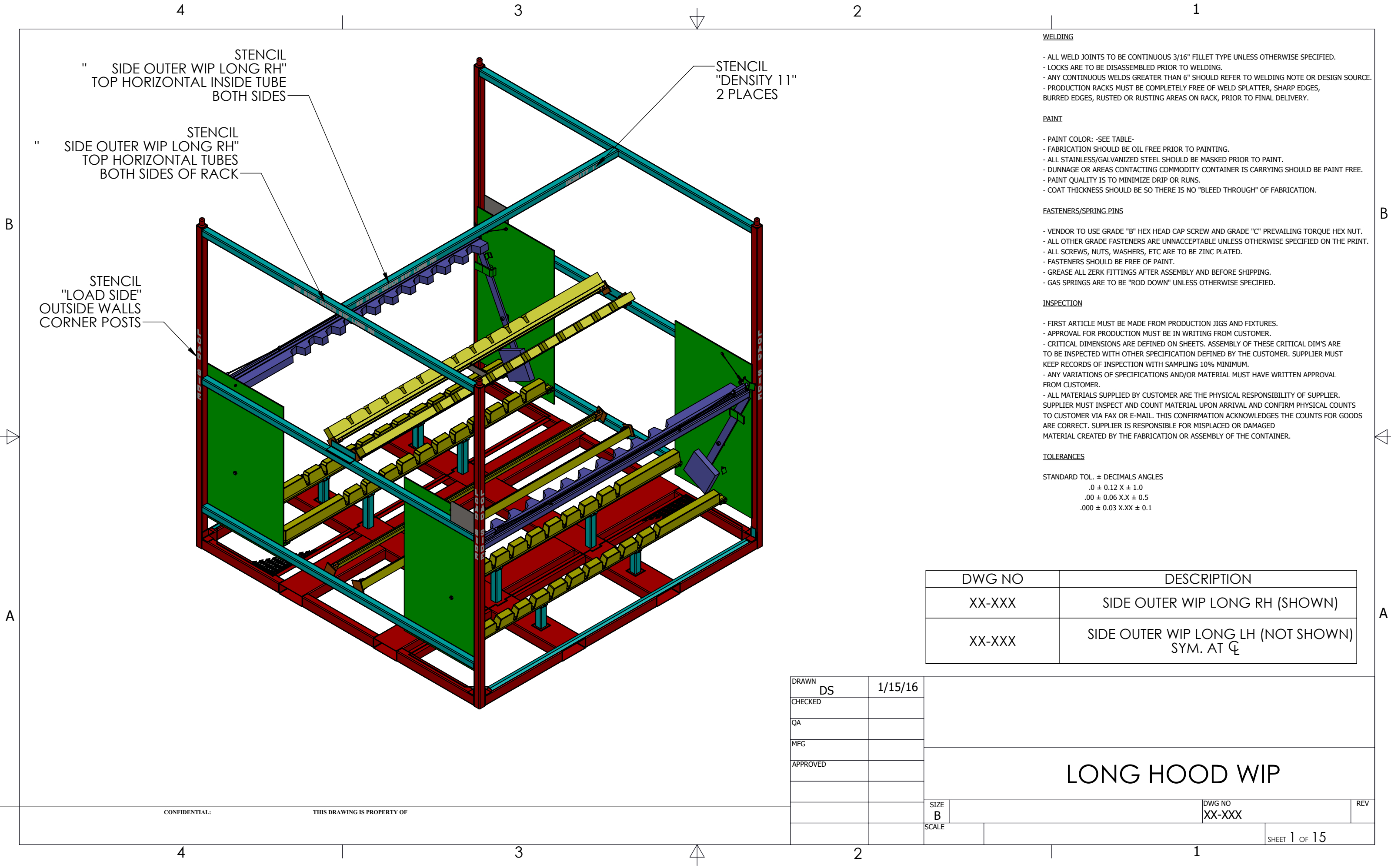
TOLERANCES

STANDARD TOL. ± DECIMALS ANGLES
.0 ± 0.12 X ± 1.0
.00 ± 0.06 X.X ± 0.5
.000 ± 0.03 X.XX ± 0.1

DWG NO	DESCRIPTION
XX-XXX	LONG RH INNER PANEL (SHOWN)
XX-XXX	LONG LH INNER PANEL (NOT SHOWN) SYM. AT Ț

DRAWN DS	1/11/16	LONG RH INNER PANEL		
CHECKED				
QA				
MFG				
APPROVED				
		SIZE B	DWG NO XX-XXX	REV
		SCALE	SHEET 1 OF 12	

CONFIDENTIAL: THIS DRAWING IS PROPERTY OF



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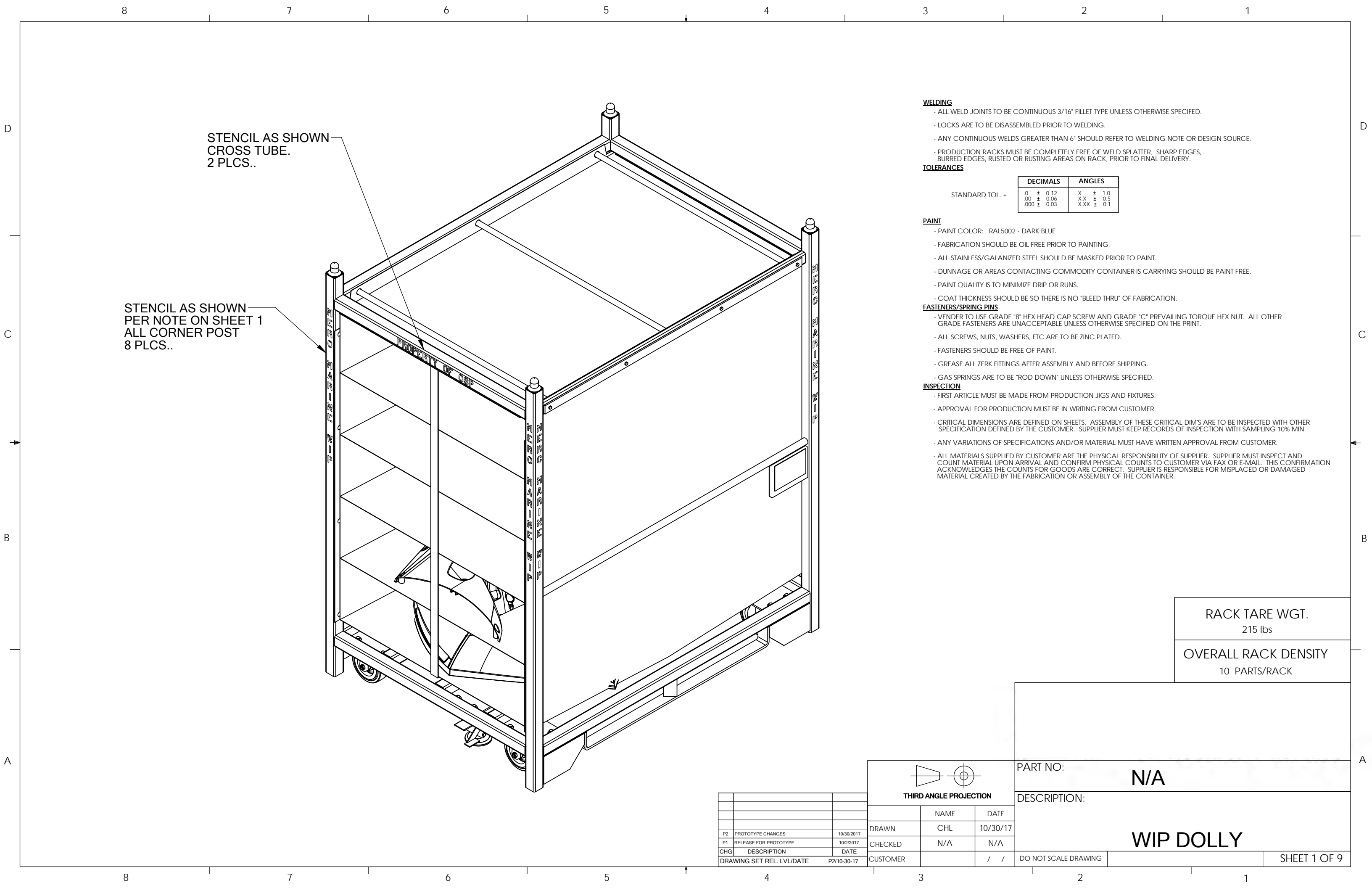
TOLERANCES

STANDARD TOL. ± DECIMALS ANGLES
.0 ± 0.12 X ± 1.0
.00 ± 0.06 X.X ± 0.5
.000 ± 0.03 X.XX ± 0.1

DWG NO	DESCRIPTION
XX-XXX	SIDE OUTER WIP LONG RH (SHOWN)
XX-XXX	SIDE OUTER WIP LONG LH (NOT SHOWN) SYM. AT Ț

DRAWN DS	1/15/16	LONG HOOD WIP		
CHECKED				
QA				
MFG				
APPROVED				
		SIZE B	DWG NO XX-XXX	REV
		SCALE	SHEET 1 OF 15	

CONFIDENTIAL: THIS DRAWING IS PROPERTY OF



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TOLERANCES		DECIMALS	ANGLES
STANDARD TOL. ±	.0	± 0.12	X ± 1.0
	.00	± 0.06	X.X ± 0.5
	.000	± 0.03	X.XX ± 0.1

- PAINT**
- PAINT COLOR: RAL5002 - DARK BLUE
 - FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
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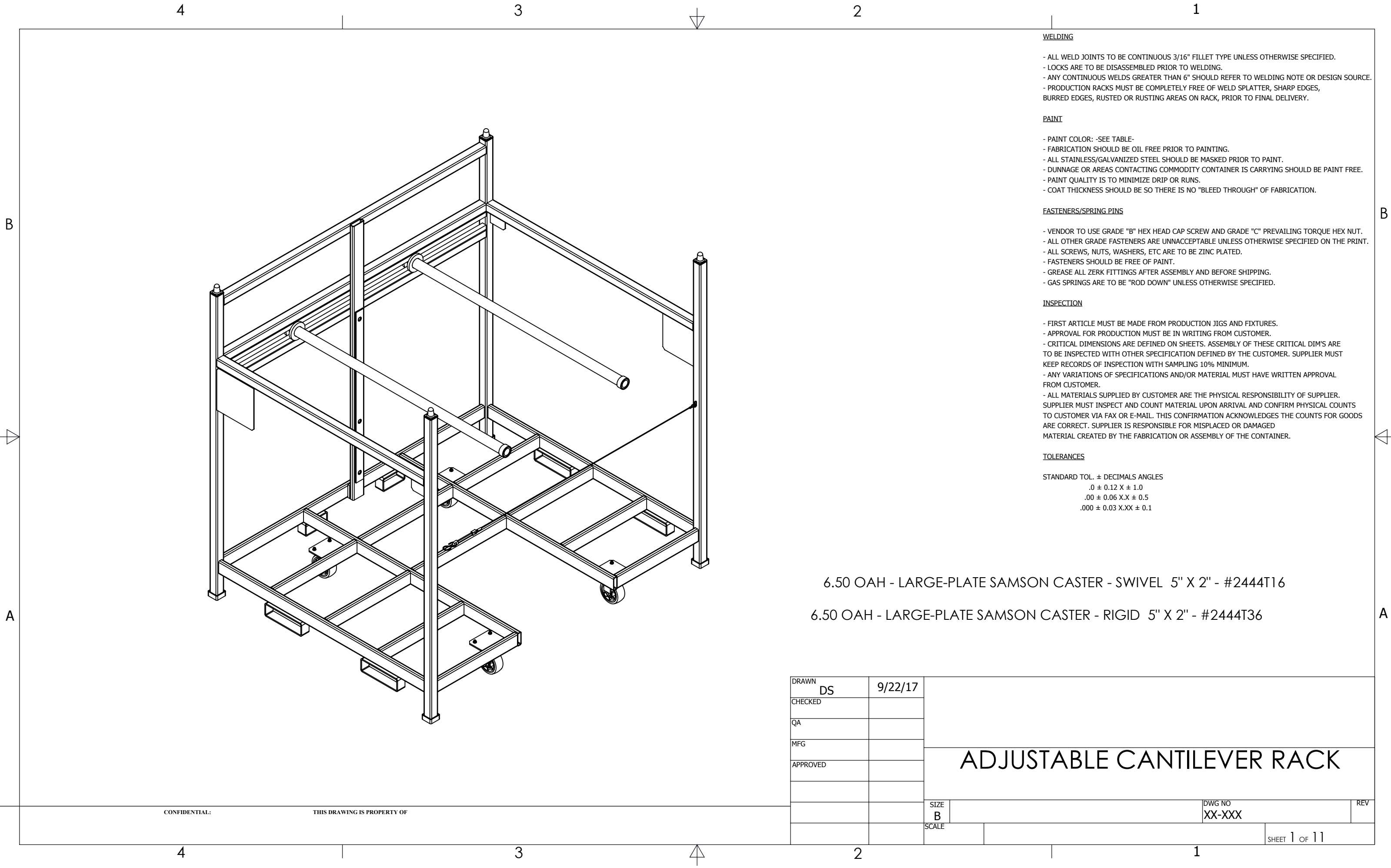
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RACK TARE WGT. 215 lbs
OVERALL RACK DENSITY 10 PARTS/RACK

P2	PROTOTYPE CHANGES	10/30/2017
P1	RELEASE FOR PROTOTYPE	10/2/2017
CHG	DESCRIPTION	DATE
DRAWING SET REL. LVL/DATE		P2/10-30-17

THIRD ANGLE PROJECTION		
	NAME	DATE
DRAWN	CHL	10/30/17
CHECKED	N/A	N/A
CUSTOMER		/ /

PART NO:	N/A
DESCRIPTION:	WIP DOLLY
DO NOT SCALE DRAWING	SHEET 1 OF 9



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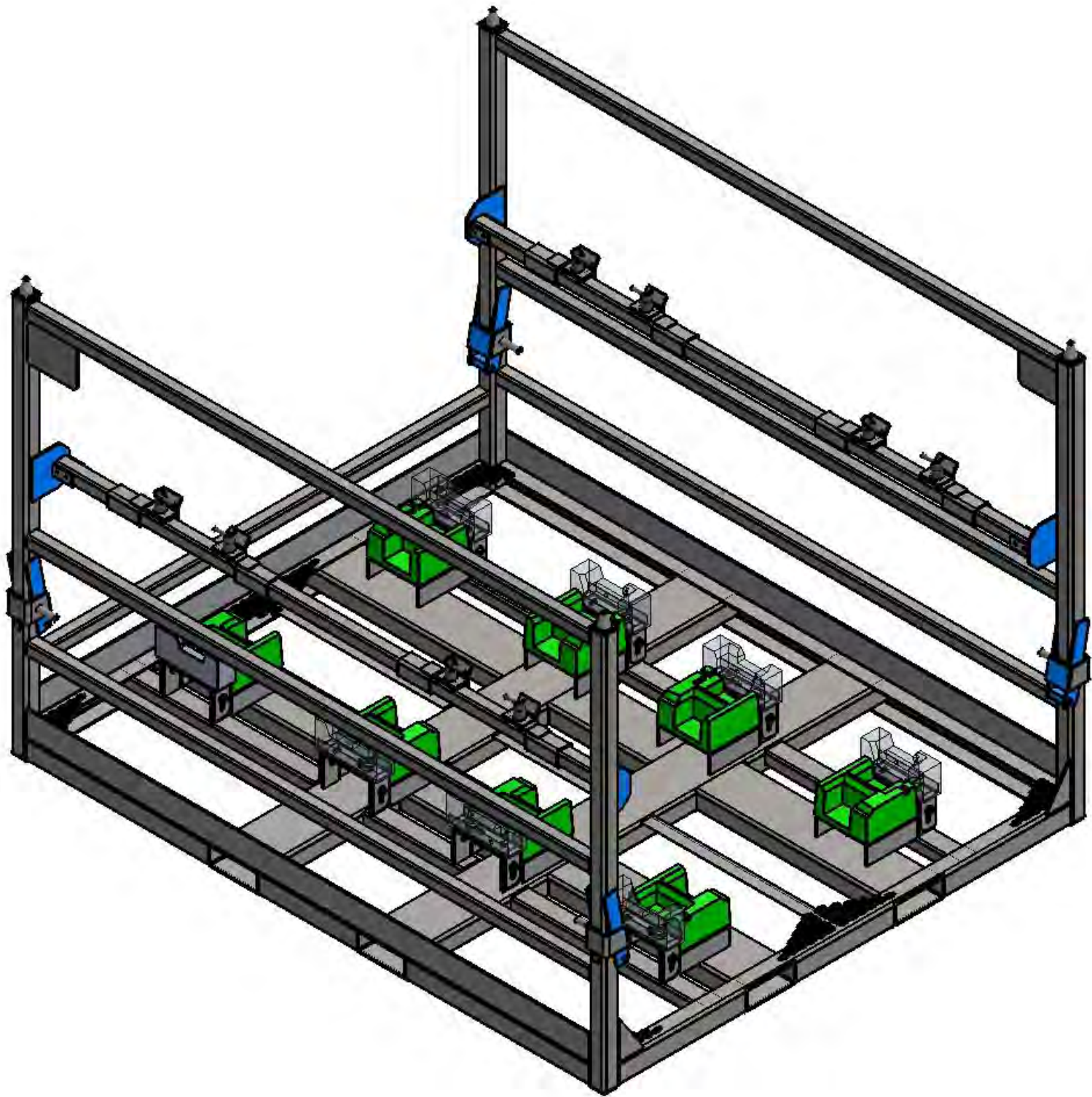
STANDARD TOL. ± DECIMALS ANGLES

- .0 ± 0.12 X ± 1.0
- .00 ± 0.06 X.X ± 0.5
- .000 ± 0.03 X.XX ± 0.1

6.50 OAH - LARGE-PLATE SAMSON CASTER - SWIVEL 5" X 2" - #2444T16

6.50 OAH - LARGE-PLATE SAMSON CASTER - RIGID 5" X 2" - #2444T36

DRAWN	DS	9/22/17	ADJUSTABLE CANTILEVER RACK		
CHECKED					
QA					
MFG					
APPROVED					
			SIZE	DWG NO	REV
			B	XX-XXX	
			SCALE		
			SHEET 1 OF 11		



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TOLERANCES

	DECIMALS	ANGLES
STANDARD TOL. ±	0 ± 0.12 .00 ± 0.06 .000 ± 0.03	X ± 1.0 X.X ± 0.5 X.XX ± 0.1

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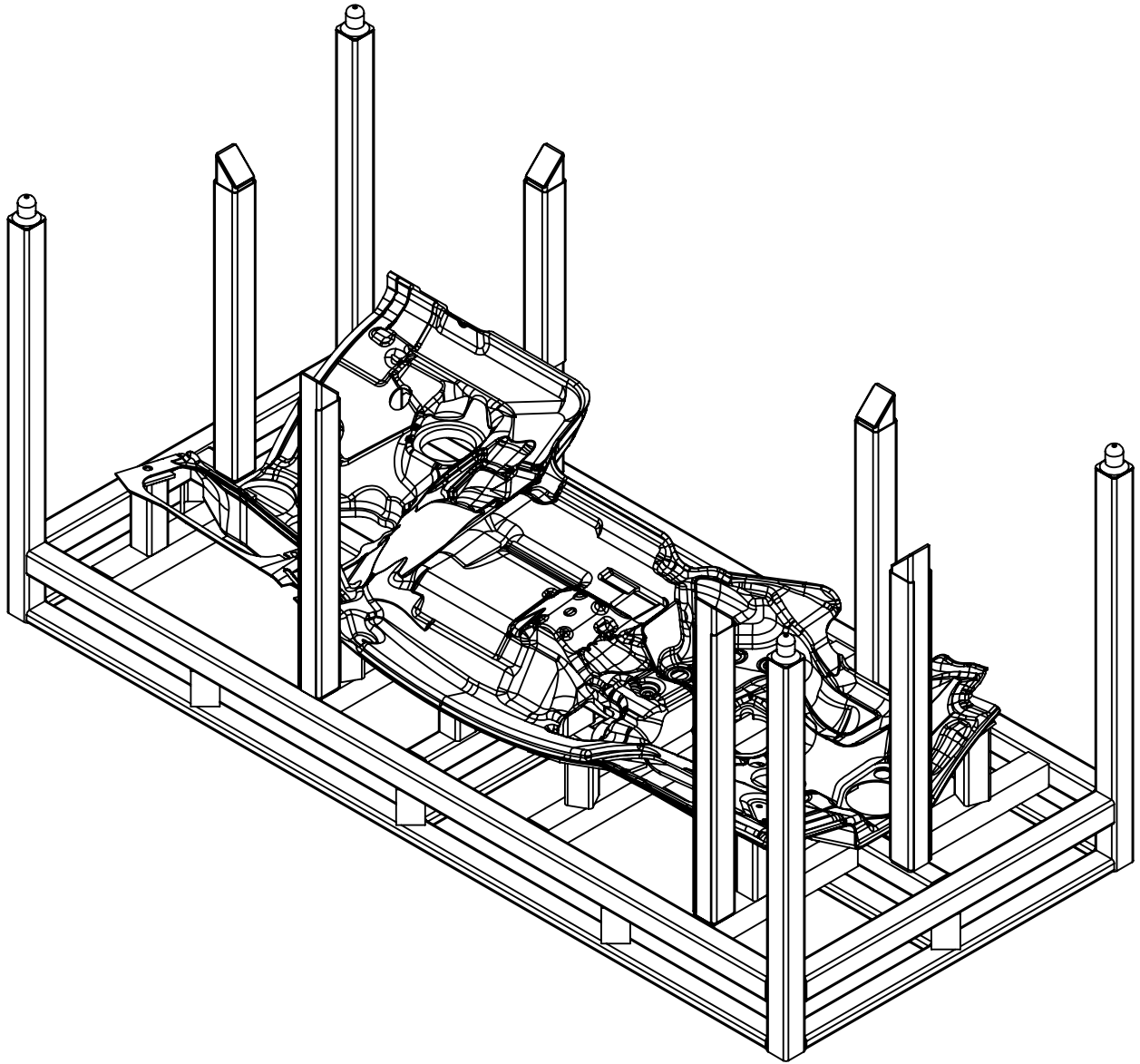
RACK TARE WEIGHT
750 LBS.
OVERALL RACK DENSITY
4 PARTS/RACK

P5	RELEASE FOR BUILD	6/17/2016
CHG	DESCRIPTION	DATE
DRAWING SET REL. LVL/DATE		P5/6-17-16

<div><div>PSS</div><div>PACKAGING SOLUTIONS & SYSTEMS (248) 269-0455 WWW.PSSRACK.COM</div></div>		
	NAME	DATE
DRAWN	CHL	6/17/16
CHECKED	- - -	- - -
CUSTOMER		/ /

<div><div><div></div><div></div></div><div>THIRD ANGLE PROJECTION</div></div>
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES
TOLERANCES: ANGULAR: ± 1 DEG. ONE PLACE DECIMAL ± .12 TWO PLACE DECIMAL ± .06 THREE PLACE DECIMAL ± .03

PART NO: - - -		
DESCRIPTION: <div>ENGINE COOLING MOD SHIPPING RACK</div>		
DO NOT SCALE DRAWING		SHEET 1 OF 21



- WELDING**
- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
 - LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
 - ANY CONTINUOUS WELDS GREATER THAN 6" SHOULD REFER TO WELDING NOTE OR DESIGN SOURCE.
 - PRODUCTION RACKS MUST BE COMPLETELY FREE OF WELD SPLATTER, SHARP EDGES, BURRED EDGES, RUSTED OR RUSTING AREAS ON RACK, PRIOR TO FINAL DELIVERY.

