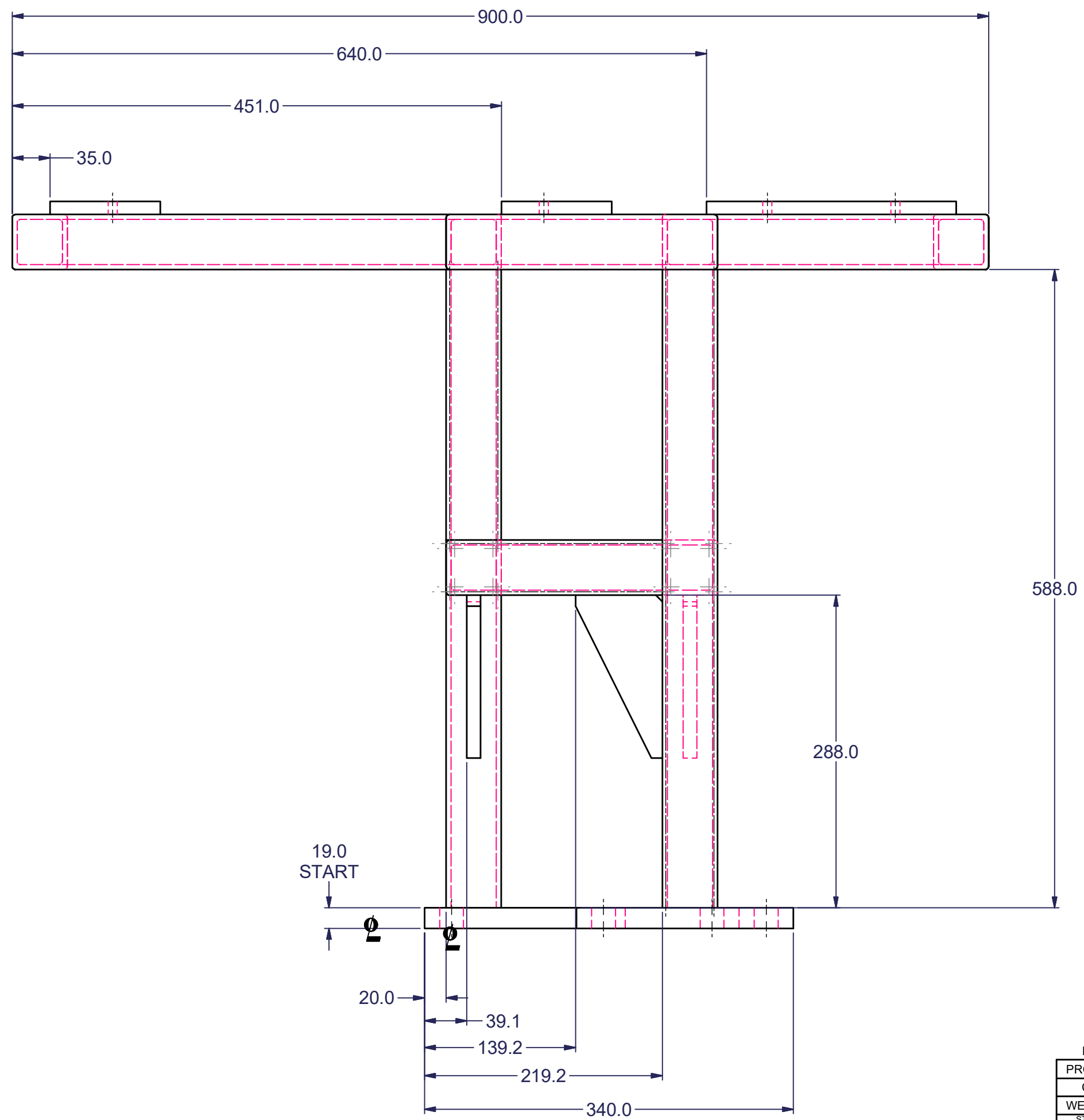


Stock List			
ITEM	QTY	MATERIAL	DESCRIPTION
a	1	HR-HRS	1/2" x 200.0mm x 230.0mm LG
b	1	HR-HRS	1/2" x 102.0mm x 270.0mm LG
c	1	HR-HRS	1/2" x 102.0mm x 270.0mm LG
d	4	HR-HRS	1/2" x 80.0mm x 150.0mm LG
e	2	SQ TUBE	2" x 2" x 3/16" x 900.0mm LG
f	2	SQ TUBE	2" x 2" x 3/16" x 250.0mm LG
g	3	SQ TUBE	2" x 2" x 3/16" x 588.0mm LG
k	1	SQ TUBE	2" x 2" x 3/16" x 274.0mm LG
m	1	HR-HRS	3/4" x 210.0mm x 290.0mm LG
n	1	HR-HRS	3/4" x 127.0mm x 200.0mm LG
p	1	SQ TUBE	2" x 2" x 3/16" x 250.0mm LG
q	1	SQ TUBE	2" x 2" x 3/16" x 250.0mm LG
r	1	SQ TUBE	2" x 2" x 3/16" x 200.0mm LG
s	1	SQ TUBE	2" x 2" x 3/16" x 150.0mm LG
t	2	SQ TUBE	2" x 2" x 3/16" x 250.0mm LG
u	2	SQ TUBE	2" x 2" x 3/16" x 185.0mm LG
v	2	SQ TUBE	2" x 2" x 3/16" x 140.0mm LG
0351	1	W/C	BRACKET SUPPORT



ONLY FOR MANUFACTURING	
PROCESS	STATUS
CUT	
WELDING	
STRESS RELIEVE	
MACHINING	
PAINT	

COSMA INNOVATIVE MANUFACTURING SOLUTIONS

REV	CHANGE	CHKD	DATE

THIS DRAWING MAY USE BOTH INCH AND METRIC UNITS OF MEASUREMENT (INDICATES INCH DIMENSIONS)

MAXIMUM ALLOWANCE ROUGHNESS OF ALL METRIC:

1 PLACE: mm FINISH DIMENSIONS TO BE 3.2 MICRONS
2 PLACE: mm FINISH DIMENSIONS TO BE 1.6 MICRONS
3 PLACE: mm FINISH DIMENSIONS TO BE 0.8 MICRONS
ALL GROUND SURFACES TO BE 0.4 MICRONS.
