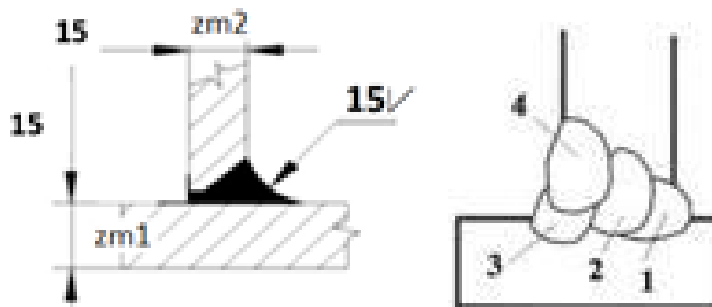


## Skoda Welding Test Instructions

Test welds for one welder during inspection

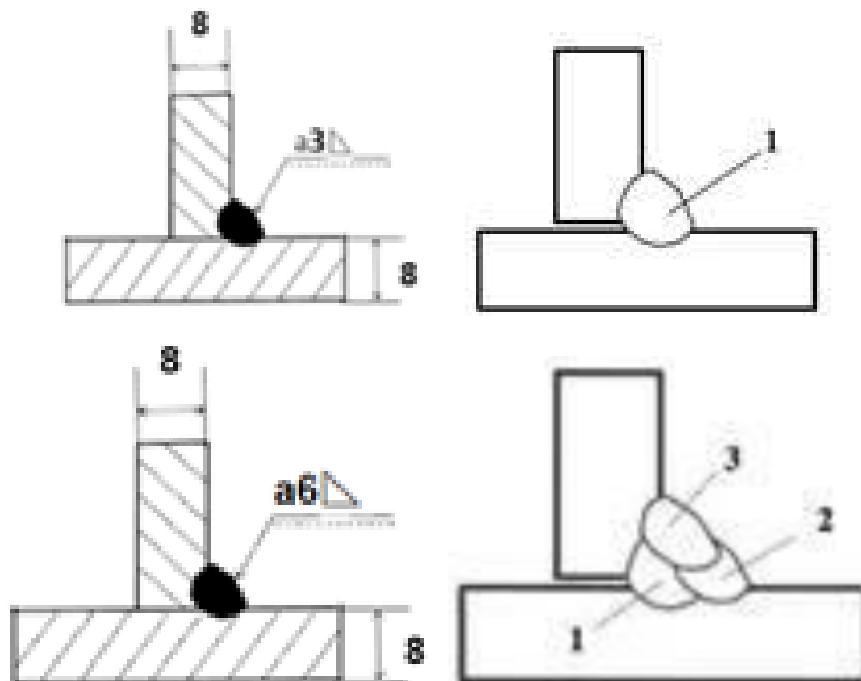
1. BW 15 ½V 15+15 PC – 1x sheet t.15mm 70x300 mm without bevel  
1x plate t.15mm 70x300 with a bevel of 50°



Keterangan:

Teknik pengelasan Butt Weld dengan menggunakan setengah fillet pengelasan pada kedua buah plat yang memiliki tebal 15 mm dengan posisi pengelasan PC (Untuk proses pengelasannya dimulai dari pembuatan root, pengisian dan penutup)

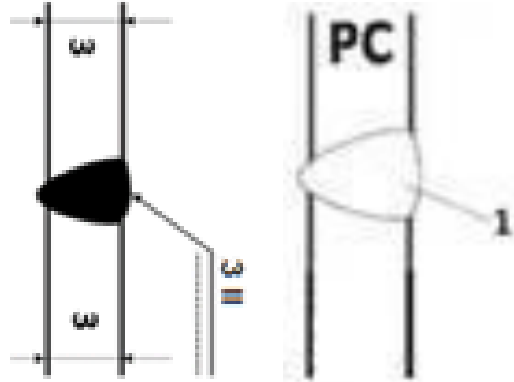
2. FW a3+ a6 8+8 PB – 2x sheet t.8 mm 70x300 without bevels



Keterangan:

Teknik pengelasan Fillet Weld pada kedua buah plat yang memiliki tebal 8 mm dengan posisipengelasan PB.