- PAINT**
- PAINT COLOR: -SEE TABLE-
 - FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
 - ALL STAINLESS/GALANIZED STEEL SHOULD BE MASKED PRIOR TO PAINT.
 - DUNNAGE OR AREAS CONTACTING COMMODITY CONTAINER IS CARRYING SHOULD BE PAINT FREE.
 - PAINT QUALITY IS TO MINIMIZE DRIP OR RUNS.
 - COAT THICKNESS SHOULD BE SO THERE IS NO "BLEED THRU" OF FABRICATION.

- INSPECTION**
- FIRST ARTICLE MUST BE MADE FROM PRODUCTION JIGS AND FIXTURES.
 - APPROVAL FOR PRODUCTION MUST BE IN WRITING FROM CUSTOMER.
 - CRITICAL DIMENSIONS ARE DEFINED ON SHEETS. ASSEMBLY OF THESE CRITICAL DIM'S ARE TO BE INSPECTED WITH OTHER SPECIFICATION DEFINED BY THE CUSTOMER. SUPPLIER MUST KEEP RECORDS OF INSPECTION WITH SAMPLING 10% MINI.
 - ANY VARIATIONS OF SPECIFICATIONS AND/OR MATERIAL MUST HAVE WRITTEN APPROVAL FROM GESTAMP.
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STANDARD TOL. ±	DECIMALS	ANGLES
	.0 ± 0.12	X ± 1.0
	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

Estimated Weight: 260lbs

PSS

PACKAGING SOLUTIONS & SYSTEMS
(248) 269-0455
WWW.PSSRACK.COM

DATE

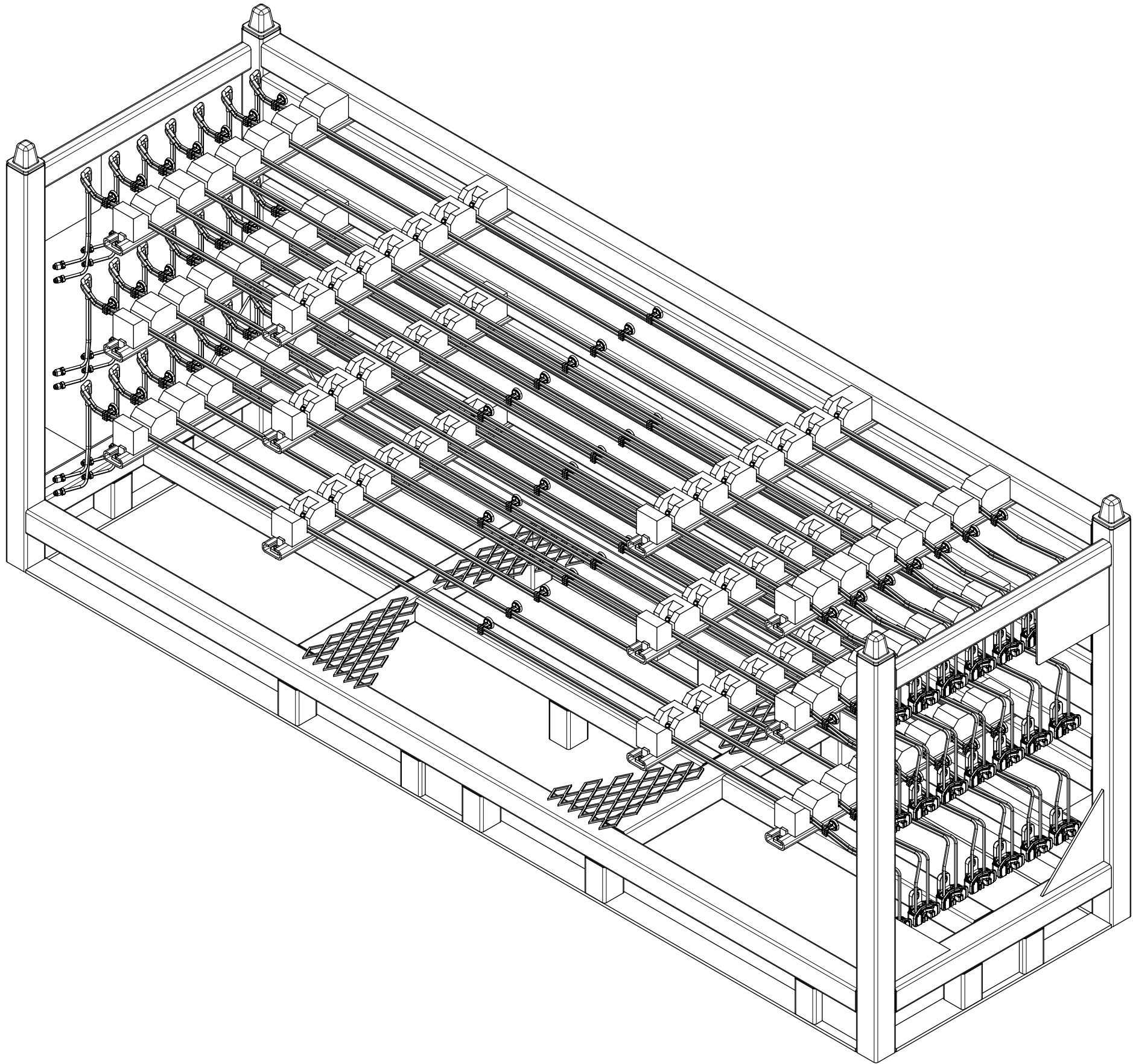
10/13/17

THIRD ANGLE PROJECTION

3RD ANGLE PROJ DIMENSIONS ARE IN INCHES

PART MUST COMPLY WITH MATERIAL SPECIFICATION WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT

CUSTOMER	REF FILE #:		
HP PELZER	SHIPPING RACK DESIGN		
DESIGN	PART NAME		
PSS	DIESEL CARPET		
ENGINEER	PART NUMBER	REV	
CMM	XXXXXXXXXXXXXX	000	SHOWN
SCALE	DIVISION	AUTOMOTIVE	
N/A	PLANT	SHEET 1 OF 17	



WELDING

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FASTENERS/SPRING PINS

- VENDER TO USE GRADE "8" HEX HEAD CAP SCREW AND GRADE "C" PREVAILING TORQUE HEX NUT.
- ALL OTHER GRADE FASTENERS ARE UNACCEPTABLE UNLESS OTHERWISE SPECIFIED ON THE PRINT.
- ALL SCREWS, NUTS, WASHERS, ETC ARE TO BE ZINC PLATED.
- FASTENERS SHOULD BE FREE OF PAINT.
- GREASE ALL ZERK FITTINGS AFTER ASSEMBLY AND BEFORE SHIPPING.
- GAS SPRINGS ARE TO BE "ROD DOWN" UNLESS OTHERWISE SPECIFIED.

INSPECTION

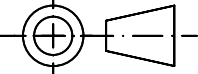
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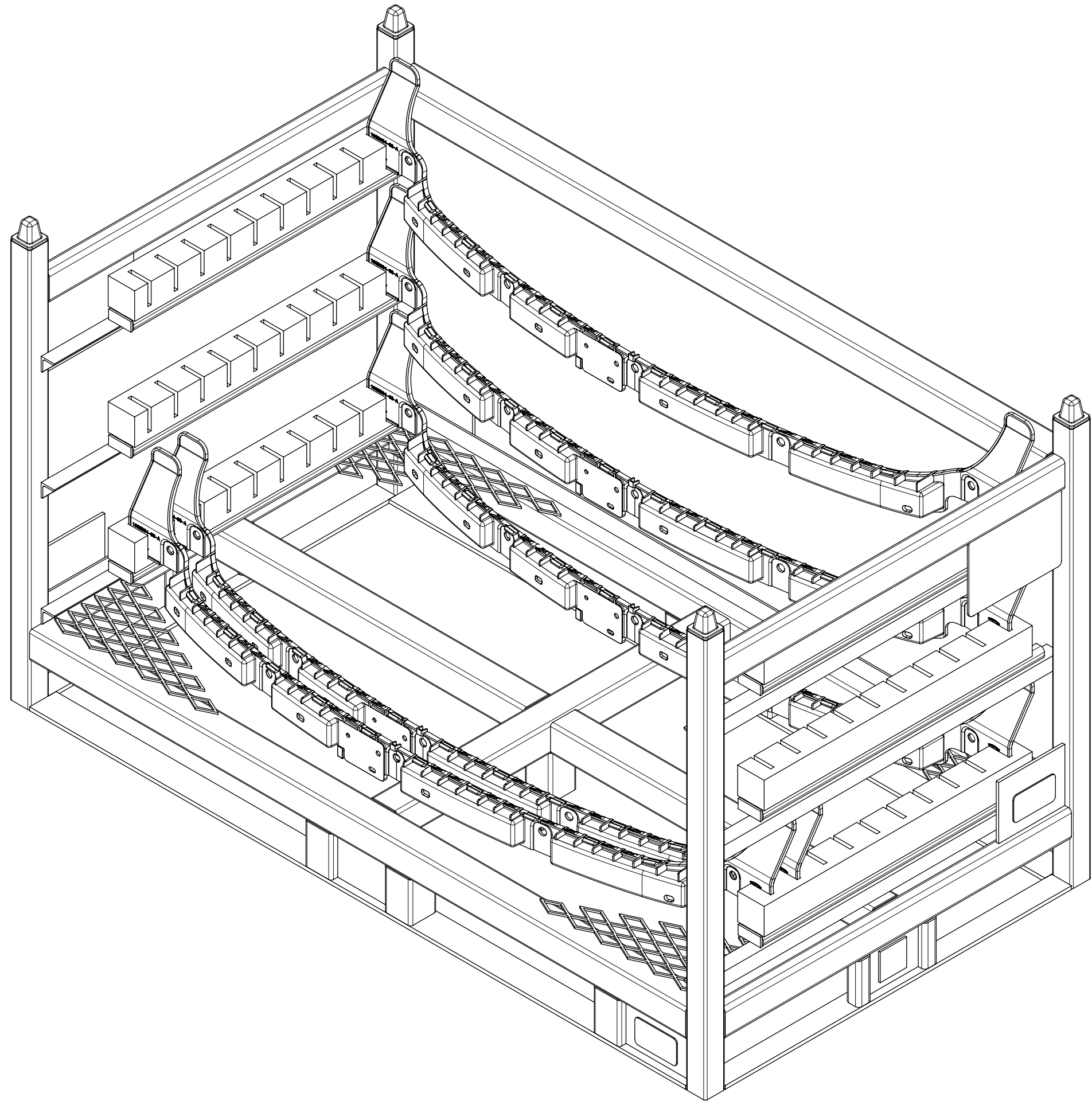
TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
	.0 ± 0.12	X ± 1.0
	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

SHIPPING RACK DESIGN
UNDERBODY BRAKE BUNDLE
PART # 1044713-00-B
RACK SIZE (MM) - 2160 X 635 X 900
RACK SIZE (INCHES) - 85.04 X 25.00 X 35.43
PART DENSITY = 21
RACK COLOR = POWDER COATED WHITE W/ BLACK STENCILS
GRIND DOWN ALL SHARP EDGES
ALL WELDS ON OUTER SURFACES GROUND FLUSH
RED SHADOW AROUND ALL FORK OPENINGS



		3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETERS	
PART MUST COMPLY WITH MATERIAL SPECIFICATION WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT			
CUSTOMER	REF FILE #: SHIPPING RACK DESIGN		
DESIGN PSS	PART NAME UNDERBODY BRAKE BUNDLE		
ENGINEER PSS	PART NUMBER	REV 004	SHOWN
SCALE N/A	DIVISION AUTOMOTIVE		SHT 1
	PLANT		OF 1 1



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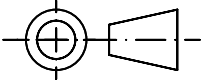
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STANDARD TOL.	± DECIMALS	ANGLES
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	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

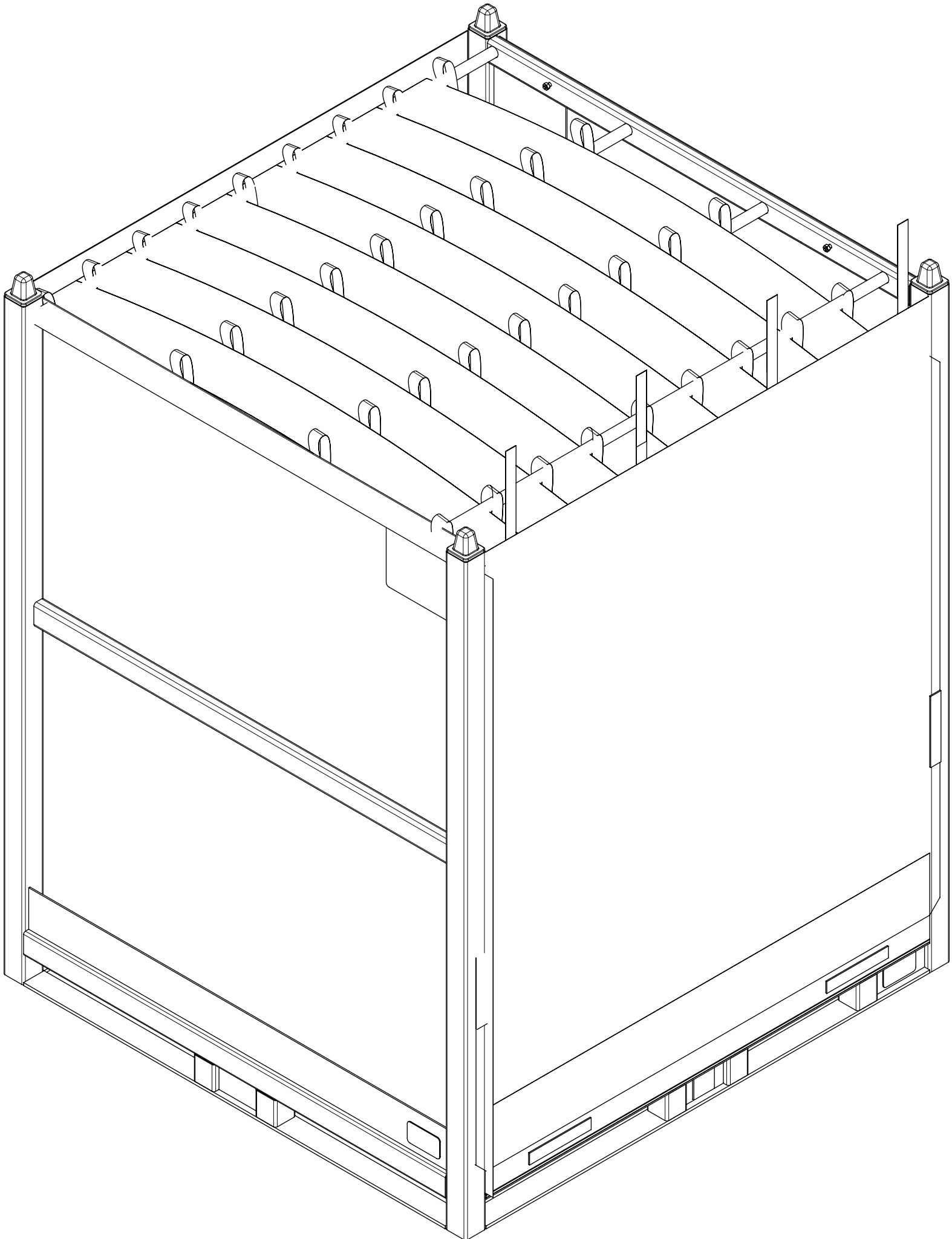
CENTER FASCIA BRACKET
PART # 1083994
RACK SIZE (MM) - 1335 X 740 X 800
RACK SIZE (INCHES) - 52.56 X 29.15 X 31.50
(30) PARTS PER RACK
EMPTY RACK WEIGHT = 215 POUNDS
FULL RACK WEIGHT = 258 POUNDS
RACK COLOR = POWDER COATED WHITE W/ BLACK STENCILS
GRIND DOWN ALL SHARP EDGES
ALL WELDS ON OUTER SURFACES GROUND FLUSH
RED SHADOW AROUND ALL FORK OPENINGS



3RD ANGLE PROJ DIMENSIONS
ARE IN MILLIMETERS

PART MUST COMPLY WITH MATERIAL SPECIFICATION
WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH,
SAFETY AND THE ENVIRONMENT

CUSTOMER	REF FILE #:		
	SHIPPING RACK DESIGN		
DESIGN PSS	PART NAME CENTER FASCIA BRACKET		
ENGINEER PSS	PART NUMBER	REV 009	SHOWN
SCALE N/A	DIVISION AUTOMOTIVE	PLANT	SHT 1 OF 12



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INSPECTION

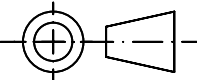
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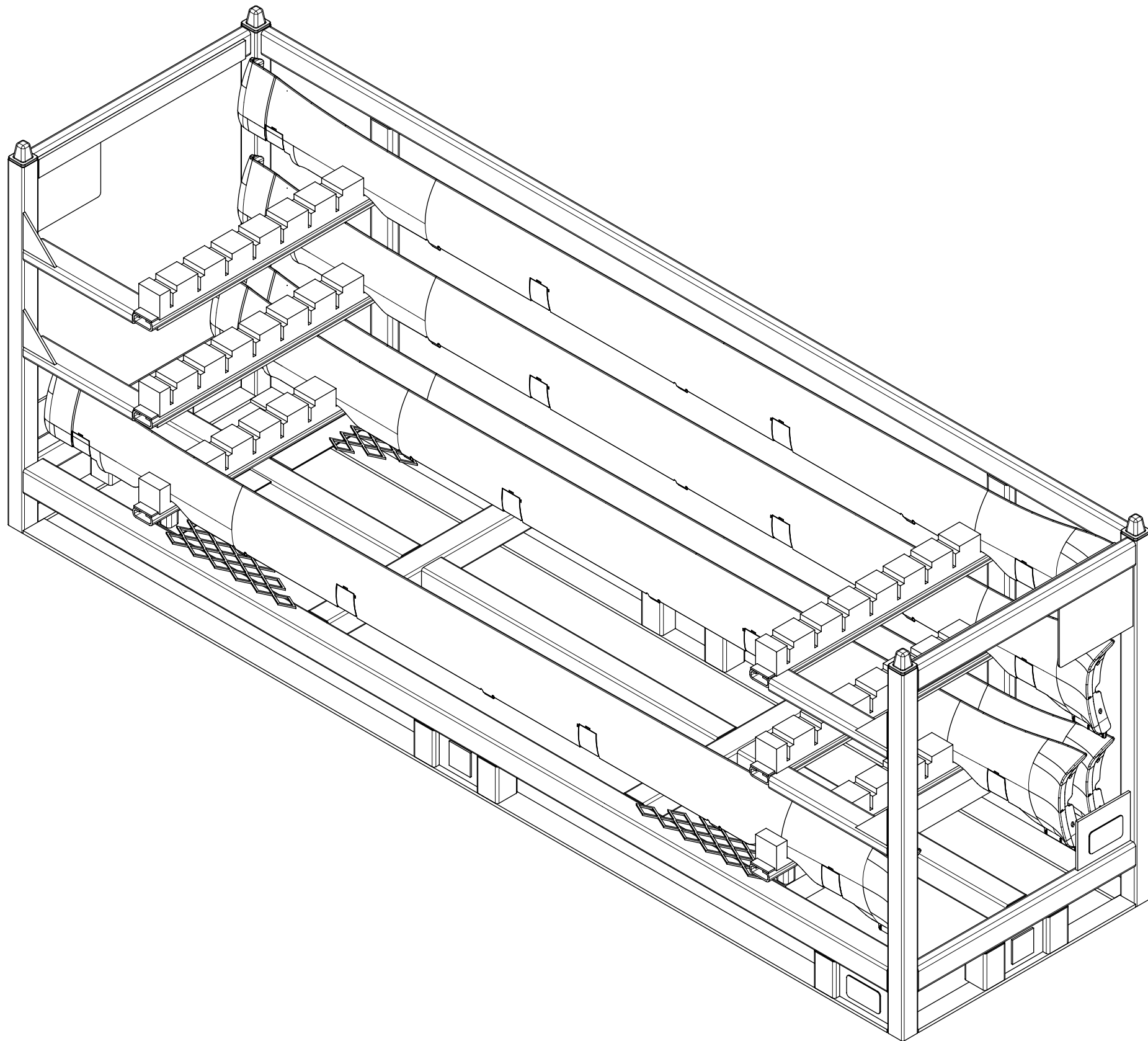
TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
	.0 ± 0.12	X ± 1.0
	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