3. BW I13 3+3 PC - 2x sheet t.3 mm 70x300 without bevels



Keterangan:



Teknik pengelasan Butt Weld kedua buah plat sejajar yang memiliki tebal 3 mm dengan posisi pengelasan PC (Untuk proses pengelasannya dimulai dari pembuatan root, pengisian dan penutup)

## Locksmith Entrance Test

- 1) What experience do you have with blueprints? ( 1=none - 10=excellent )
- 2) What experience do you have with industrial adhesives? ( 1=none - 10=excellent )
- 3) What experience do you have with pressure pipe installation? ( 1=none - 10=excellent )
- 4) What experience do you have with assembly according to drawings? (1=none - 10=excellent )
- 5) What is your experience with riveting (rivet nuts)? ( 1=none - 10=excellent )
- 6) What experience do you have with bolted joints? ( 1=none - 10=excellent )
- 7) What experience do you have with tightening bolted connections? ( 1=none - 10=excellent )
- 8) What experience do you have in manual metalworking? ( 1=none - 10=excellent )

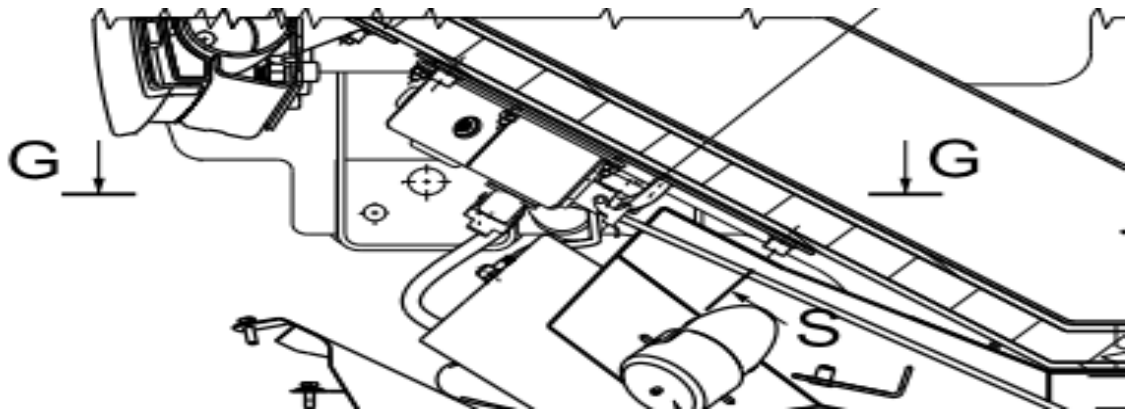
### Questions:

1. According to the attached picture, say:

Ind.	Pop. / Code	PŘEKRESLENO SE ZMĚNAMI A, NOVÁ POZICE 12.49.53, NOVÝ POHLED C1, NOVÝ ŘEZ S-S	RANIDA	ŠEPLAVÝ	10.11.2016
Ind.	Pop. / Code	Popis změny / Description of Change	Provedl/Issued	Schválil/ Appr.	Dot./Date
Norma Standard				Čistá hm. kg Mass netto	52,46
Položka Raw Product				Hrubá hm. kg Mass brutto	
Materiál výchozí Default material			Materiál konečný Final material		
TDP Tech. Dejt./v. Cond.				Skupina Group	
	Tolerance/Tolerance ISO 8015 EN ISO 13920 BF ISO 2768 mK SN 01 4240-m EN ISO 9013-33		Neoznačené hrany Unmarked edges ISO 13715	Drsnost/Roughness ISO 1302:1978 Ra	SPG kód SPG code Výrob. fáze Prod. phase S
Vypracoval Drawn	JARKOVSKÝ	10.4.2015	Provedení Version	Typ Type	
Přezkoušel Checked	MÍKA T.	23.4.2015	Pozn. Note	Sestava/Assembly	
Schválil Approved	ŠEPLAVÝ	23.4.2015			
Formát / Size	A1_0	Měr. / Scale	1:5	List / Sheet No.	1
				Listů / Sheets	2
Název Title PÍSKOVÁNÍ NA SKŘÍNI-KR. PODV.					
			Číslo výkresu / Drawing No. DO575582		Index b

- a) How many drawings does the assembly consist of?
- b) Where can you find the drawing number and title?
- c) What is the index on the drawing?
- d) What and where do I find the scale and what does it mean?