HEADLINER ASSY PICKUP BASE
PART # 1084617
RACK SIZE (INCHES) - 45.08 X 47.2 X 59.06
RACK SIZE (MM) - 1145 X 1200 X 1500
PARTS PER RACK = 5
EMPTY RACK WEIGHT = 349 POUNDS
FULL RACK WEIGHT = 354 POUNDS
RACK COLOR = POWDER COATED WHITE W/ BLACK STENCILS
GRIND DOWN ALL SHARP EDGES
ALL WELDS ON OUTER SURFACES GROUND FLUSH
RED SHADOW AROUND ALL FORK OPENINGS



		3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETERS	
PART MUST COMPLY WITH MATERIAL SPECIFICATION WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT			
CUSTOMER	REF FILE #: SHIPPING RACK DESIGN		
DESIGN PSS	PART NAME HEADLINER ASSY		
ENGINEER PSS	PART NUMBER	REV 016	SHOWN
SCALE N/A	DIVISION AUTOMOTIVE	SHT 1	
	PLANT	OF 14	



WELDING

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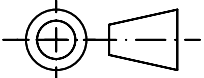
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STANDARD TOL.	± DECIMALS	ANGLES
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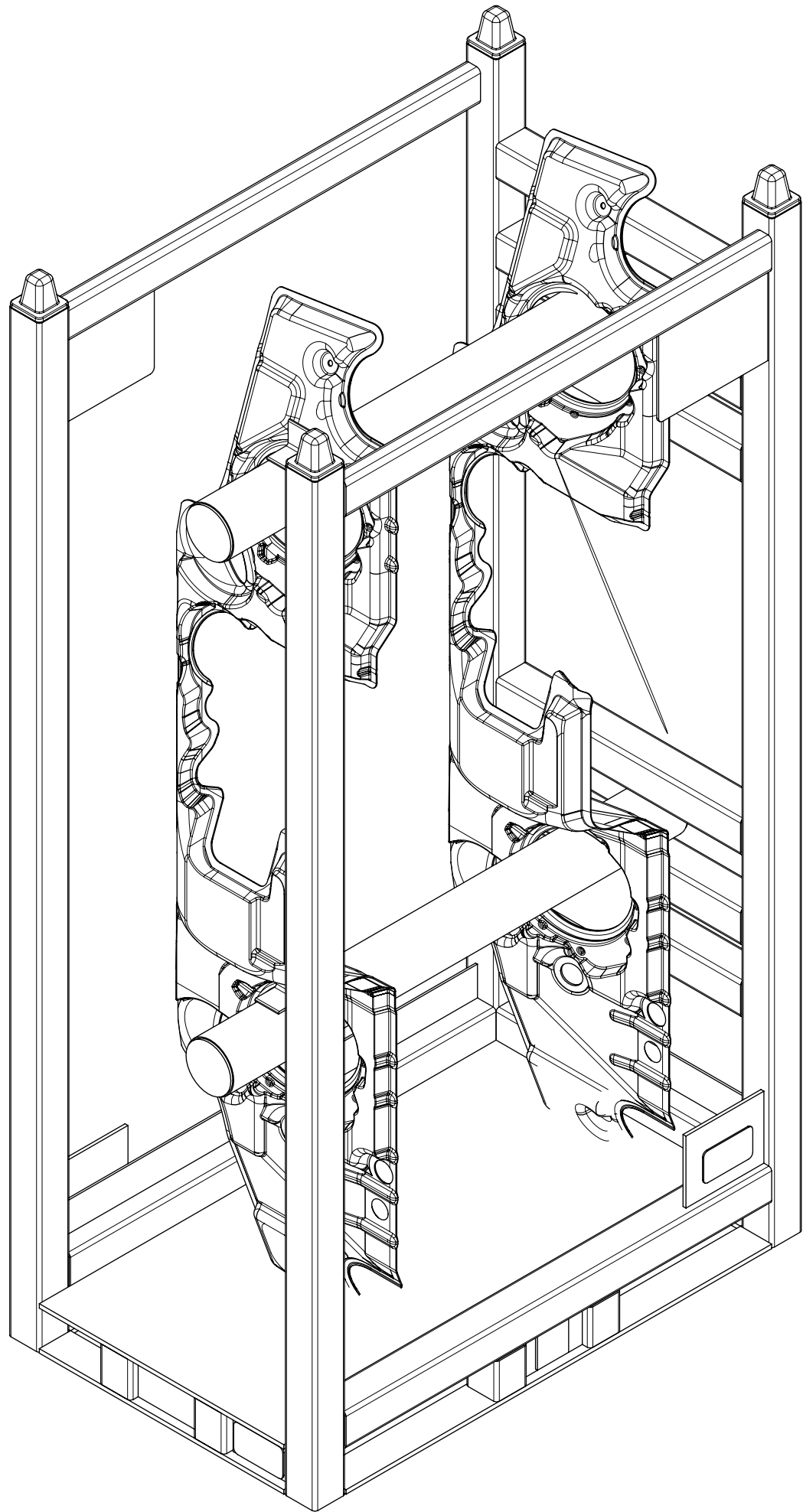
ROCKER MOLDING LH SHOWN - PART # 1089828
ROCKER MOLDING RH OPPOSITE - PART # 1089829
RACK SIZE - 2161 X 600 X 800 (MM)
RACK SIZE - 85.08 X 23.62 X 31.50 (INCHES)
(24) PARTS PER RACK
EMPTY RACK WEIGHT = 295 POUNDS
FULL RACK WEIGHT = 350 POUNDS
RACK COLOR = POWDER COATED WHITE W/ BLACK STENCILS
GRIND DOWN ALL SHARP EDGES
ALL WELDS ON OUTER SURFACES GROUND FLUSH
RED SHADOW AROUND ALL FORK OPENINGS



3RD ANGLE PROJ DIMENSIONS
ARE IN MILLIMETERS

PART MUST COMPLY WITH MATERIAL SPECIFICATION
WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH,
SAFETY AND THE ENVIRONMENT

CUSTOMER	REF FILE #: SHIPPING RACK DESIGN		
DESIGN PSS	PART NAME ROCKER MOLDING RH & LH		
ENGINEER PSS	PART NUMBER	REV 010	SHOWN
SCALE N/A	DIVISION AUTOMOTIVE	PLANT	SHT 1 OF 12



WELDING

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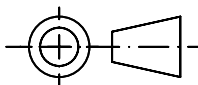
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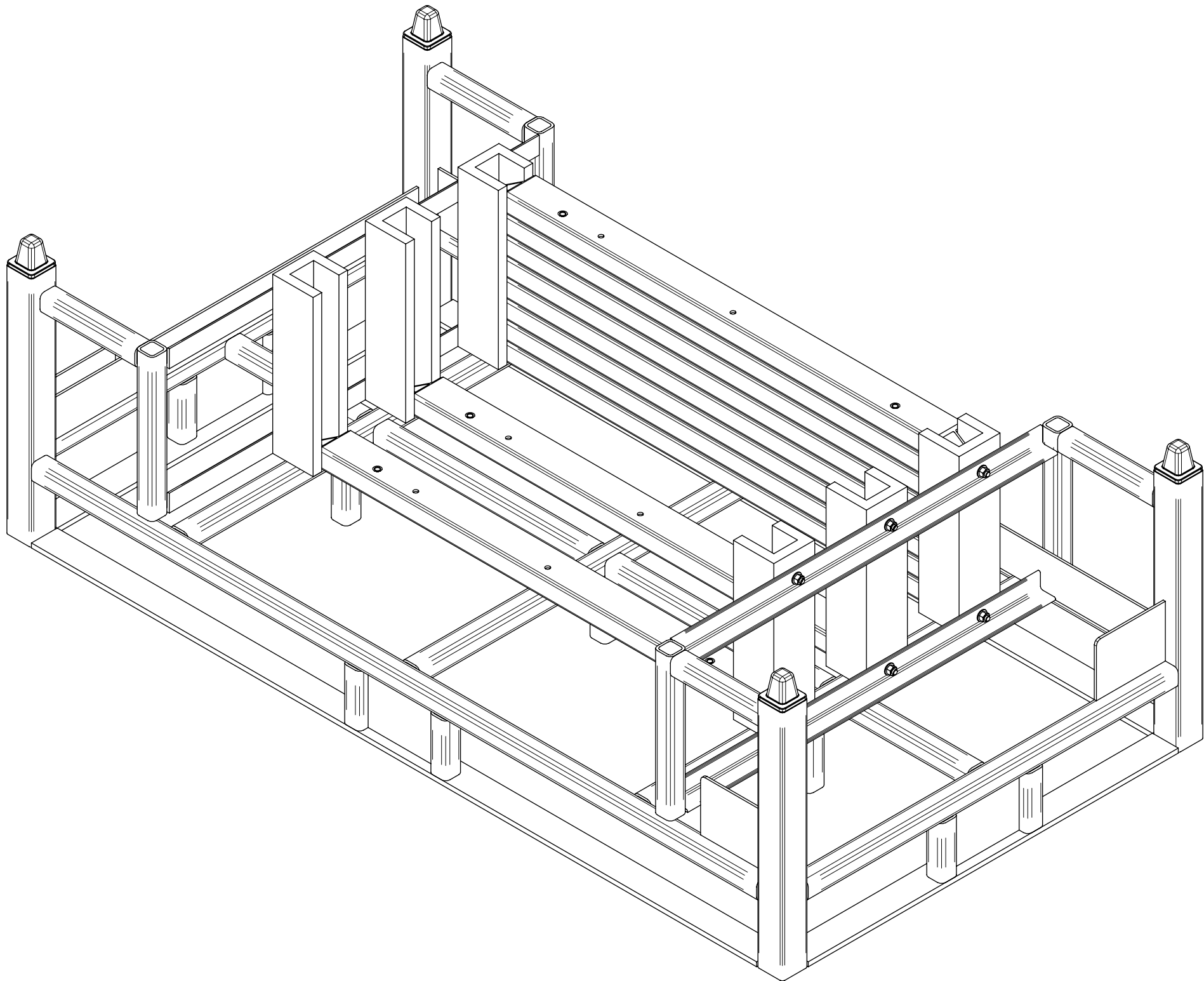
TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
	.0 ± 0.12	X ± 1.0
	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

NOISE ABSORBER
PART # 1090677
RACK SIZE (INCHES) - 19.68 X 31.3 X 59.05
RACK SIZE (MM) - 500 X 795 X 1500
RACK DENSITY TBD
EMPTY RACK WEIGHT = 246 POUNDS
RACK COLOR = POWDER COATED WHITE W/ BLACK STENCILS
GRIND DOWN ALL SHARP EDGES
ALL WELDS ON OUTER SURFACES GROUND FLUSH
RED SHADOW AROUND ALL FORK OPENINGS



 3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETERS			
PART MUST COMPLY WITH MATERIAL SPECIFICATION WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT			
CUSTOMER	REF FILE #: SHIPPING RACK DESIGN		
DESIGN PSS	PART NAME NOISE ABSORBER		
ENGINEER PSS	PART NUMBER	REV 010	SHOWN
SCALE N/A	DIVISION AUTOMOTIVE	SHT 1 OF 9	
	PLANT		



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- CRITICAL DIMENSIONS ARE DEFINED ON SHEETS. ASSEMBLY OF THESE CRITICAL DIM'S ARE TO BE INSPECTED WITH OTHER SPECIFICATION DEFINED BY THE CUSTOMER. SUPPLIER MUST KEEP RECORDS OF INSPECTION WITH SAMPLING 10% MINIMUM.
- ANY VARIATIONS OF SPECIFICATIONS AND/OR MATERIAL MUST HAVE WRITTEN APPROVAL FROM CUSTOMER.
- ALL MATERIALS SUPPLIED BY CUSTOMER ARE THE PHYSICAL RESPONSIBILITY OF SUPPLIER. SUPPLIER MUST INSPECT AND COUNT MATERIAL UPON ARRIVAL AND CONFIRM PHYSICAL COUNTS TO CUSTOMER VIA FAX OR E-MAIL. THIS CONFIRMATION ACKNOWLEDGES THE COUNTS FOR GOODS ARE CORRECT. SUPPLIER IS RESPONSIBLE FOR MISPLACED OR DAMAGED MATERIAL CREATED BY THE FABRICATION OR ASSEMBLY OF THE CONTAINER.

TOLERANCES

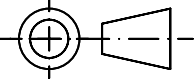
STANDARD TOL. ±	DECIMALS	ANGLES
	.0 ± 0.12	X ± 1.0
	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

RACK SIZE = 1145 MM X 622 MM X 378 MM
RACK SIZE = 45.08" X 24.47" X 14.9"

(24) PARTS PER RACK
EMPTY RACK WEIGHT = 44 POUNDS
FULL RACK WEIGHT = 54 POUNDS
RACK COLOR = POWDER COATED WHITE
W/ BLACK STENCILS

GRIND DOWN ALL SHARP EDGES
ALL WELDS ON OUTER SURFACES GROUND FLUSH
RED SHADOW AROUND ALL FORK OPENINGS

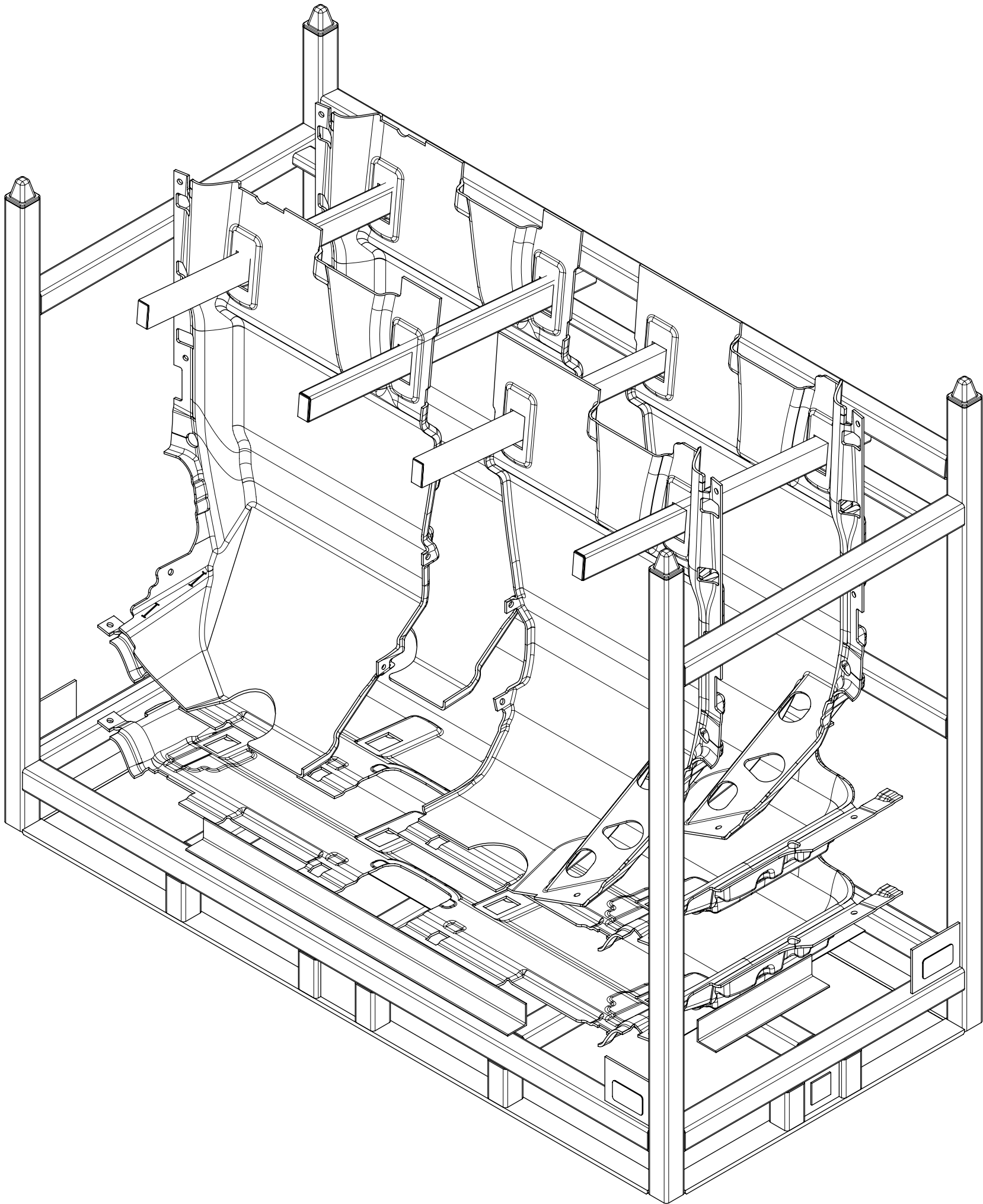




3RD ANGLE PROJ DIMENSIONS
ARE IN MILLIMETERS

PART MUST COMPLY WITH MATERIAL SPECIFICATION
WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH,
SAFETY AND THE ENVIRONMENT

CUSTOMER	REF FILE #:		
SHIPPING RACK DESIGN			
DESIGN PSS	PART NAME FRUNK REINF BEAM		
ENGINEER PSS	PART NUMBER	REV 017	SHOWN
SCALE N/A	DIVISION AUTOMOTIVE	SHT 1	
	PLANT	OF 9	



WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
- LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
- ANY CONTINUOUS WELDS GREATER THAN 6" SHOULD REFER TO WELDING NOTE OR DESIGN SOURCE.
- PRODUCTION RACKS MUST BE COMPLETELY FREE OF WELD SPLATTER, SHARP EDGES, BURRED EDGES, RUSTED OR RUSTING AREAS ON RACK, PRIOR TO FINAL DELIVERY.

PAINT

- PAINT COLOR: -SEE TABLE-
- FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
- ALL STAINLESS/GALANIZED STEEL SHOULD BE MASKED PRIOR TO PAINT.
- DUNNAGE OR AREAS CONTACTING COMMODITY CONTAINER IS CARRYING SHOULD BE PAINT FREE.
- PAINT QUALITY IS TO MINIMIZE DRIP OR RUNS.
- COAT THICKNESS SHOULD BE SO THERE IS NO "BLEED THRU" OF FABRICATION.

FASTENERS/SPRING PINS

- VENDER TO USE GRADE "8" HEX HEAD CAP SCREW AND GRADE "C" PREVAILING TORQUE HEX NUT.
- ALL OTHER GRADE FASTENERS ARE UNACCEPTABLE UNLESS OTHERWISE SPECIFIED ON THE PRINT.
- ALL SCREWS, NUTS, WASHERS, ETC ARE TO BE ZINC PLATED.
- FASTENERS SHOULD BE FREE OF PAINT.
- GREASE ALL ZERK FITTINGS AFTER ASSEMBLY AND BEFORE SHIPPING.
- GAS SPRINGS ARE TO BE "ROD DOWN" UNLESS OTHERWISE SPECIFIED.

INSPECTION

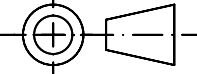
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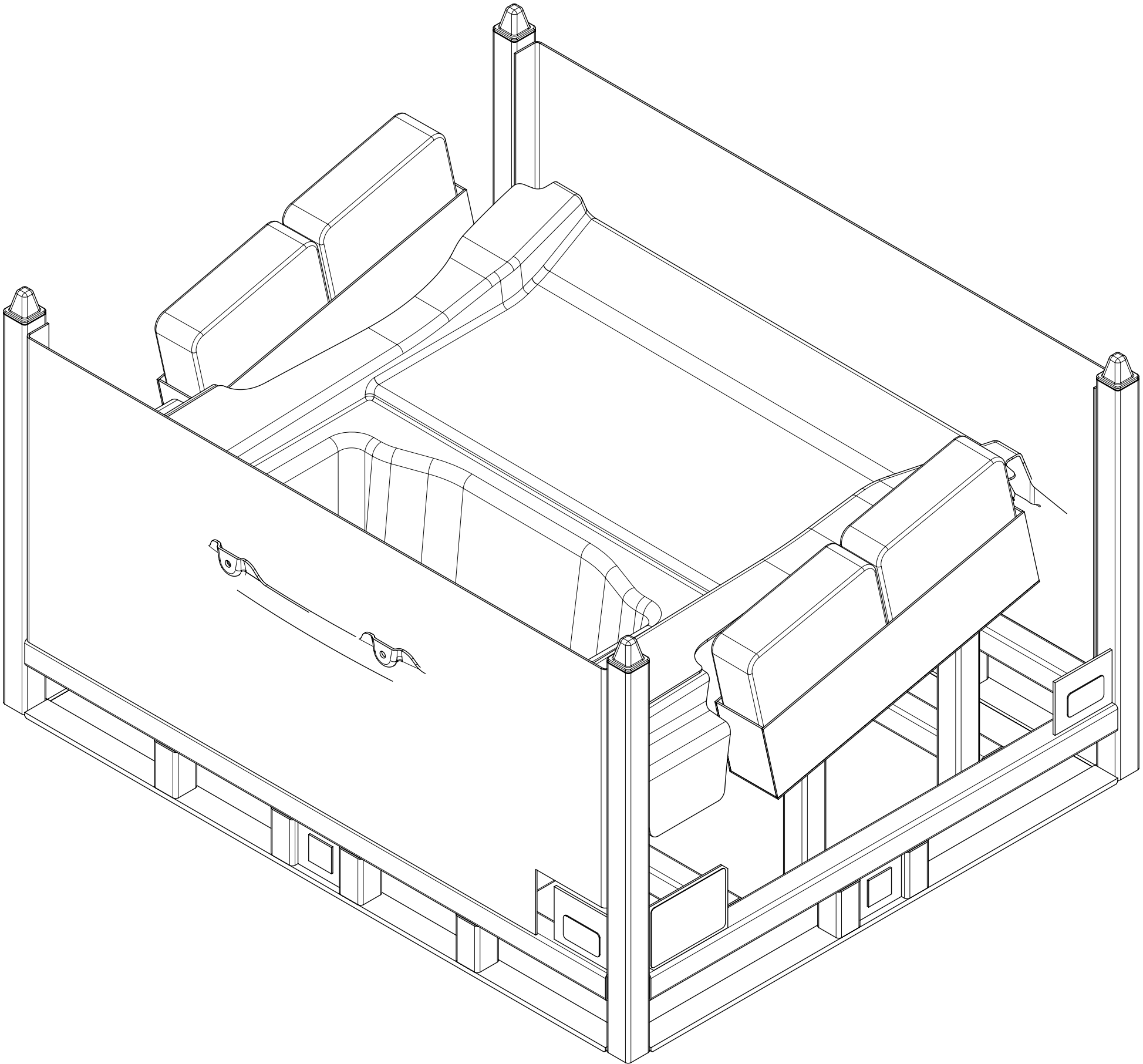
TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
	.0 ± 0.12	X ± 1.0
	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

RACK SIZE = 70"X 33.48"X 58.88"
RACK SIZE (MM) = 1778 X 850 X 1485
(6) PARTS PER RACK
EMPTY RACK WEIGHT = 400 POUNDS
RACK COLOR = POWDER COATED WHITE W/ BLACK STENCILS
GRIND DOWN ALL SHARP EDGES
ALL WELDS ON OUTER SURFACES GROUND FLUSH
RED SHADOW AROUND ALL FORK OPENINGS



		3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETERS	
PART MUST COMPLY WITH MATERIAL SPECIFICATION WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT			
CUSTOMER	REF FILE #: SHIPPING RACK DESIGN		
DESIGN PSS	PART NAME MAIN CABIN CARPET		
ENGINEER PSS	PART NUMBER		REV 009
SCALE N/A	DIVISION AUTOMOTIVE		SHOWN SHT 1 OF 9
	PLANT		



WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
- LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
- ANY CONTINUOUS WELDS GREATER THAN 6" SHOULD REFER TO WELDING NOTE OR DESIGN SOURCE.
- PRODUCTION RACKS MUST BE COMPLETELY FREE OF WELD SPLATTER, SHARP EDGES, BURRED EDGES, RUSTED OR RUSTING AREAS ON RACK, PRIOR TO FINAL DELIVERY.

PAINT

- PAINT COLOR: -SEE TABLE-
- FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
- ALL STAINLESS/GALANIZED STEEL SHOULD BE MASKED PRIOR TO PAINT.
- DUNNAGE OR AREAS CONTACTING COMMODITY CONTAINER IS CARRYING SHOULD BE PAINT FREE.
- PAINT QUALITY IS TO MINIMIZE DRIP OR RUNS.
- COAT THICKNESS SHOULD BE SO THERE IS NO "BLEED THRU" OF FABRICATION.

FASTENERS/SPRING PINS

- VENDER TO USE GRADE "8" HEX HEAD CAP SCREW AND GRADE "C" PREVAILING TORQUE HEX NUT.
- ALL OTHER GRADE FASTENERS ARE UNACCEPTABLE UNLESS OTHERWISE SPECIFIED ON THE PRINT.
- ALL SCREWS, NUTS, WASHERS, ETC ARE TO BE ZINC PLATED.
- FASTENERS SHOULD BE FREE OF PAINT.
- GREASE ALL ZERK FITTINGS AFTER ASSEMBLY AND BEFORE SHIPPING.
- GAS SPRINGS ARE TO BE "ROD DOWN" UNLESS OTHERWISE SPECIFIED.

INSPECTION

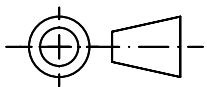
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TOLERANCES

STANDARD TOL.	± DECIMALS	ANGLES
	.0 ± 0.12	X ± 1.0
	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

RACK SIZE = 55"X 45"X 31.50"
RACK SIZE (MM) = 1397 X 1143 X 800
(4) PARTS PER RACK
EMPTY RACK WEIGHT = 400 POUNDS
RACK COLOR = POWDER COATED WHITE W/ BLACK STENCILS
GRIND DOWN ALL SHARP EDGES
ALL WELDS ON OUTER SURFACES GROUND FLUSH
RED SHADOW AROUND ALL FORK OPENINGS

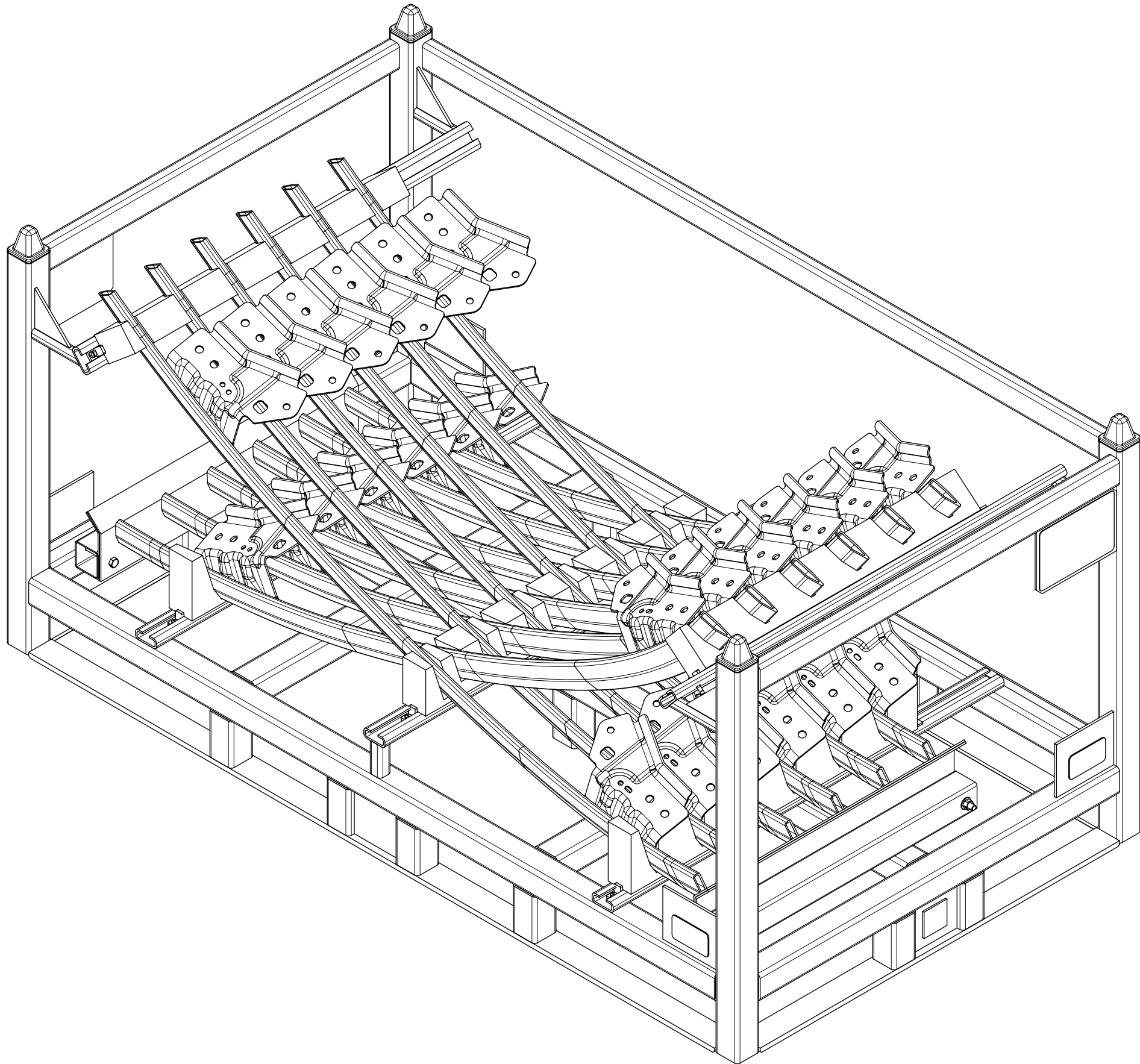




3RD ANGLE PROJ DIMENSIONS
ARE IN MILLIMETERS

PART MUST COMPLY WITH MATERIAL SPECIFICATION
WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH,
SAFETY AND THE ENVIRONMENT

CUSTOMER	REF FILE #: SHIPPING RACK DESIGN		
DESIGN PSS	PART NAME TRUNK CARPET		
ENGINEER PSS	PART NUMBER	REV 009	SHOWN
SCALE N/A	DIVISION AUTOMOTIVE	SHT 1 OF 10	
	PLANT		



WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
- LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
- ANY CONTINUOUS WELDS GREATER THAN 6" SHOULD REFER TO WELDING NOTE OR DESIGN SOURCE.
- PRODUCTION RACKS MUST BE COMPLETELY FREE OF WELD SPLATTER, SHARP EDGES, BURRED EDGES, RUSTED OR RUSTING AREAS ON RACK, PRIOR TO FINAL DELIVERY.

PAINT

- PAINT COLOR: -SEE TABLE-
- FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
- ALL STAINLESS/GALANIZED STEEL SHOULD BE MASKED PRIOR TO PAINT.
- DUNNAGE OR AREAS CONTACTING COMMODITY CONTAINER IS CARRYING SHOULD BE PAINT FREE.
- PAINT QUALITY IS TO MINIMIZE DRIP OR RUNS.
- COAT THICKNESS SHOULD BE SO THERE IS NO "BLEED THRU" OF FABRICATION.

FASTENERS/SPRING PINS

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- FASTENERS SHOULD BE FREE OF PAINT.
- GREASE ALL ZERK FITTINGS AFTER ASSEMBLY AND BEFORE SHIPPING.
- GAS SPRINGS ARE TO BE "ROD DOWN" UNLESS OTHERWISE SPECIFIED.

INSPECTION

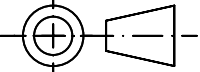
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TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
.0	± 0.12	X ± 1.0
.00	± 0.06	X.X ± 0.5
.000	± 0.03	X.XX ± 0.1

RACK SIZE = 63.88" X 35.38" X 31.44"
RACK SIZE (MM) = 1622 X 899 X 799
(15) PARTS PER RACK
EMPTY RACK WEIGHT = 315 POUNDS
RACK COLOR = POWDER COATED WHITE W/ BLACK STENCILS
GRIND DOWN ALL SHARP EDGES
ALL WELDS ON OUTER SURFACES GROUND FLUSH
RED SHADOW AROUND ALL FORK OPENINGS

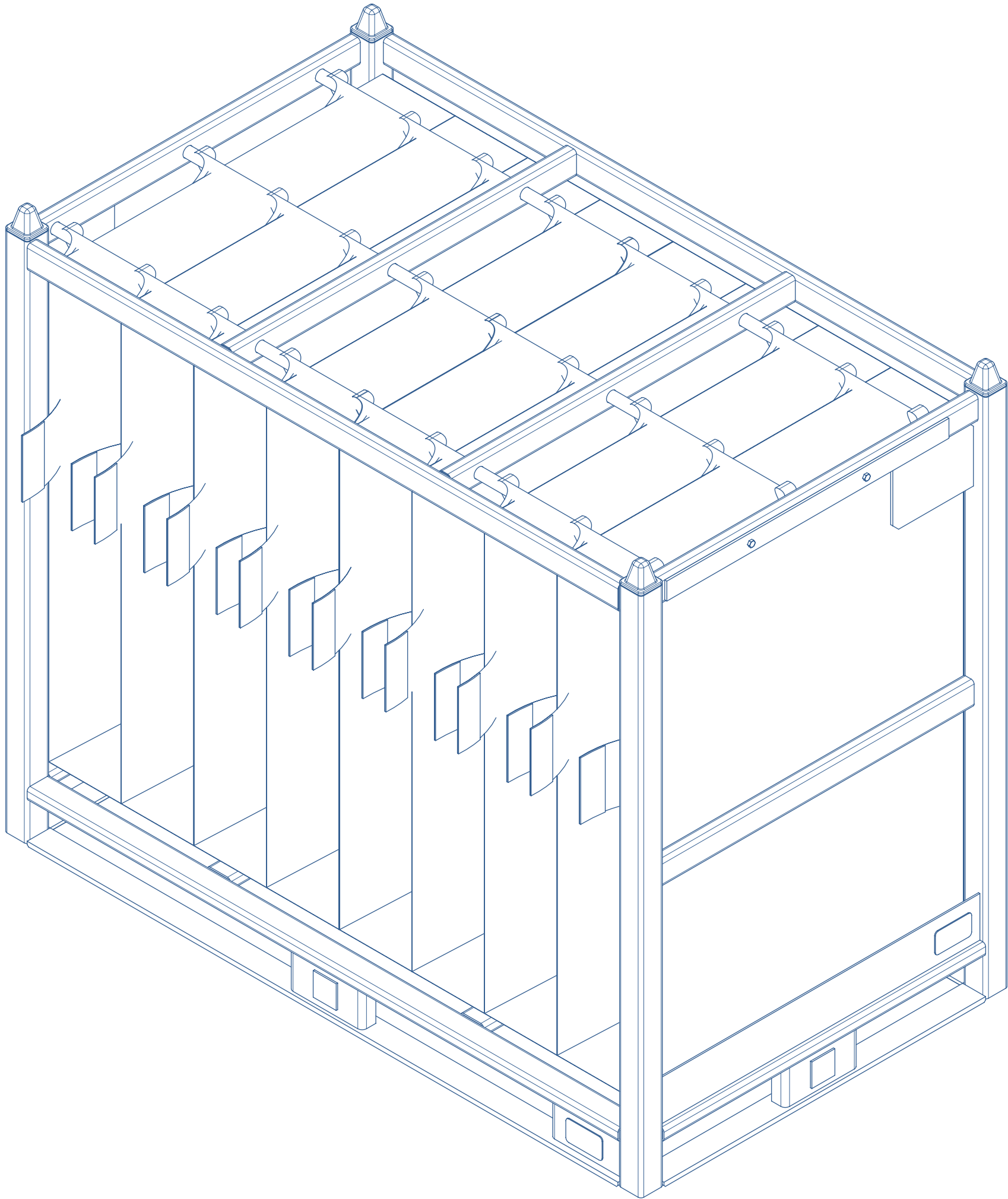




3RD ANGLE PROJ DIMENSIONS
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WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH,
SAFETY AND THE ENVIRONMENT

CUSTOMER	REF FILE #:		
	SHIPPING RACK DESIGN		
DESIGN PSS	PART NAME		
	ANKLE CATCHER		
ENGINEER PSS	PART NUMBER	REV	
		008	SHOWN
SCALE N/A	DIVISION	AUTOMOTIVE	SHT 1
	PLANT		OF 13



WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
- LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
- ANY CONTINUOUS WELDS GREATER THAN 6" SHOULD REFER TO WELDING NOTE OR DESIGN SOURCE.
- PRODUCTION RACKS MUST BE COMPLETELY FREE OF WELD SPLATTER, SHARP EDGES, BURRED EDGES, RUSTED OR RUSTING AREAS ON RACK, PRIOR TO FINAL DELIVERY.

PAINT

- PAINT COLOR: -SEE TABLE-
- FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
- ALL STAINLESS/GALANIZED STEEL SHOULD BE MASKED PRIOR TO PAINT.
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- PAINT QUALITY IS TO MINIMIZE DRIP OR RUNS.
- COAT THICKNESS SHOULD BE SO THERE IS NO "BLEED THRU" OF FABRICATION.

FASTENERS/SPRING PINS

- VENDER TO USE GRADE "8" HEX HEAD CAP SCREW AND GRADE "C" PREVAILING TORQUE HEX NUT.
- ALL OTHER GRADE FASTENERS ARE UNACCEPTABLE UNLESS OTHERWISE SPECIFIED ON THE PRINT.
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- FASTENERS SHOULD BE FREE OF PAINT.
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- GAS SPRINGS ARE TO BE "ROD DOWN" UNLESS OTHERWISE SPECIFIED.

INSPECTION

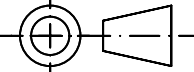
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TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
	.0 ± 0.12	X ± 1.0
	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

RACK SIZE (INCHES) = 55.31"X 31.94"X 47.12"
RACK SIZE (MM) = 1405 X 811 X 435
(8) PARTS PER RACK
EMPTY RACK WEIGHT = 247 POUNDS
RACK COLOR = POWDER COATED WHITE W/ BLACK STENCILS
GRIND DOWN ALL SHARP EDGES
ALL WELDS ON OUTER SURFACES GROUND FLUSH
RED SHADOW AROUND ALL FORK OPENINGS

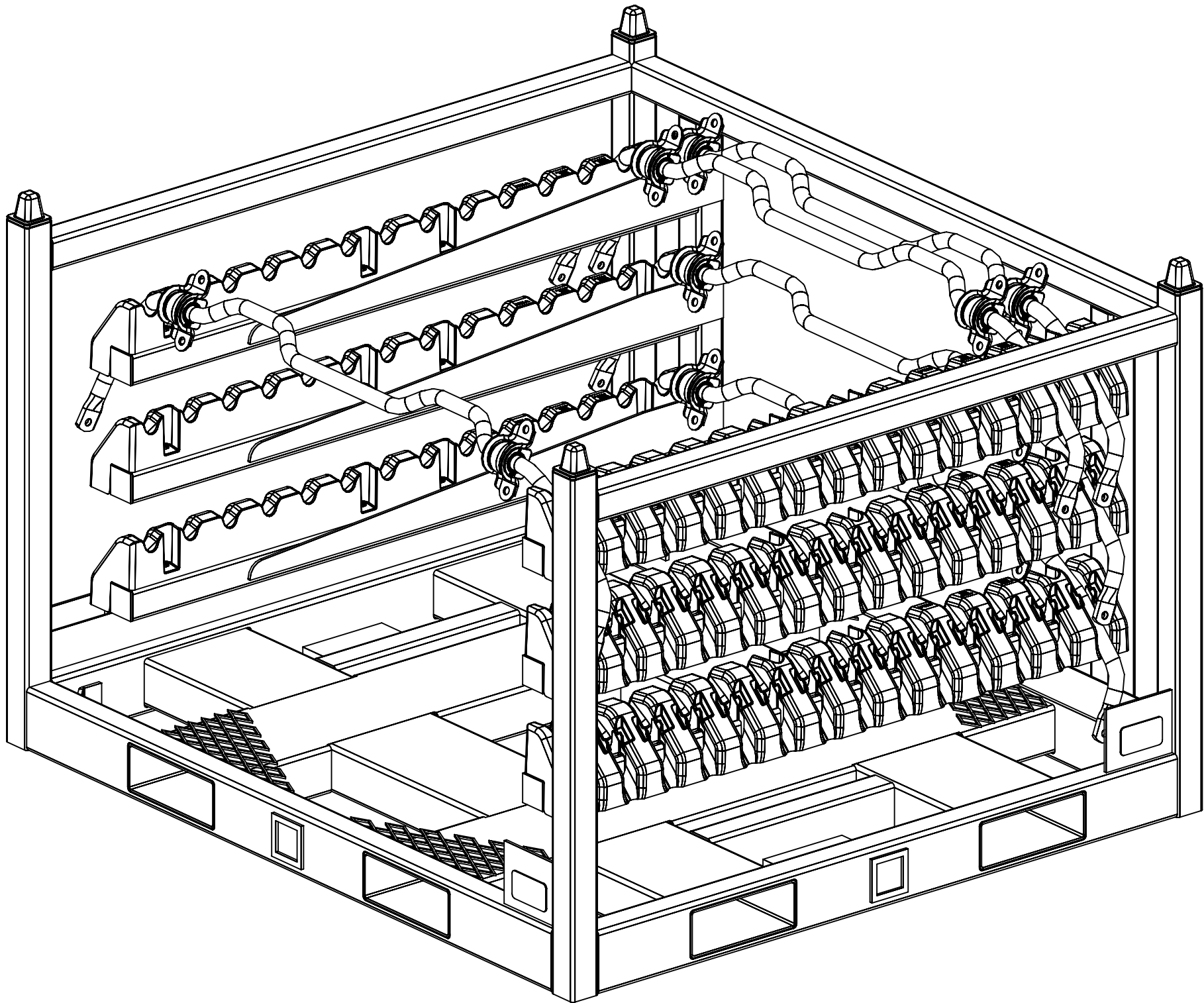




3RD ANGLE PROJ DIMENSIONS
ARE IN MILLIMETERS

PART MUST COMPLY WITH MATERIAL SPECIFICATION
WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH,
SAFETY AND THE ENVIRONMENT

CUSTOMER	REF FILE #: SHIPPING RACK DESIGN		
DESIGN PSS	PART NAME FRONT & REAR DOOR PANEL LH		
ENGINEER PSS	PART NUMBER	REV 009	SHOWN
SCALE N/A	DIVISION AUTOMOTIVE		SHT 1
	PLANT		OF 12



WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
- LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
- ANY CONTINUOUS WELDS GREATER THAN 6" SHOULD REFER TO WELDING NOTE OR DESIGN SOURCE.
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PAINT

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FASTENERS/SPRING PINS

- VENDER TO USE GRADE "8" HEX HEAD CAP SCREW AND GRADE "C" PREVAILING TORQUE HEX NUT.
- ALL OTHER GRADE FASTENERS ARE UNACCEPTABLE UNLESS OTHERWISE SPECIFIED ON THE PRINT.
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- FASTENERS SHOULD BE FREE OF PAINT.
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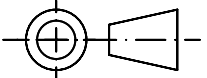
INSPECTION

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TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
	.0 ± 0.12	X ± 1.0
	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