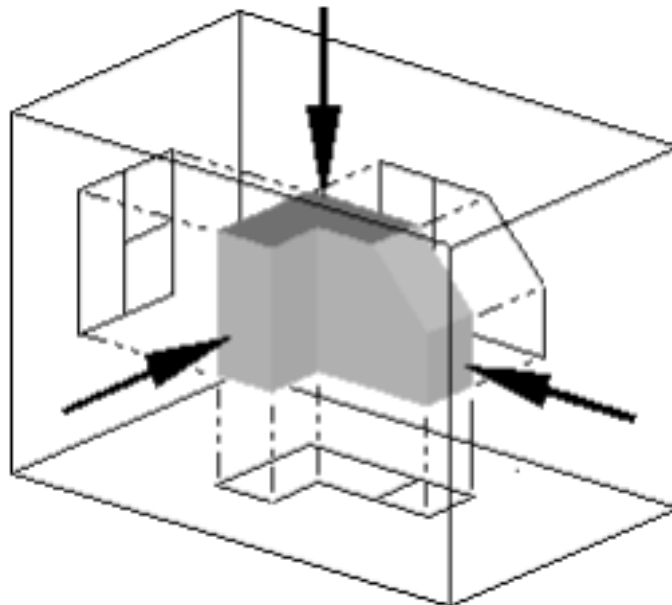
2. According to the attached picture, say:



a) What do you call what is between the letters G-G?

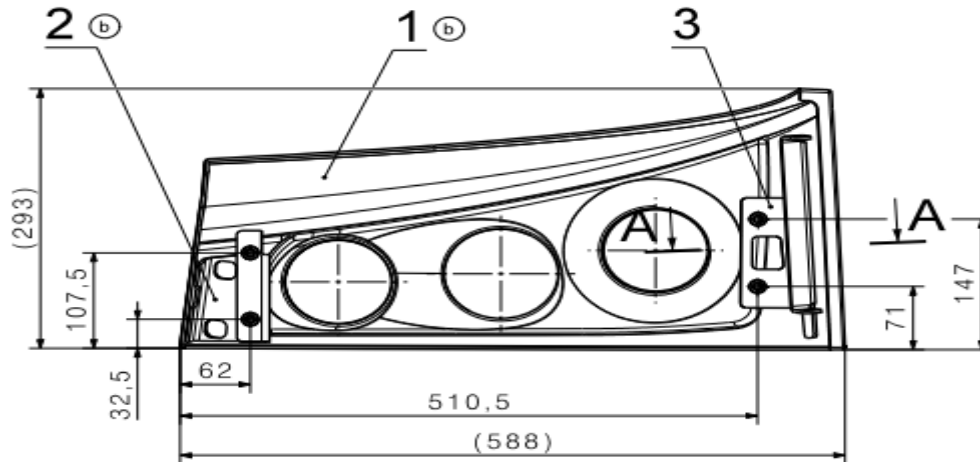
b) What does the arrow by the letters G-G mean?