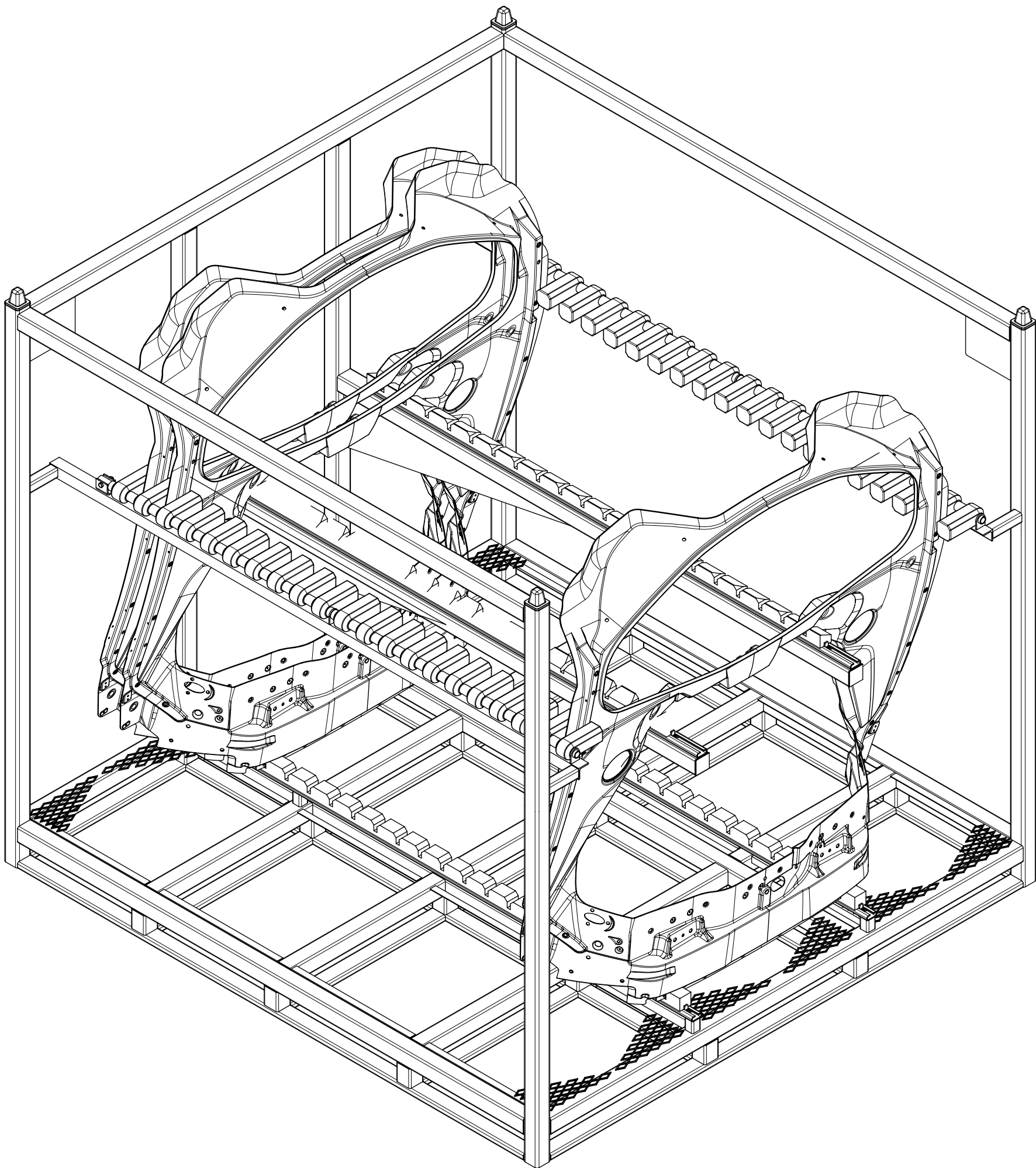
RACK SIZE = 53"X 48"X 34.94"
RACK SIZE (MM) = 1346 X 1219 X 887
(42) PARTS PER RACK
EMPTY RACK WEIGHT = 430 POUNDS
RACK COLOR = POWDER COATED WHITE W/ BLACK STENCILS
GRIND DOWN ALL SHARP EDGES
ALL WELDS ON OUTER SURFACES GROUND FLUSH
RED SHADOW AROUND ALL FORK OPENINGS



3RD ANGLE PROJ DIMENSIONS
ARE IN MILLIMETERS

PART MUST COMPLY WITH MATERIAL SPECIFICATION
WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH,
SAFETY AND THE ENVIRONMENT

CUSTOMER	REF FILE #:		
	SHIPPING RACK DESIGN		
DESIGN PSS	PART NAME REAR STAY BAR		
ENGINEER PSS	PART NUMBER	REV 008	SHOWN
SCALE N/A	DIVISION AUTOMOTIVE	PLANT	SHT 1 OF 13



WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
- LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
- ANY CONTINUOUS WELDS GREATER THAN 6" SHOULD REFER TO WELDING NOTE OR DESIGN SOURCE.
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PAINT

- PAINT COLOR: -SEE TABLE-
- FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
- ALL STAINLESS/GALANIZED STEEL SHOULD BE MASKED PRIOR TO PAINT.
- DUNNAGE OR AREAS CONTACTING COMMODITY CONTAINER IS CARRYING SHOULD BE PAINT FREE.
- PAINT QUALITY IS TO MINIMIZE DRIP OR RUNS.
- COAT THICKNESS SHOULD BE SO THERE IS NO "BLEED THRU" OF FABRICATION.

FASTENERS/SPRING PINS

- VENDER TO USE GRADE "8" HEX HEAD CAP SCREW AND GRADE "C" PREVAILING TORQUE HEX NUT.
- ALL OTHER GRADE FASTENERS ARE UNACCEPTABLE UNLESS OTHERWISE SPECIFIED ON THE PRINT.
- ALL SCREWS, NUTS, WASHERS, ETC ARE TO BE ZINC PLATED.
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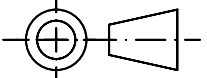
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TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
	.0 ± 0.12	X ± 1.0
	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

RACK SIZE = 96"X 90"X 89"
(20) PARTS PER RACK
EMPTY RACK WEIGHT = 840 POUNDS

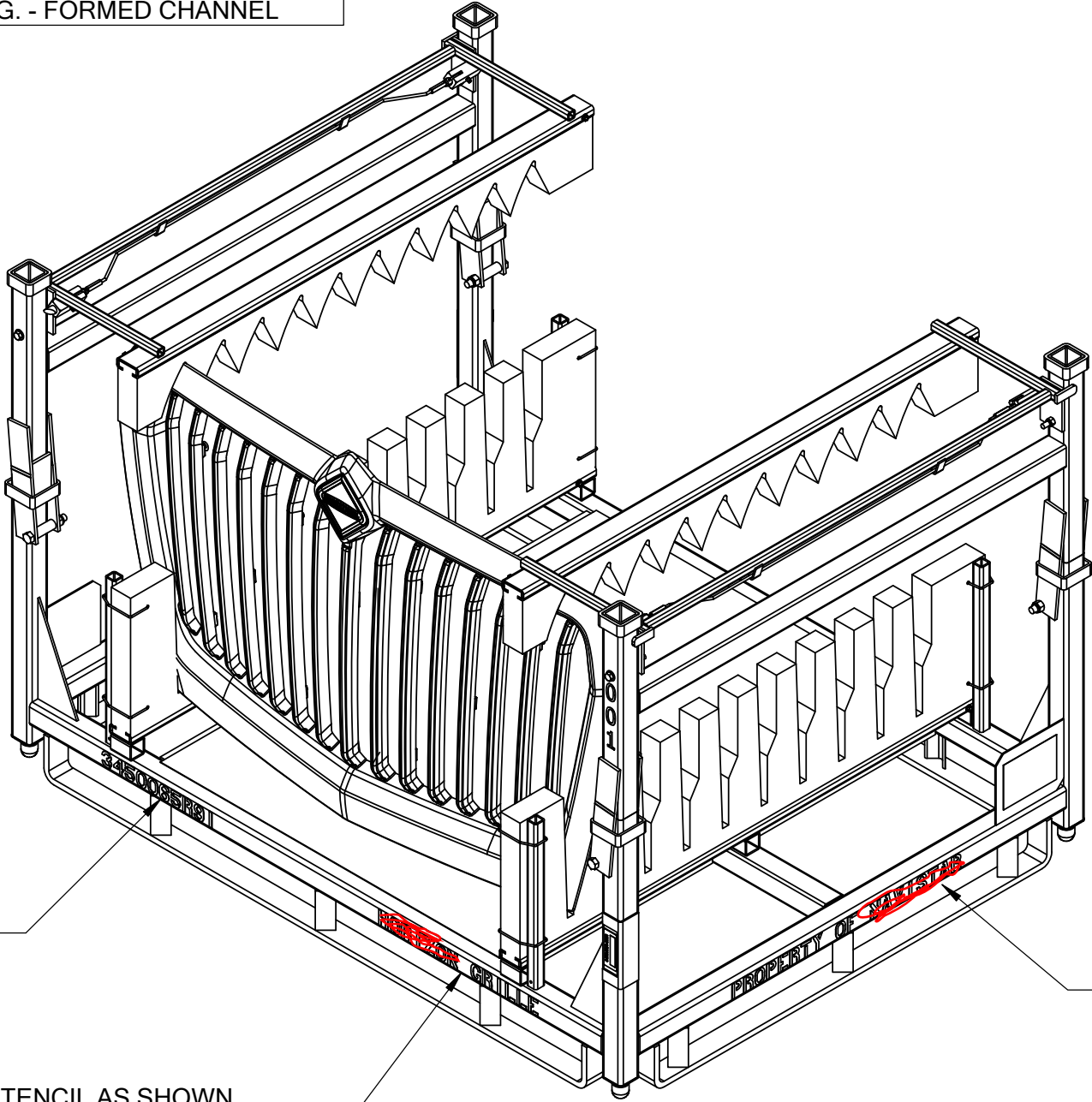


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ARE IN MILLIMETERS

PART MUST COMPLY WITH MATERIAL SPECIFICATION
WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH,
SAFETY AND THE ENVIRONMENT

CUSTOMER	REF FILE #:		
	COUPE / CONV WIP RACK		
DESIGN PSS	PART NAME		
ENGINEER PSS	PART NUMBER	REV 006	SHOWN
SCALE N/A	DIVISION AUTOMOTIVE	SHT 1 OF 1 1	
	PLANT		

DET	QTY	DESCRIPTION
1	2	BOTTOM DUNNAGE - 4# X-LINK FOAM
2	2	GATE DUNNAGE - 4# X-LINK FOAM
3	8	1/4 x 1.00" LG. - SELF DRILLING (TEK) SCREW
4	8	1/4" x DEV. LENGTH - ZIP TIE
5	2	3.25 X 1.31 - SCID LABEL
6	2	11 GA. x DEV. WIDTH x 6.00 LG. - FORMED CHANNEL



STENCIL AS SHOWN
PER NOTE ON SHEET 1
FRONT/BACK OF RACK
RACK NO.

STENCIL AS SHOWN
PER NOTE ON SHEET 1
FRONT/BACK OF RACK
DECSRIPTION

STENCIL AS SHOWN
PER NOTE ON SHEET 1
BOTH SIDES OF RACK
"PROPERTY OF " "

WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
- LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
- ANY CONTINUOUS WELDS GREATER THAN 6" SHOULD REFER TO WELDING NOTE OR DESIGN SOURCE.
- PRODUCTION RACKS MUST BE COMPLETELY FREE OF WELD SPLATTER, SHARP EDGES, BURRED EDGES, RUSTED OR RUSTING AREAS ON RACK, PRIOR TO FINAL DELIVERY.

TOLERANCES

DECIMALS	ANGLES
0 ± 0.12	X ± 1.0
.00 ± 0.06	X.X ± 0.5
.000 ± 0.03	X.XX ± 0.1

PAINT

- PAINT COLOR: -SEE TABLE-
- FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
- ALL STAINLESS/GALANIZED STEEL SHOULD BE MASKED PRIOR TO PAINT.
- DUNNAGE OR AREAS CONTACTING COMMODITY CONTAINER IS CARRYING SHOULD BE PAINT FREE.
- PAINT QUALITY IS TO MINIMIZE DRIP OR RUNS.
- COAT THICKNESS SHOULD BE SO THERE IS NO "BLEED THRU" OF FABRICATION.

FASTENERS/SPRING PINS

- VENDER TO USE GRADE "8" HEX HEAD CAP SCREW AND GRADE "C" PREVAILING TORQUE HEX NUT. ALL OTHER GRADE FASTENERS ARE UNACCEPTABLE UNLESS OTHERWISE SPECIFIED ON THE PRINT.
- ALL SCREWS, NUTS, WASHERS, ETC ARE TO BE ZINC PLATED.
- FASTENERS SHOULD BE FREE OF PAINT.
- GREASE ALL ZERK FITTINGS AFTER ASSEMBLY AND BEFORE SHIPPING.
- GAS SPRINGS ARE TO BE "ROD DOWN" UNLESS OTHERWISE SPECIFIED.

INSPECTION

- FIRST ARTICLE MUST BE MADE FROM PRODUCTION JIGS AND FIXTURES.
- APPROVAL FOR PRODUCTION MUST BE IN WRITING FROM CUSTOMER.
- CRITICAL DIMENSIONS ARE DEFINED ON SHEETS. ASSEMBLY OF THESE CRITICAL DIM'S ARE TO BE INSPECTED WITH OTHER SPECIFICATION DEFINED BY THE CUSTOMER. SUPPLIER MUST KEEP RECORDS OF INSPECTION WITH SAMPLING 10% MINI.
- ANY VARIATIONS OF SPECIFICATIONS AND/OR MATERIAL MUST HAVE WRITTEN APPROVAL FROM CUSTOMER.
- ALL MATERIALS SUPPLIED BY CUSTOMER ARE THE PHYSICAL RESPONSIBILITY OF SUPPLIER. SUPPLIER MUST INSPECT AND COUNT MATERIAL UPON ARRIVAL AND CONFIRM PHYSICAL COUNTS TO CUSTOMER VIA FAX OR E-MAIL. THIS CONFIRMATION ACKNOWLEDGES THE COUNTS FOR GOODS ARE CORRECT. SUPPLIER IS RESPONSIBLE FOR MISPLACED OR DAMAGED MATERIAL CREATED BY THE FABRICATION OR ASSEMBLY OF THE CONTAINER.

RACK NO.	DESCRIPTION	RACK COLOR	STENCIL COLOR
3450065R1	GRILLE	SAFETY YELLOW	BLACK

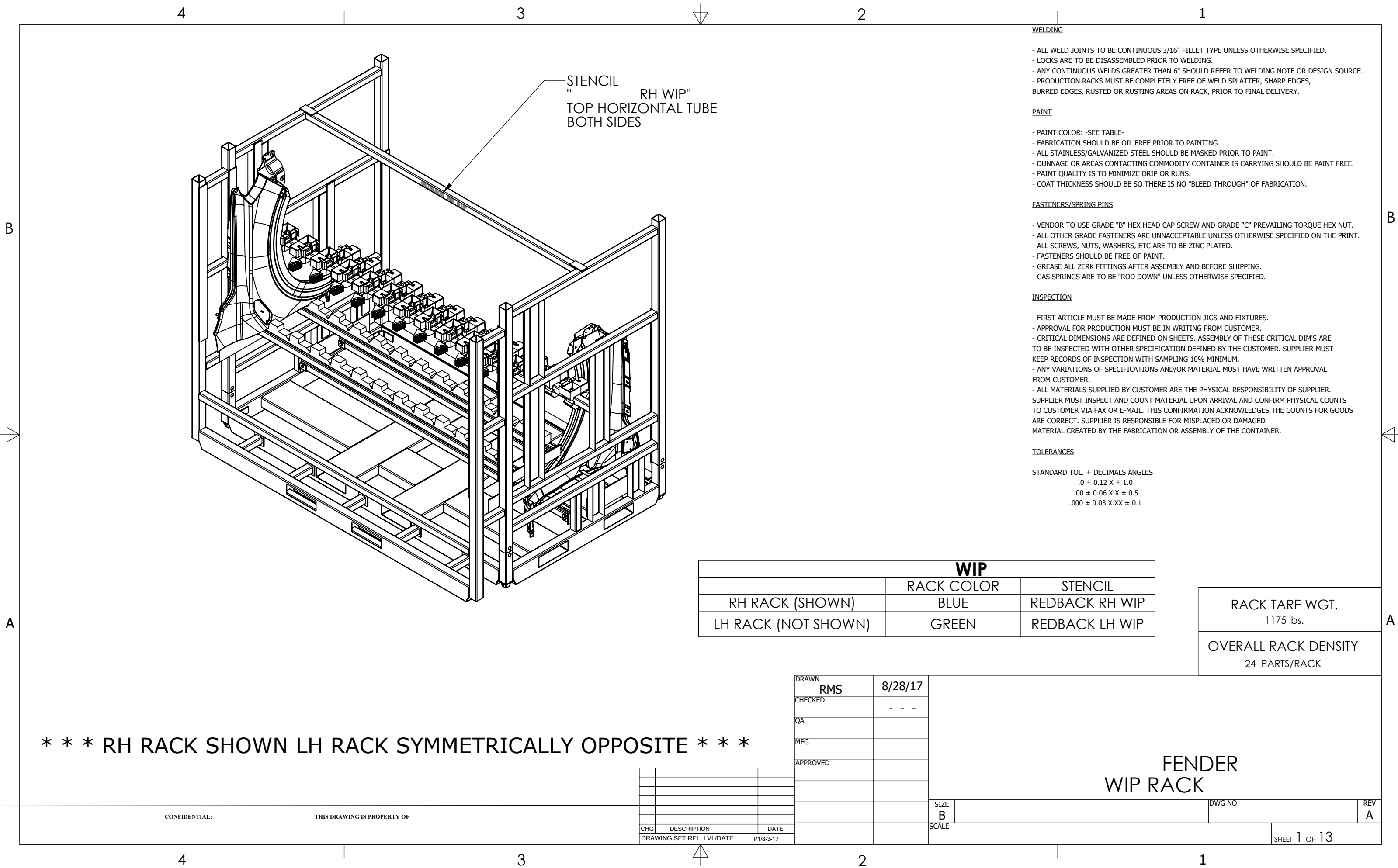
P4	RELEASE FOR PRODUCTION	6/8/2016
CHG	DESCRIPTION	DATE
	DRAWING SET REL. LVL/DATE	P4 - 6/8/16

<div><div>PSS</div><div>PACKAGING SOLUTIONS & SYSTEMS (248) 269-0455 WWW.PSSRACK.COM</div></div>		
	NAME	DATE
DRAWN	CHL	6/8/16
CHECKED	- - -	- - -
CUSTOMER		/ /

<div><div><div></div><div></div></div><div>THIRD ANGLE PROJECTION</div></div>
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES
TOLERANCES: ANGULAR: ± 1 DEG. ONE PLACE DECIMAL ± .12 TWO PLACE DECIMAL ± .06 THREE PLACE DECIMAL ± .03

PART NO:	N/A	
DESCRIPTION:	GRILLE SHIPPING RACK	
DO NOT SCALE DRAWING		SHEET 1 OF 4

RACK TARE WGT. 525 LBS
OVERALL RACK DENSITY 10 PARTS/RACK



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TOLERANCES

STANDARD TOL. ± DECIMALS ANGLES

.0 ± 0.12 X ± 1.0

.00 ± 0.06 X.X ± 0.5

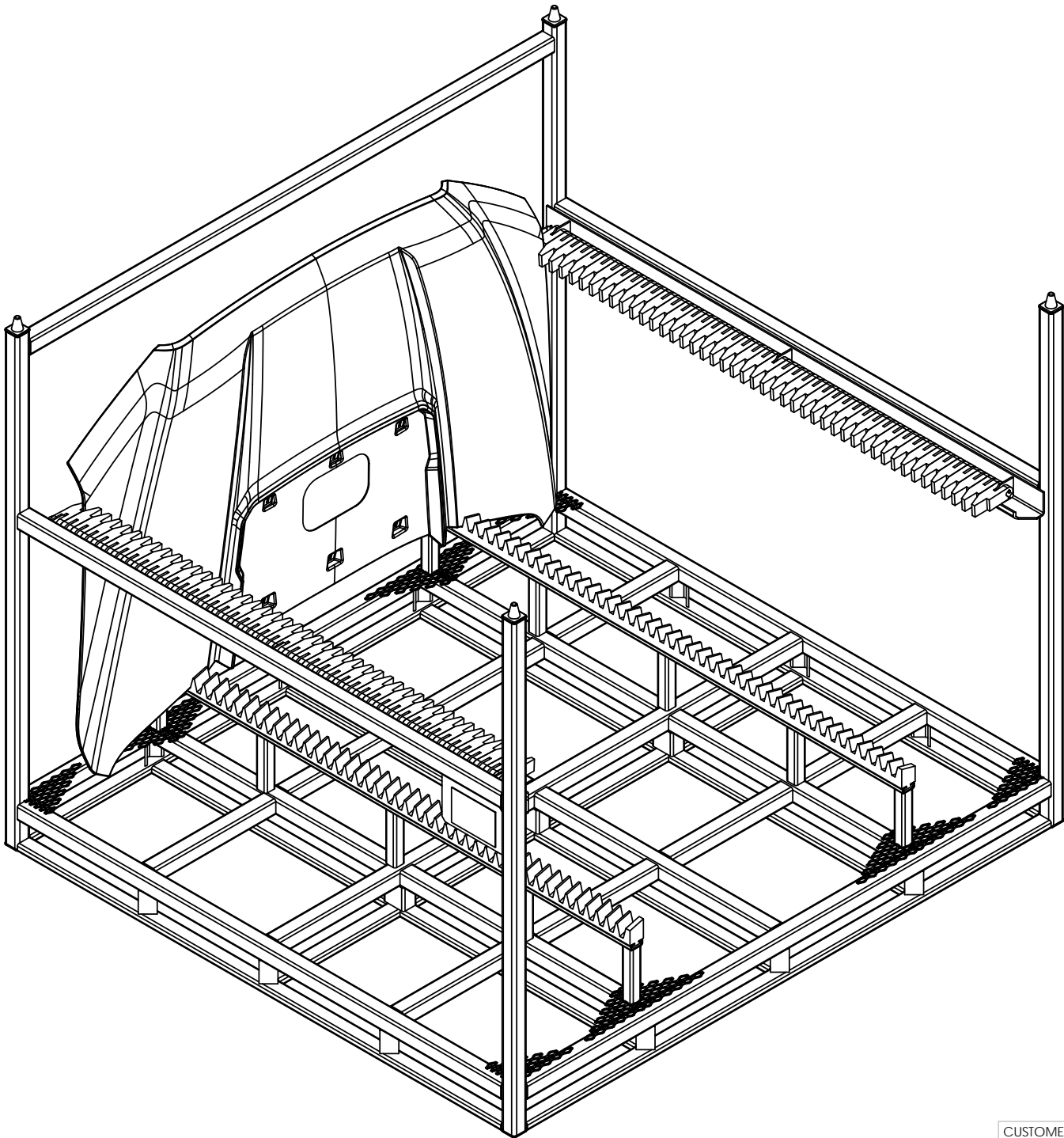
.000 ± 0.03 X.XX ± 0.1

WIP		
	RACK COLOR	STENCIL
RH RACK (SHOWN)	BLUE	REDBACK RH WIP
LH RACK (NOT SHOWN)	GREEN	REDBACK LH WIP

RACK TARE WGT. 1175 lbs.
OVERALL RACK DENSITY 24 PARTS/RACK

* * * RH RACK SHOWN LH RACK SYMMETRICALLY OPPOSITE * * *

DRAWN RMS	8/28/17	FENDER WIP RACK	
CHECKED	- - -		
QA			
MFG			
APPROVED			
CHG	DESCRIPTION	DATE	SIZE B
DRAWING SET REL. LVL/DATE		P1/8-3-17	SCALE
			DWG NO
			REV A
			SHEET 1 OF 13



- WELDING**
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	DECIMALS	ANGLES
STANDARD TOL. ±	.0 ± 0.12	X ± 1.0
	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

- PAINT**
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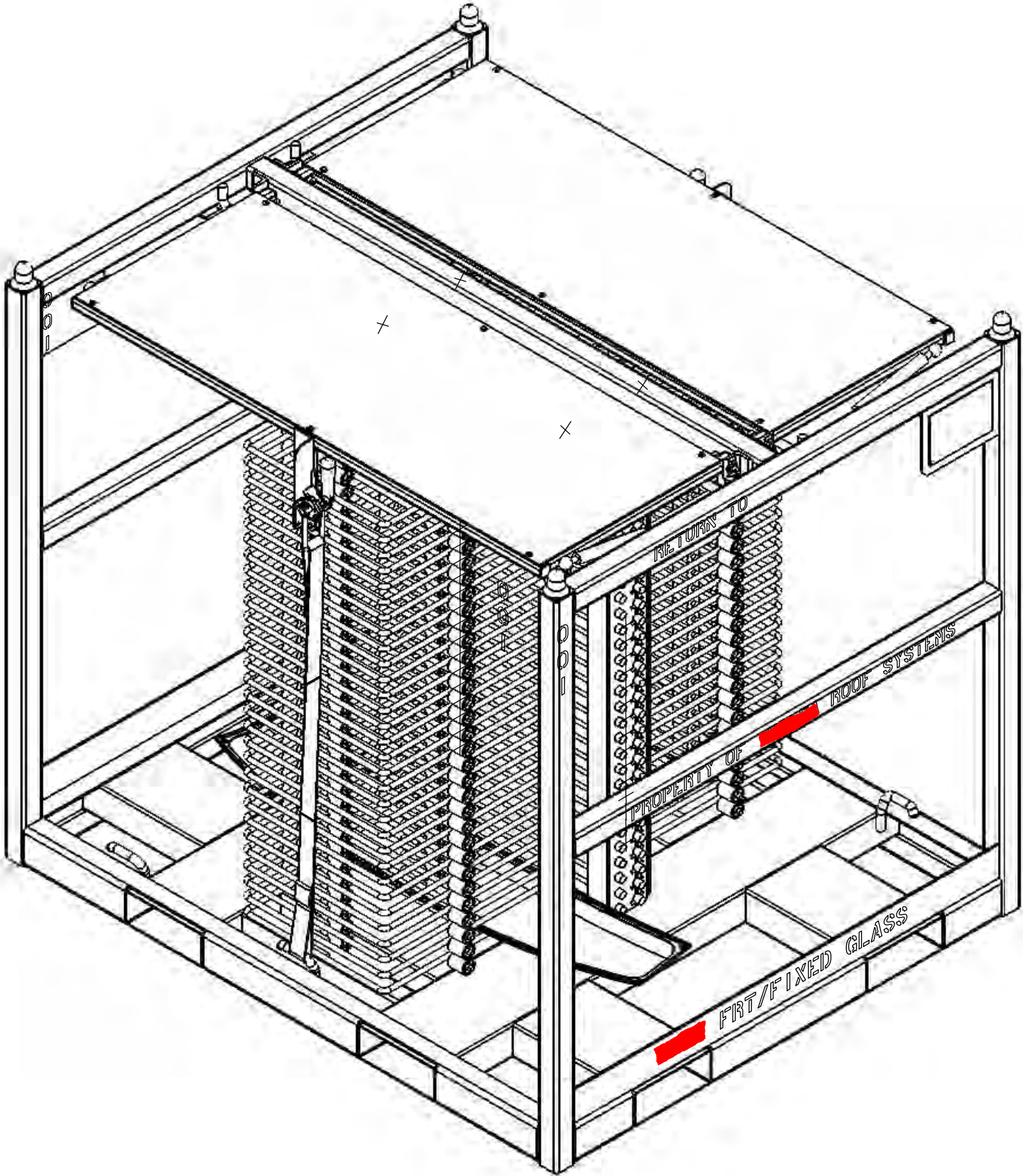
1	RELEASE FOR BUILD	8/1/2016
CHG	DESCRIPTION	DATE
DRAWING SET REL. LVL/DATE		1/8-1-16

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/8
ANGULAR: ± 1 DEG.
TWO PLACE DECIMAL ± .06
THREE PLACE DECIMAL ± .03

MATERIAL
FINISH
DO NOT SCALE DRAWING

CUSTOMER:	NAME	DATE
DRAWN	CHL	8/1/16
CHECKED	N/A	N/A
ENG APPR.	n/a	n/a
MFG APPR.		
Q.A.		
SUPPLIER:	<div>PSS</div> <div>PACKAGING SOLUTIONS & SYSTEMS (248) 269-0455 WWW.PSSRACK.COM</div>	

PART NO: - - - -		
TITLE: <div>HOOD OUTER WIP RACK</div>		
SIZE B	RACK. NO. - - - -	REV 1
		SHEET 1 OF 13



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TOLERANCES

	DECIMALS	ANGLES
STANDARD TOL. ±	.0 ± 0.12 .00 ± 0.06 .000 ± 0.03	X ± 1.5 X.X ± 0.5 X.XX ± 0.1

PAINT

- SEE TABLE FOR PAINT COLOR.
- FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
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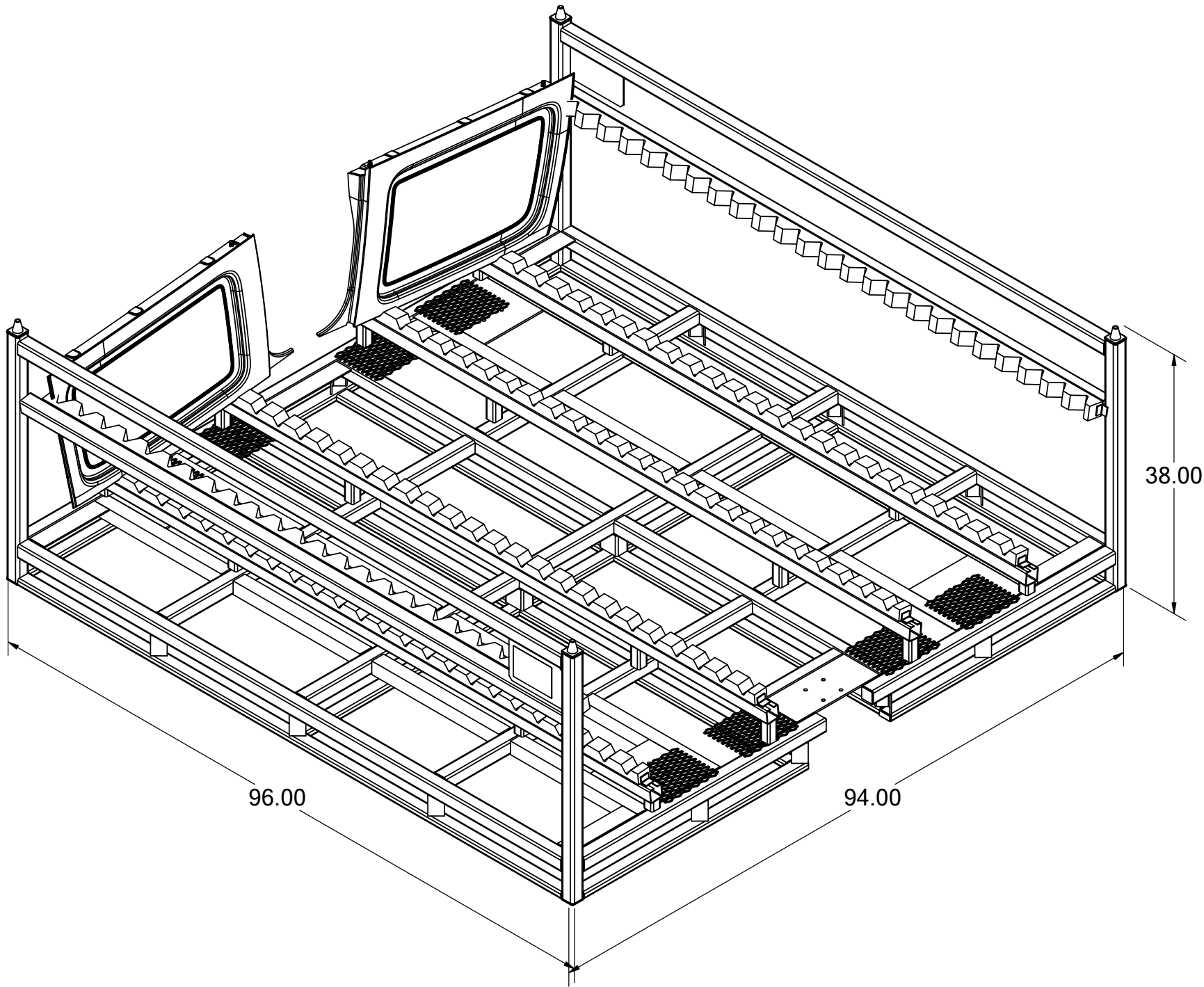
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RACK TARE WGT. 780 lbs.
OVERALL RACK DENSITY 124 PARTS/RACK

PART NO.	DESCRIPTION	RACK COLOR	STENCIL COLOR
	FRT/FIX GLASS	T.B.D.	WHITE

P1	RELEASE FOR PROTO	12/01/17
CHG	DESCRIPTION	DATE
DRAWING SET REL. LVL/DATE		P1 - 12/01/17

UNLESS OTHERWISE SPECIFIED:		NAME	DATE	PART NO: - - - -		
DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/8 ANGULAR: ± 1 DEG. TWO PLACE DECIMAL ± .06 THREE PLACE DECIMAL ± .03	DRAWN	CHL	12/1/17	TITLE: FRT/FIX GLASS SHIPPING RACK		
	CHECKED	CHECKER	Cxx/xx/xx			
	ENG APPR.	ENGINEER	DATE			
	MFG APPR.					
	Q.A.					
MATERIAL	CUSTOMER:			SIZE	RACK. NO.	REV
FINISH				B	- - - -	A
DO NOT SCALE DRAWING				SHEET 1 OF 16		



WELDING

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TOLERANCES

STANDARD TOL ±	DECIMALS	ANGLES
	0 ± 0.12	X ± 1.0
	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

- ALL BOXED DIMENSIONS TO BE HELD WITH +/- .06 RELATIVE TO THE ASSOCIATED DATUM FEATURE.

PAINT

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PART NO.	DESCRIPTION	RACK COLOR	STENCIL COLOR
- - -	SIDE PNL	SAFETY ORANGE	BLACK
- - -		SAFETY ORANGE	

P1	RELEASE FOR PROTOTYPE	8/1/2017
CHG	DESCRIPTION	DATE
DRAWING SET REL. LVL/DATE		P1/8-1-17

THIRD ANGLE PROJECTION		
	NAME	DATE
DRAWN	CHL	8/1/17
CHECKED	- - -	- - -
CUSTOMER		/ /

RACK TARE WGT. 725 LBS.		
OVERALL RACK DENSITY 48 PARTS/RACK		
PART NO: - - -		
DESCRIPTION: SIDE PNL JL WIP RACK		
DO NOT SCALE DRAWING		SHEET 1 OF 13

4

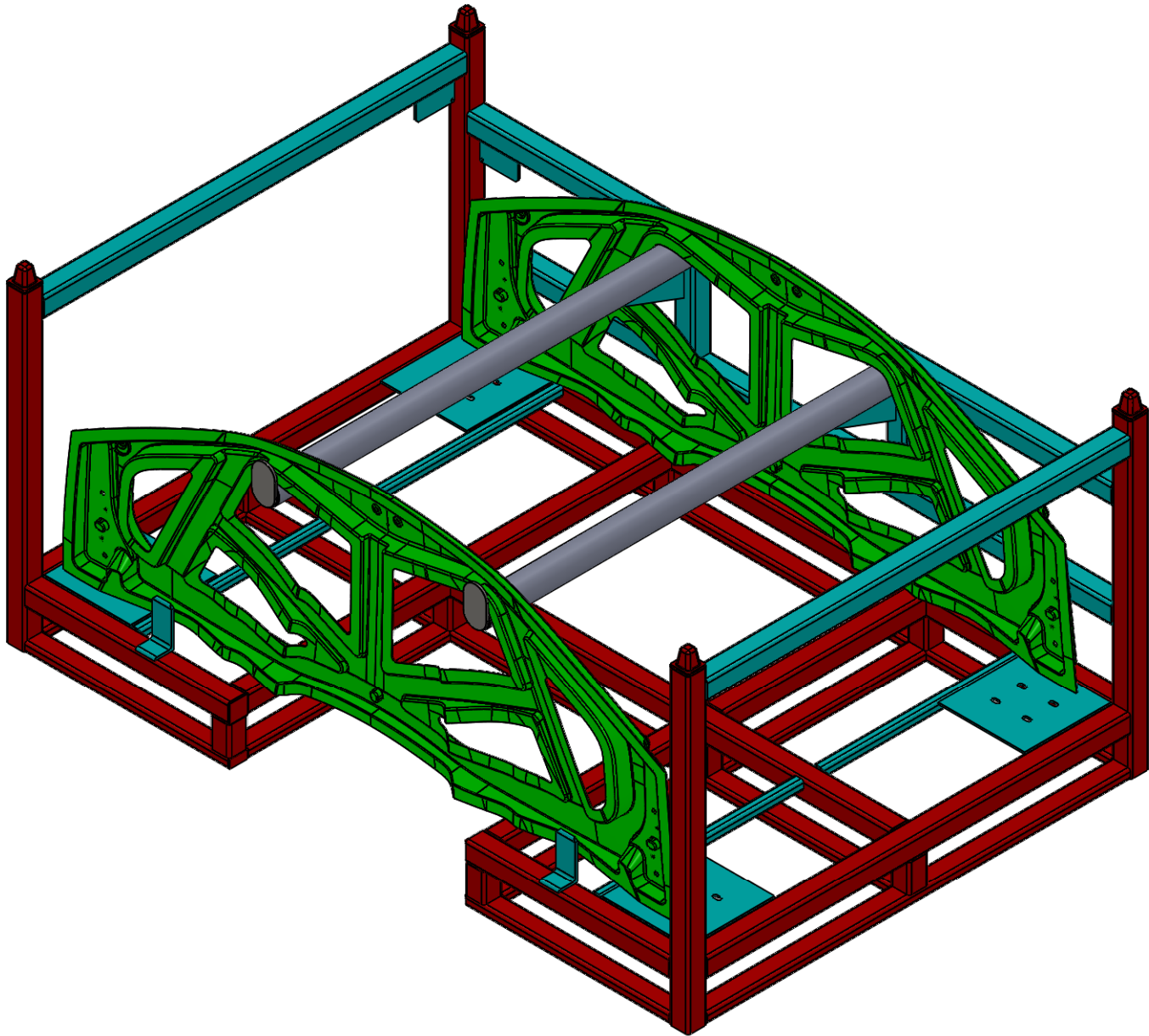
3

2

1

B

A



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TOLERANCES

STANDARD TOL. ± DECIMALS ANGLES
.0 ± 0.12 X ± 1.0
.00 ± 0.06 X.X ± 0.5
.000 ± 0.03 X.XX ± 0.1

DRAWN	DS	11/4/16	DECKLID INNER RACK			
CHECKED						
QA						
MFG						
APPROVED						
			SIZE	DWG NO		REV
			B	XX-XXX		
			SCALE			
			SHEET 1 OF 8			

CONFIDENTIAL:

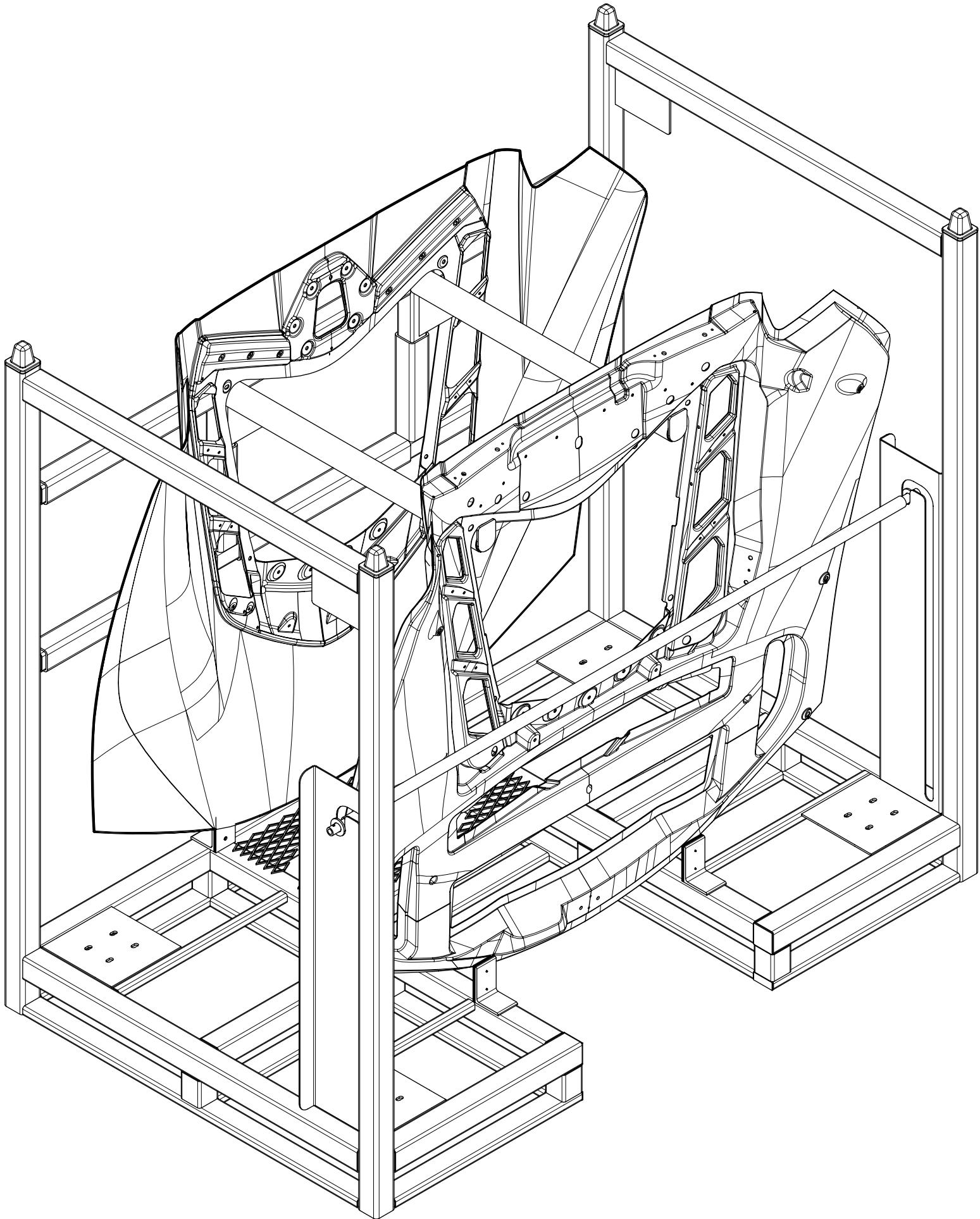
THIS DRAWING IS PROPERTY OF

4

3

2

1



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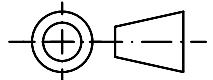
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	.00 ± 0.06	X.X ± 0.5
	.000 ± 0.03	X.XX ± 0.1

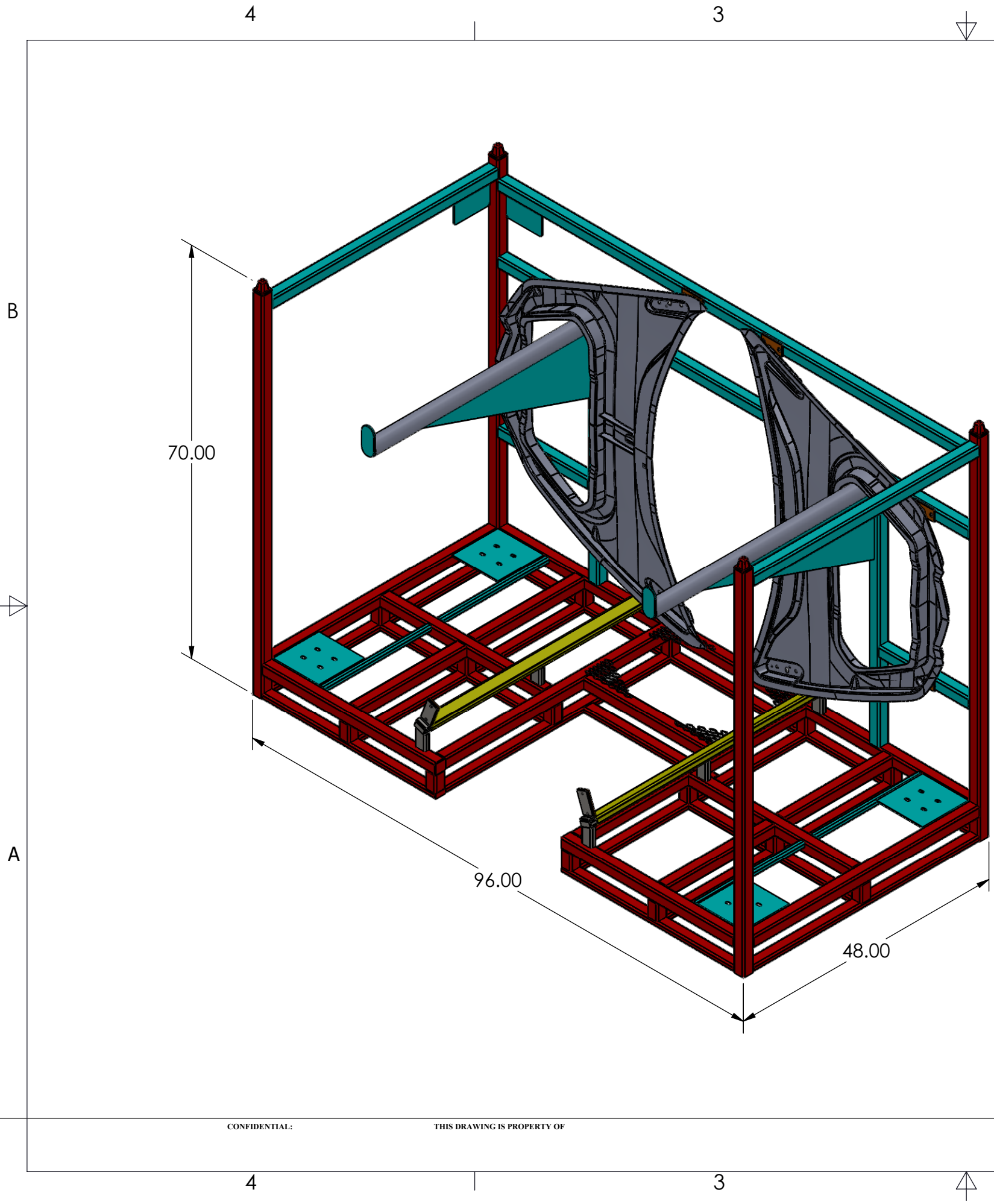
NOTE :
RACK SIZE = 78" X 48.25" X 74"
RACK WEIGHT = 460 POUNDS



3RD ANGLE PROJ DIMENSIONS
ARE IN MILLIMETERS

PART MUST COMPLY WITH MATERIAL SPECIFICATION
WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH,
SAFETY AND THE ENVIRONMENT

CUSTOMER	REF FILE #:		
	PRODUCTION WIP RACK		
DESIGN PSS	PART NAME HATCH INNER & OUTER		
ENGINEER	DATE 7-13-2017	REV 002	SHOWN
SCALE N/A	DIVISION AUTOMOTIVE	PLANT	SHT 1 OF 7



WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
- LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
- ANY CONTINUOUS WELDS GREATER THAN 6" SHOULD REFER TO WELDING NOTE OR DESIGN SOURCE.
- PRODUCTION RACKS MUST BE COMPLETELY FREE OF WELD SPLATTER, SHARP EDGES, BURRED EDGES, RUSTED OR RUSTING AREAS ON RACK, PRIOR TO FINAL DELIVERY.