3. According to the attached picture write to the arrows where is: a) outline, b) floor plan, c) side plan



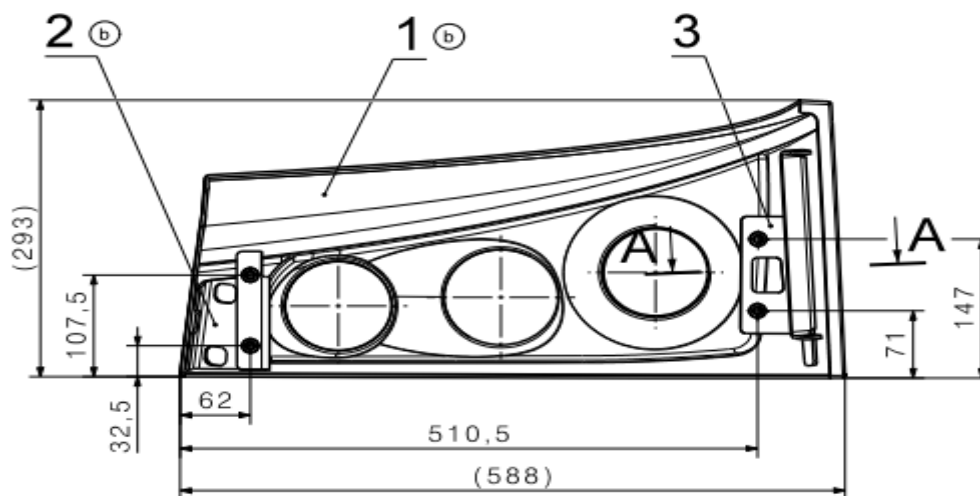
#### 4. What do the dimensions in brackets mean?

- a) the dimension must be respected
- b) the dimension does not have to be observed, it can be any dimension
- c) the dimension does not have to be exact, but can vary, e.g. by 1mm on each side



#### 5. What do the dimensions without brackets mean?

- a) the dimension must be observed
- b) the dimension does not have to be observed, it can be any dimension
- c) the dimension does not have to be exact, but can vary, e.g. by 1mm on each side



**6. Choose the correct answer:**

What is a threaded eyelet used for:

- a) To cut external threads
- b) To cut internal threads
- c) To cut internal and external threads



**What taps are used for:**

- a) To cut external threads
- b) To cut internal threads
- c) To cut internal and external threads



**7. Match the correct option to the picture:**

(a) Punch



b) Gatekeeper



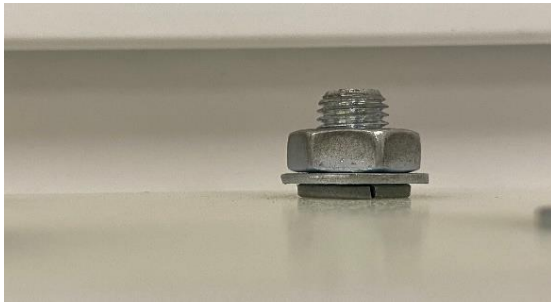
c) Threaded eyelet holder



d) Taper recess



8. Which of the pictures of the screw connection is correct and why?



9. Use the tables to determine the correct tightening torque:

7.3. **Mosazné, bronzové a měděné šroubové spoje a spoje z Al slitin** (Dle VDI 2230)

Závit	Utahovací moment v Nm	Závit	Utahovací moment v Nm	Závit	Utahovací moment v Nm
M2	0,2	M 7	8	M 20	204
M2,5	0,4	M 8	12	M 22	282
M3	0,7	M 10	24	M 24	260
M3,5	1	M 12	42	M 27	520
M 4	1,5	M 14	68	M 30	700
M 5	3	M 16	106	M 33	960
M 6	5	M 18	146	M 36	1240

7.4. **Plastové šroubové spoje** (Dle MARYLAND METRICS)

Šroubové spoje, kde min. jeden závit je v plastu s výjimkou kabelových průchodek			
Závit	Utahovací moment (Nm)	Závit	Utahovací moment (Nm)
M 2	0,1	M 6	2,5
M 2,5	0,2	M 8	5
M 3	0,3	M 10	8
M 3,5	0,5	M 12	13
M 4	0,8	M 14	20
M 5	1,5	M 16	32

- a) Brass bolt M10 .....Nm
- b) Plastic screw M16 .....Nm
- c) Copper screw M3,5 .....Nm
- d) Bronze screw M6 .....Nm