PAINT

- PAINT COLOR: -SEE TABLE-
- FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
- ALL STAINLESS/GALVANIZED STEEL SHOULD BE MASKED PRIOR TO PAINT.
- DUNNAGE OR AREAS CONTACTING COMMODITY CONTAINER IS CARRYING SHOULD BE PAINT FREE.
- PAINT QUALITY IS TO MINIMIZE DRIP OR RUNS.
- COAT THICKNESS SHOULD BE SO THERE IS NO "BLEED THROUGH" OF FABRICATION.

FASTENERS/SPRING PINS

- VENDOR TO USE GRADE "B" HEX HEAD CAP SCREW AND GRADE "C" PREVAILING TORQUE HEX NUT.
- ALL OTHER GRADE FASTENERS ARE UNACCEPTABLE UNLESS OTHERWISE SPECIFIED ON THE PRINT.
- ALL SCREWS, NUTS, WASHERS, ETC ARE TO BE ZINC PLATED.
- FASTENERS SHOULD BE FREE OF PAINT.
- GREASE ALL ZERK FITTINGS AFTER ASSEMBLY AND BEFORE SHIPPING.
- GAS SPRINGS ARE TO BE "ROD DOWN" UNLESS OTHERWISE SPECIFIED.

INSPECTION

- FIRST ARTICLE MUST BE MADE FROM PRODUCTION JIGS AND FIXTURES.
- APPROVAL FOR PRODUCTION MUST BE IN WRITING FROM CUSTOMER.
- CRITICAL DIMENSIONS ARE DEFINED ON SHEETS. ASSEMBLY OF THESE CRITICAL DIM'S ARE TO BE INSPECTED WITH OTHER SPECIFICATION DEFINED BY THE CUSTOMER. SUPPLIER MUST KEEP RECORDS OF INSPECTION WITH SAMPLING 10% MINIMUM.
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TOLERANCES

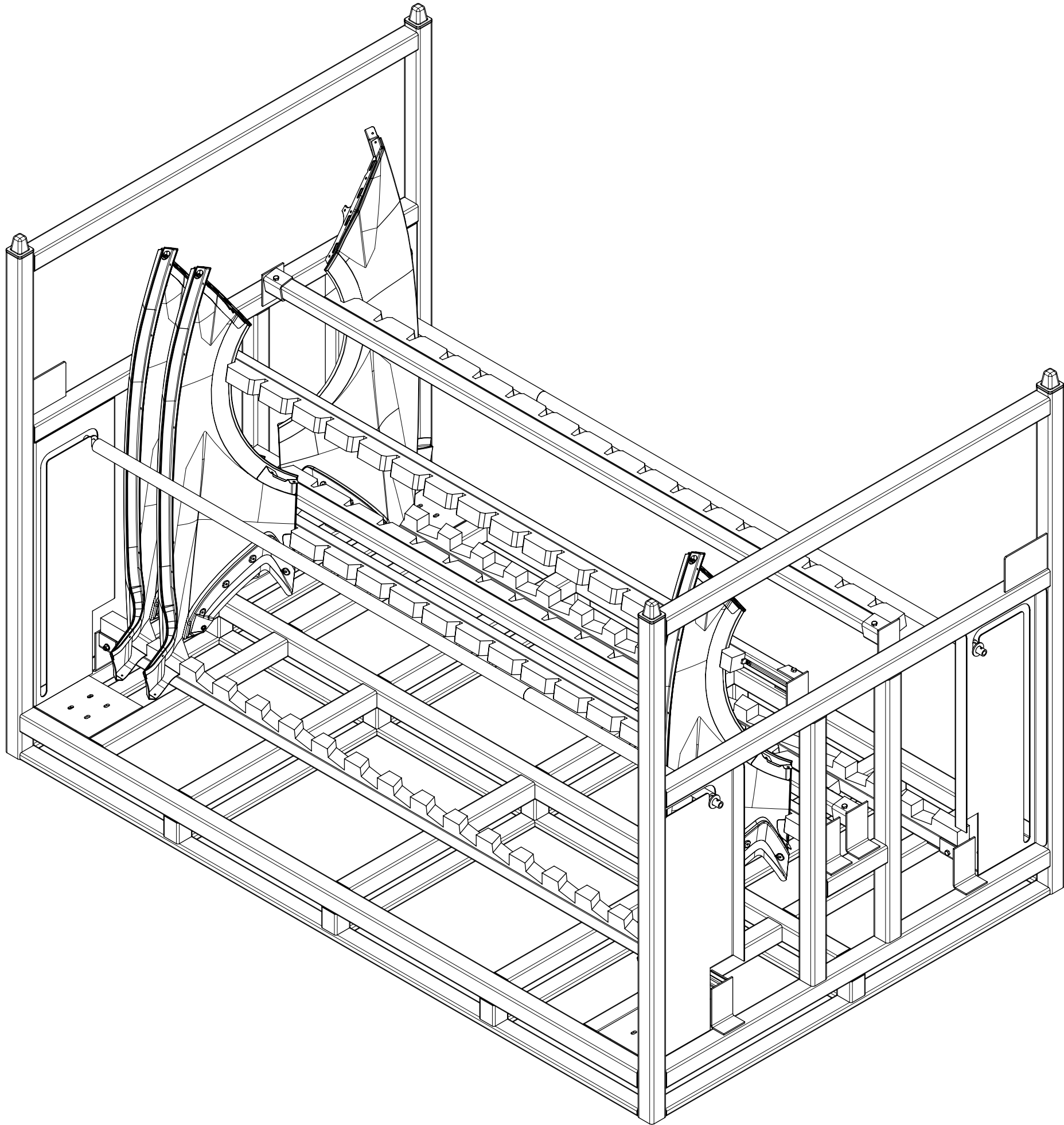
STANDARD TOL. ± DECIMALS ANGLES
.0 ± 0.12 X ± 1.0
.00 ± 0.06 X.X ± 0.5
.000 ± 0.03 X.XX ± 0.1

RACK TARE WGT.
550 lbs.

OVERALL RACK DENSITY
XX PARTS/RACK

DRAWN DS	9/22/17	HOOD INNER RACK		
CHECKED				
QA				
MFG				
APPROVED				
		SIZE B	DWG NO XX-XXX	REV
		SCALE		
				SHEET 1 OF 10

CONFIDENTIAL: THIS DRAWING IS PROPERTY OF



WELDING

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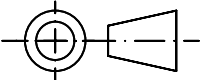
INSPECTION

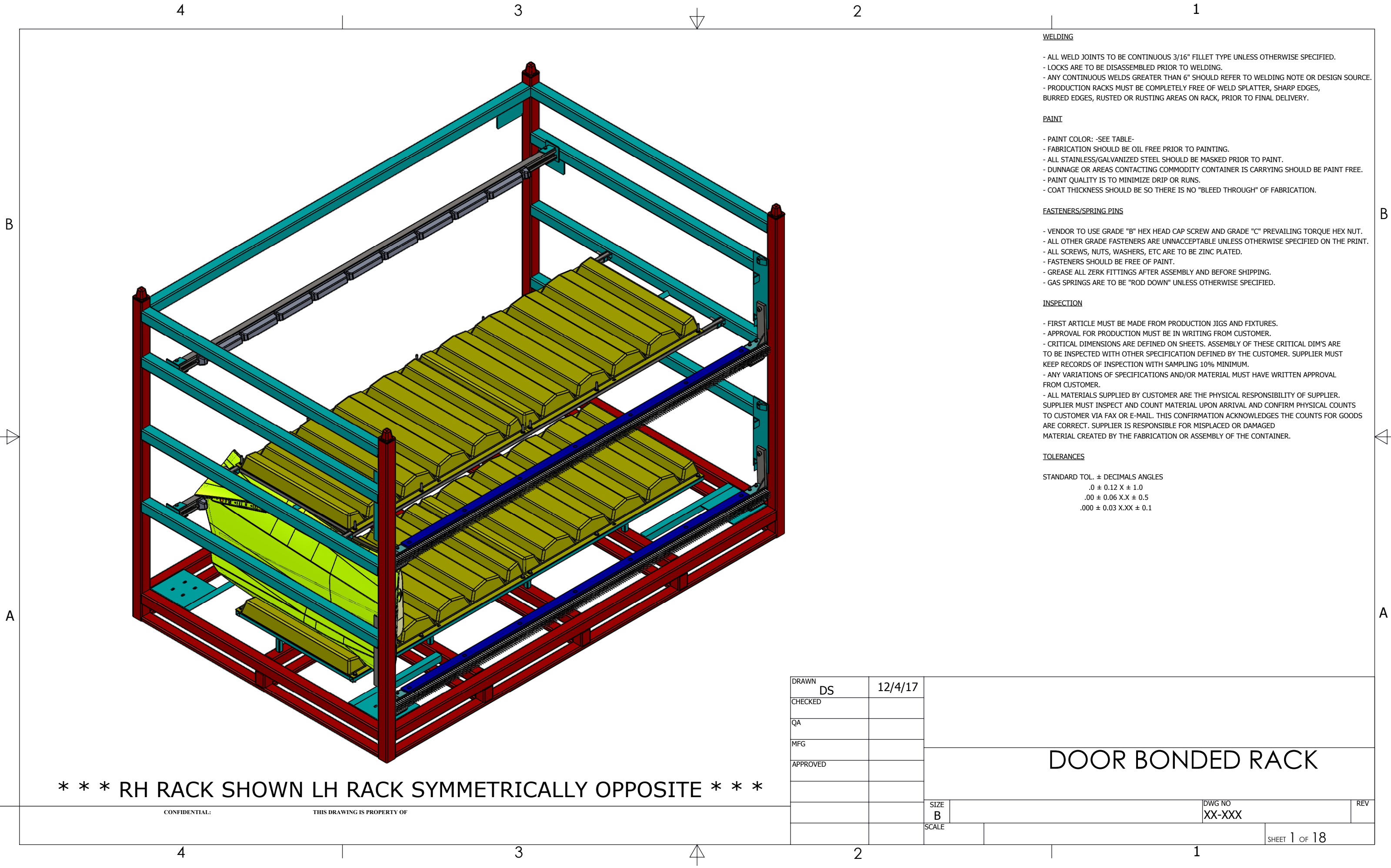
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TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
.0	± 0.12	X ± 1.0
.00	± 0.06	X.X ± 0.5
.000	± 0.03	X.XX ± 0.1

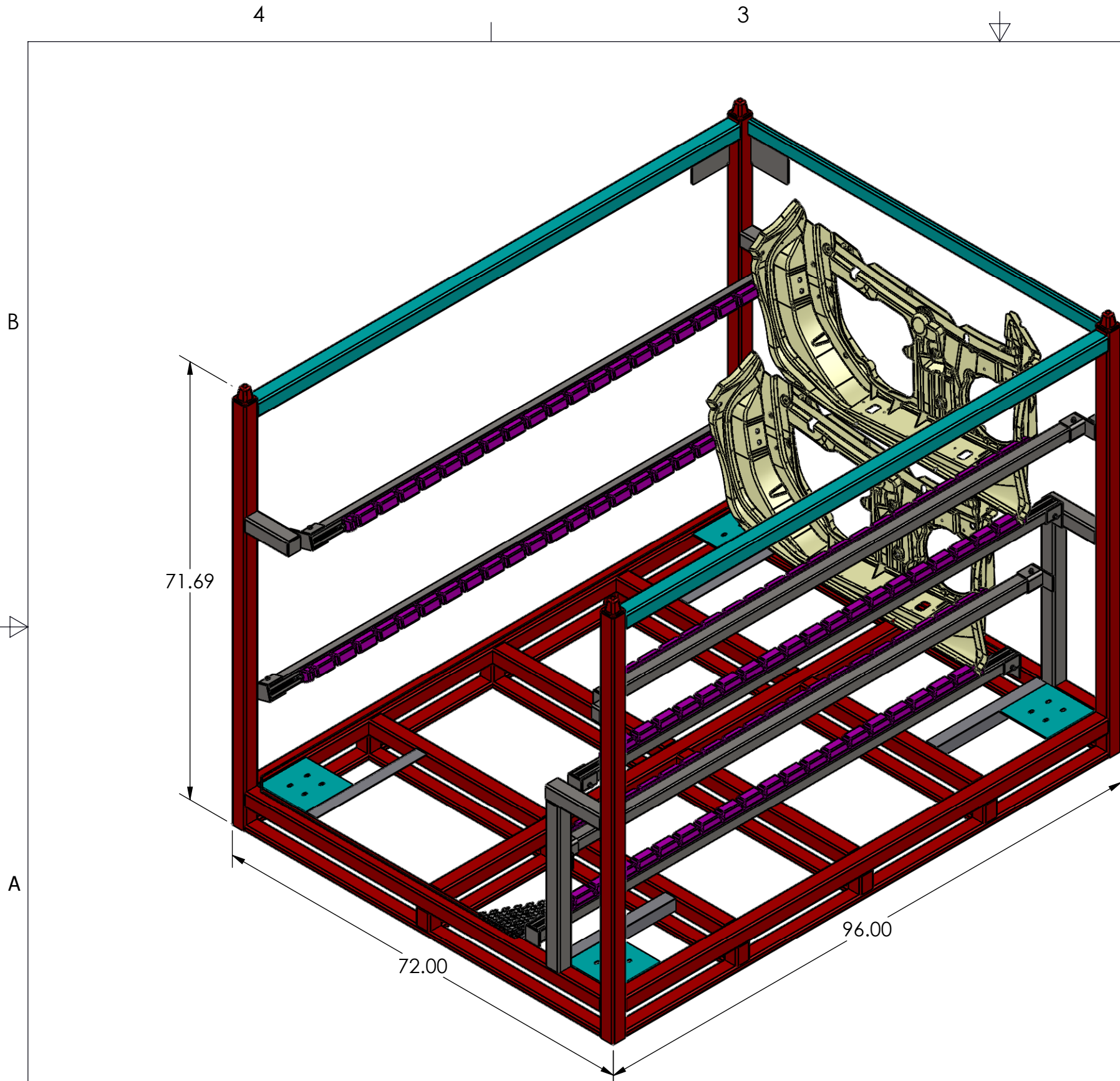
NOTE :
ZERV RH REAR QTR PANEL WIP RACK SHOWN
ZERV LH REAR QTR PANEL WIP RACK OPPOSITE
RACK SIZE - 108" X 69" X 74.5"
DENSITY - (34) PIECES PER RACK
RACK WEIGHT = 915 POUNDS

				3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETERS	
PART MUST COMPLY WITH MATERIAL SPECIFICATION WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT					
CUTOMER		REF FILE #:			
		PRODUCTION WIP RACK			
DESIGN PSS		PART NAME RH REAR QUARTER			
ENGINEER		DATE 12-15-2017		REV 003	
SCALE N/A		DIVISION AUTOMOTIVE			SHOWN SHT 1 OF 13
		PLANT			



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- TOLERANCES**
- STANDARD TOL. ± DECIMALS ANGLES
- .0 ± 0.12 X ± 1.0
 - .00 ± 0.06 X.X ± 0.5
 - .000 ± 0.03 X.XX ± 0.1

DRAWN	DS	12/4/17	DOOR BONDED RACK		
CHECKED					
QA					
MFG					
APPROVED					
			SIZE	DWG NO	REV
			B	XX-XXX	
			SCALE		
			SHEET 1 OF 18		



* * * RH RACK SHOWN LH RACK SYMMETRICALLY OPPOSITE * * *

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TOLERANCES

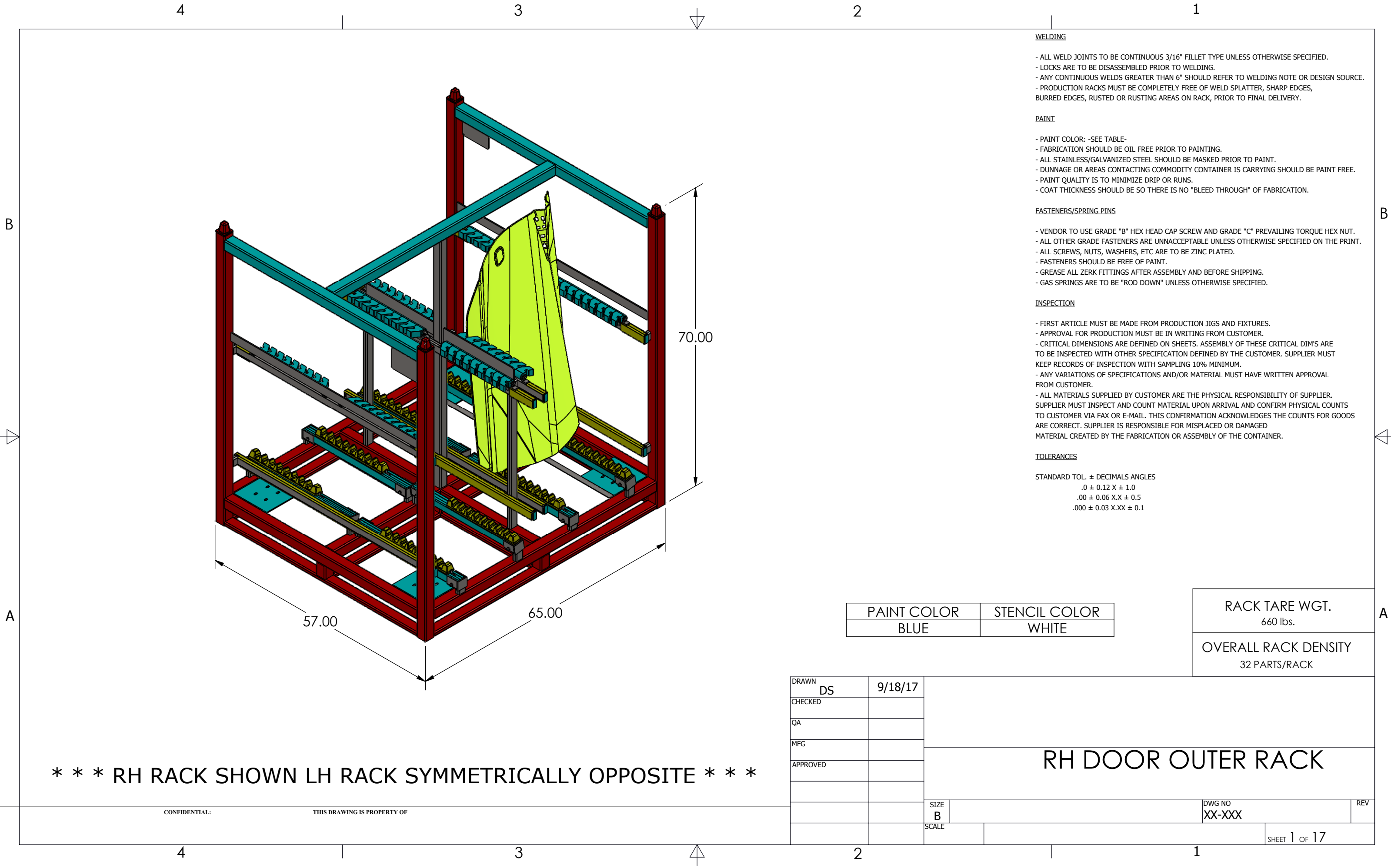
STANDARD TOL. ± DECIMALS ANGLES

- .0 ± 0.12 X ± 1.0
- .00 ± 0.06 X.X ± 0.5
- .000 ± 0.03 X.XX ± 0.1

PAINT COLOR	STENCIL COLOR
BLUE	WHITE

RACK TARE WGT. 779 lbs.
OVERALL RACK DENSITY 40 PARTS/RACK

DRAWN DS	9/18/17	RH DOOR INNER RACK		
CHECKED				
QA				
MFG				
APPROVED				
		SIZE B	DWG NO XX-XXX	REV
		SCALE		
				SHEET 1 OF 13



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TOLERANCES

STANDARD TOL. ± DECIMALS ANGLES

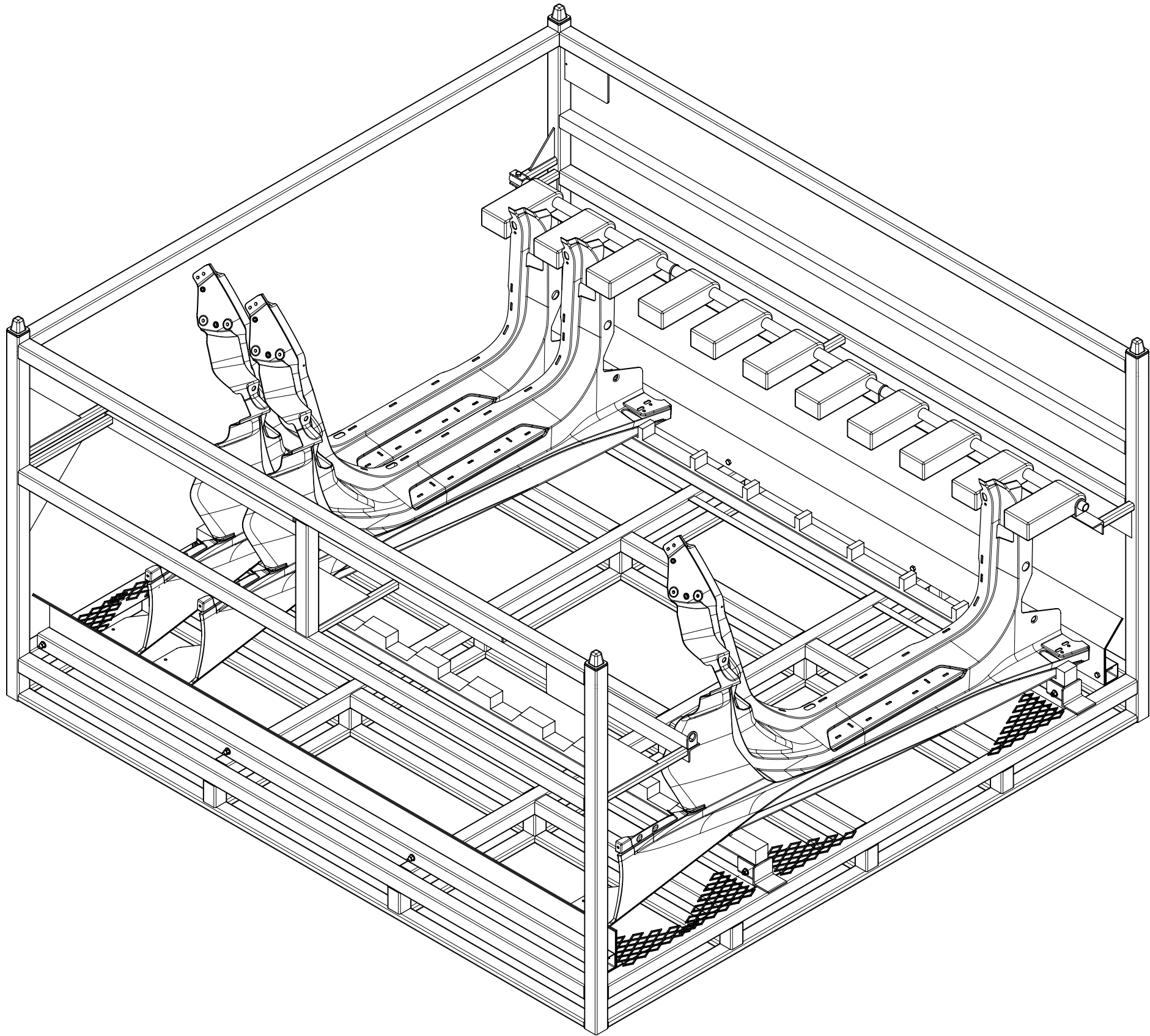
- .0 ± 0.12 X ± 1.0
- .00 ± 0.06 X.X ± 0.5
- .000 ± 0.03 X.XX ± 0.1

PAINT COLOR	STENCIL COLOR
BLUE	WHITE

RACK TARE WGT. 660 lbs.
OVERALL RACK DENSITY 32 PARTS/RACK

* * * RH RACK SHOWN LH RACK SYMMETRICALLY OPPOSITE * * *

DRAWN DS	9/18/17	RH DOOR OUTER RACK			
CHECKED					
QA					
MFG					
APPROVED					
		SIZE B	DWG NO XX-XXX		REV
		SCALE			
		SHEET 1 OF 17			



WELDING

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INSPECTION

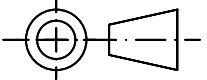
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TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
.0	± 0.12	X ± 1.0
.00	± 0.06	X.X ± 0.5
.000	± 0.03	X.XX ± 0.1

NOTE:

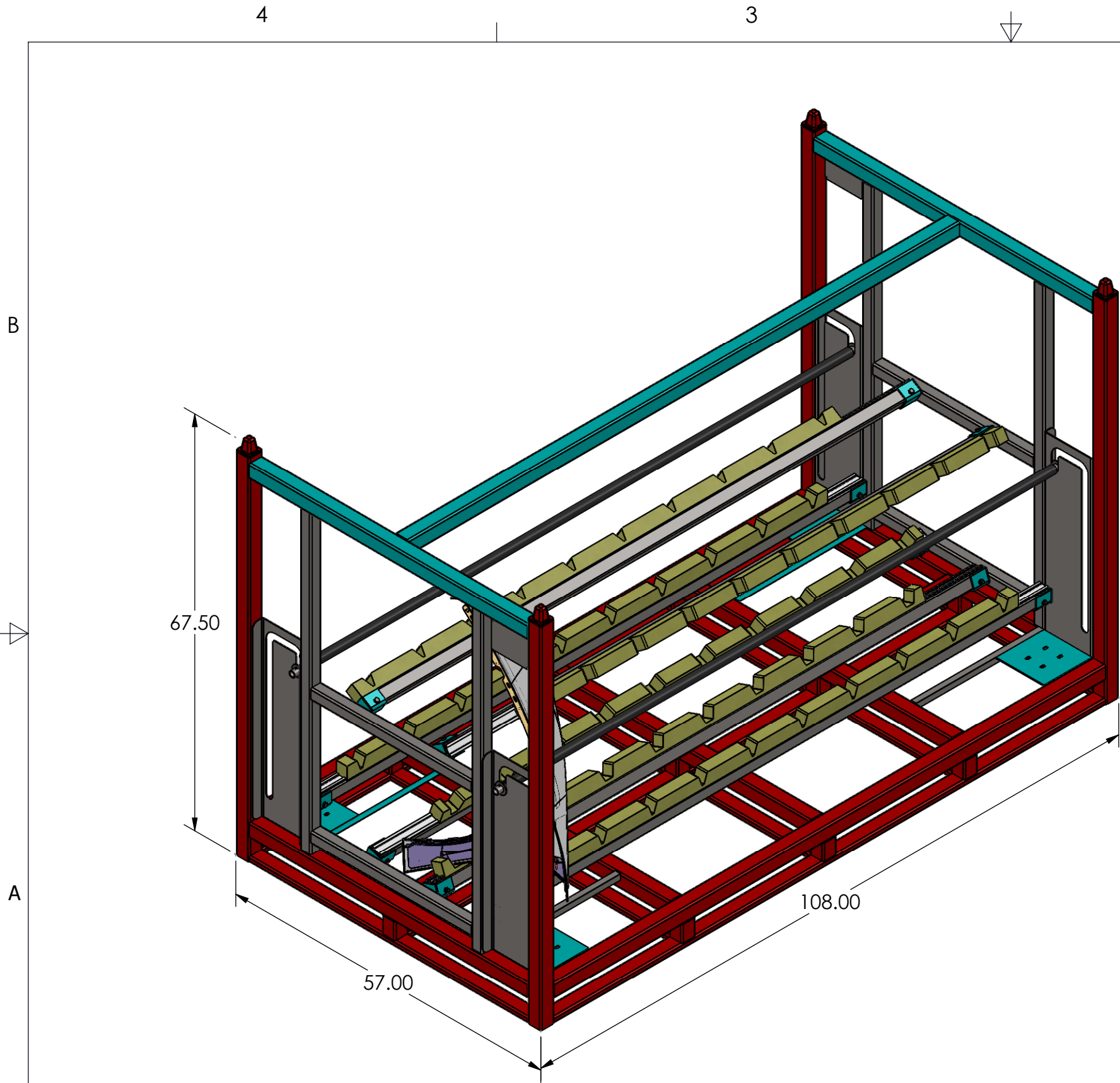
RH DOOR SORROUND WIP RACK SHOWN
LH DOOR SORROUND WIP RACK OPPOSITE
RACK SIZE - 96 X 90 X 53
DENSITY - (10) PIECES PER RACK
RACK WEIGHT = 791 POUNDS



3RD ANGLE PROJ DIMENSIONS
ARE IN MILLIMETERS

PART MUST COMPLY WITH MATERIAL SPECIFICATION
WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH,
SAFETY AND THE ENVIRONMENT

CUSTOMER	REF FILE #:		
	PRODUCTION WIP RACK		
DESIGN PSS	PART NAME RH DOOR SORROUND		
ENGINEER	DATE 8-3-2017	REV 004	SHOWN
SCALE N/A	DIVISION AUTOMOTIVE	PLANT	SHT 1 OF 14



* * * RH RACK SHOWN LH RACK SYMMETRICALLY OPPOSITE * * *

CONFIDENTIAL: THIS DRAWING IS PROPERTY OF

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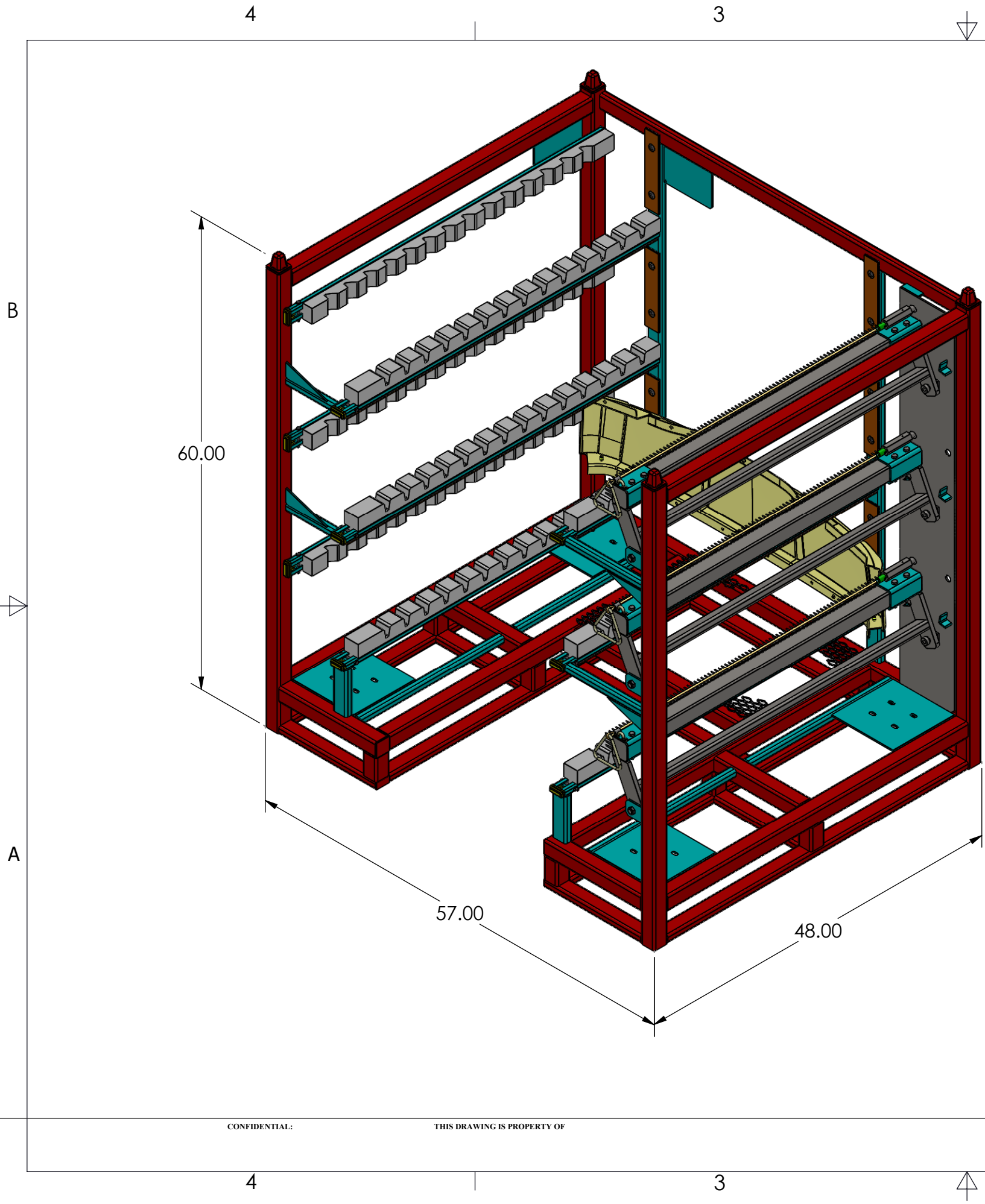
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- .0 ± 0.12 X ± 1.0
- .00 ± 0.06 X.X ± 0.5
- .000 ± 0.03 X.XX ± 0.1

DRAWN	DS	10/14/17	RH FENDER BONDED AND OUTER			
CHECKED						
QA						
MFG						
APPROVED						
			SIZE B	DWG NO XX-XXX		REV
			SCALE	SHEET 1 OF 17		



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INSPECTION

- FIRST ARTICLE MUST BE MADE FROM PRODUCTION JIGS AND FIXTURES.
- APPROVAL FOR PRODUCTION MUST BE IN WRITING FROM CUSTOMER.
- CRITICAL DIMENSIONS ARE DEFINED ON SHEETS. ASSEMBLY OF THESE CRITICAL DIM'S ARE TO BE INSPECTED WITH OTHER SPECIFICATION DEFINED BY THE CUSTOMER. SUPPLIER MUST KEEP RECORDS OF INSPECTION WITH SAMPLING 10% MINIMUM.
- ANY VARIATIONS OF SPECIFICATIONS AND/OR MATERIAL MUST HAVE WRITTEN APPROVAL FROM CUSTOMER.
- ALL MATERIALS SUPPLIED BY CUSTOMER ARE THE PHYSICAL RESPONSIBILITY OF SUPPLIER. SUPPLIER MUST INSPECT AND COUNT MATERIAL UPON ARRIVAL AND CONFIRM PHYSICAL COUNTS TO CUSTOMER VIA FAX OR E-MAIL. THIS CONFIRMATION ACKNOWLEDGES THE COUNTS FOR GOODS ARE CORRECT. SUPPLIER IS RESPONSIBLE FOR MISPLACED OR DAMAGED MATERIAL CREATED BY THE FABRICATION OR ASSEMBLY OF THE CONTAINER.

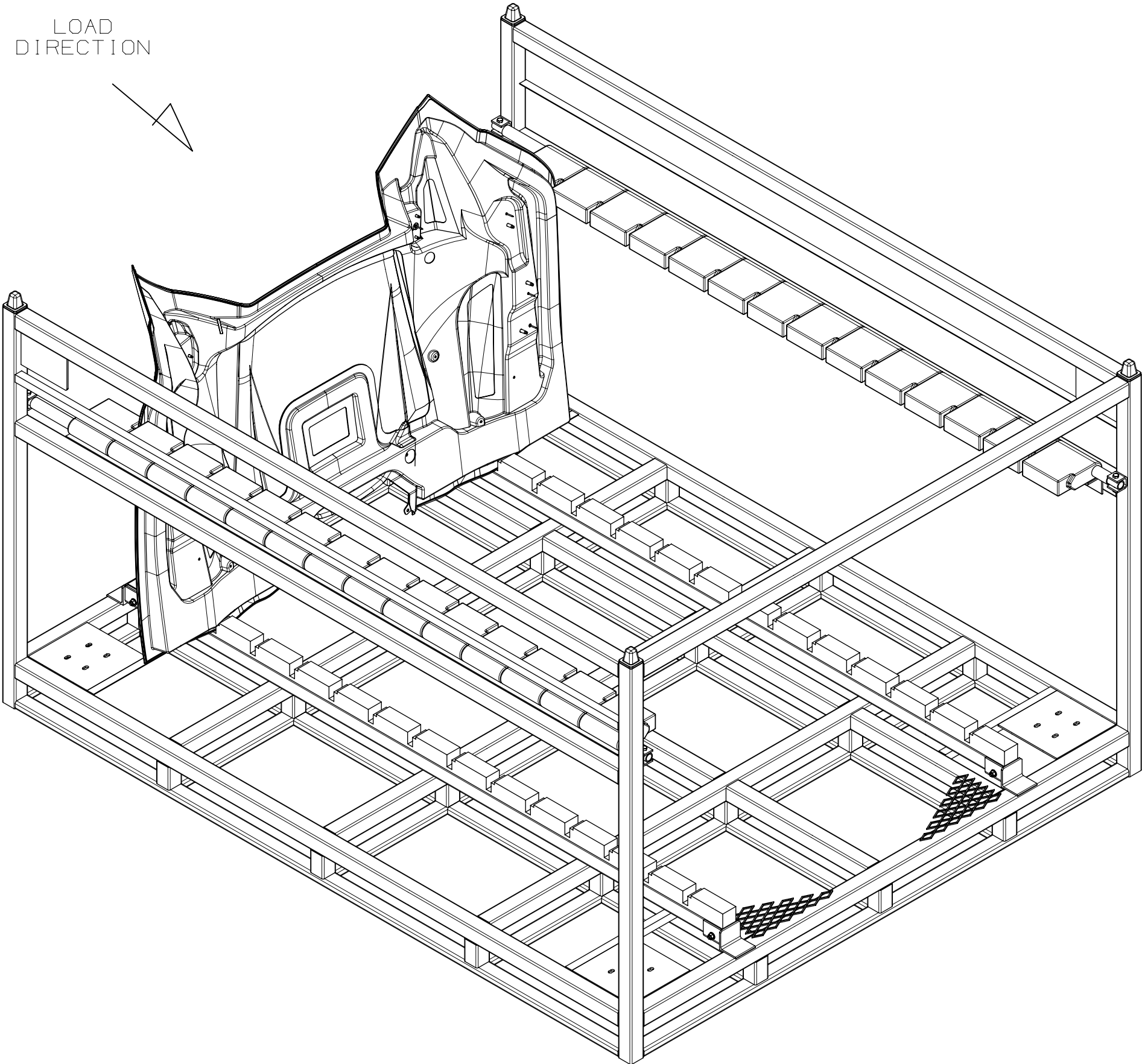
TOLERANCES

STANDARD TOL. ± DECIMALS ANGLES
.0 ± 0.12 X ± 1.0
.00 ± 0.06 X.X ± 0.5
.000 ± 0.03 X.XX ± 0.1

RACK TARE WGT. 500 lbs.
OVERALL RACK DENSITY 42 PARTS/RACK

DRAWN DS	11/28/17	ROOF BOW ASSY		
CHECKED				
QA				
MFG				
APPROVED				
		SIZE B	DWG NO XX-XXX	REV
		SCALE		
		SHEET 1 OF 17		

CONFIDENTIAL: THIS DRAWING IS PROPERTY OF



LOAD
DIRECTION

WELDING

- ALL WELD JOINTS TO BE CONTINUOUS 3/16" FILLET TYPE UNLESS OTHERWISE SPECIFIED.
- LOCKS ARE TO BE DISASSEMBLED PRIOR TO WELDING.
- ANY CONTINUOUS WELDS GREATER THAN 6" SHOULD REFER TO WELDING NOTE OR DESIGN SOURCE.
- PRODUCTION RACKS MUST BE COMPLETELY FREE OF WELD SPLATTER, SHARP EDGES, BURRED EDGES, RUSTED OR RUSTING AREAS ON RACK, PRIOR TO FINAL DELIVERY.

PAINT

- PAINT COLOR: -SEE TABLE-
- FABRICATION SHOULD BE OIL FREE PRIOR TO PAINTING.
- ALL STAINLESS/GALANIZED STEEL SHOULD BE MASKED PRIOR TO PAINT.
- DUNNAGE OR AREAS CONTACTING COMMODITY CONTAINER IS CARRYING SHOULD BE PAINT FREE.
- PAINT QUALITY IS TO MINIMIZE DRIP OR RUNS.
- COAT THICKNESS SHOULD BE SO THERE IS NO "BLEED THRU" OF FABRICATION.

FASTENERS/SPRING PINS

- VENDER TO USE GRADE "8" HEX HEAD CAP SCREW AND GRADE "C" PREVAILING TORQUE HEX NUT.
- ALL OTHER GRADE FASTENERS ARE UNACCEPTABLE UNLESS OTHERWISE SPECIFIED ON THE PRINT.
- ALL SCREWS, NUTS, WASHERS, ETC ARE TO BE ZINC PLATED.
- FASTENERS SHOULD BE FREE OF PAINT.
- GREASE ALL ZERK FITTINGS AFTER ASSEMBLY AND BEFORE SHIPPING.
- GAS SPRINGS ARE TO BE "ROD DOWN" UNLESS OTHERWISE SPECIFIED.

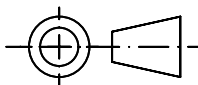
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TOLERANCES

STANDARD TOL. ±	DECIMALS	ANGLES
.0	± 0.12	X ± 1.0
.00	± 0.06	X.X ± 0.5
.000	± 0.03	X.XX ± 0.1

NOTE :
RACK SIZE = 96"X 78"X 54"
(13) PARTS PER RACK
EMPTY RACK WEIGHT = 615 POUNDS

 3RD ANGLE PROJ DIMENSIONS ARE IN MILLIMETERS			
PART MUST COMPLY WITH MATERIAL SPECIFICATION WSS-M99P9999-A1 TO HELP SAFEGUARD HEALTH, SAFETY AND THE ENVIRONMENT			
CUSTOMER	REF FILE #: PRODUCTION WIP RACK		
DESIGN PSS	PART NAME OUTER & BONDED		
ENGINEER	DATE 8-3-2017	REV 002	SHOWN
SCALE N/A	DIVISION AUTOMOTIVE	PLANT	SHT 1 OF 10