METRIC - EXCEPT AS NOTED TOLERANCES SHALL BE:
1 PLACE: MACHINING: 0.3
1 PLACE: FABRICATION: 1.5
2 PLACE: 0.08 BETWEEN MACHINED SURFACES
0.03 BETWEEN SINGLE DOWEL AND A HEEL SURFACE
0.03 BETWEEN DOWELS IN THE SAME PLANE
0.10 BETWEEN DOWELS IN DIFFERENT PLANES
0.13 TO SCREW HOLES: NON ACCUMULATIVE
ALL 0 SURFACES MUST BE FINISHED EXCEPT FOR COLD DRAWN SURFACES

ALL EDGES OF PART CONTACT SURFACES ON LOCATING BLOCKS AND FINGERS TO HAVE: 12R INCH / 3.00 mm AFTER SPOTTING.

MARK IDENTIFICATION AND MATERIAL NUMBERS ON DETAILS.
PAINT IDENTIFICATION NUMBERS ON STRUCTURAL WORK.

CRITICAL FEATURES ARE MARKED WITH "M"

WELDMENTS:
ALL WELD RILETS TO BE 1/4 INCH.
ALL "V" GROOVES TO BE 90° EXCEPT AS SHOWN.
ADD VENT HOLES IN ALL WELDMENTS WHERE TRAPPED AIR IS A POSSIBILITY. (E. TUBING CAPPED AT BOTH ENDS, BOXED FORMS ETC. SPOTFACE SCREW AND / OR BOLT HOLES WHEN CLEARANCE FOR SCREW AND / OR BOLT HEAD AND / OR WASHERS IS INFRINGED UPON BY WELD BEADS.

FOR BASES: APPLY CONTINUOUS WELDING AROUND OUTER SIDE. FOR SUPPORTS APPLY CONTINUOUS WELDING. ELIMINATE SCRAP AFTER WELDING. WELDMENT CONSTRUCTION MUST BE: STRESS RELIEVED BY NORMALIZED. WELDMENT CONSTRUCTION MUST BE MILLING AND DRILLING AFTER WELDING AND STRESS RELIEVED. APPLY MICRO WIRE WELD 0.45mm. WIRE DIAMETER BREAK SHARP EDGES

UNIT No.:	03
WEIGHT (KG):	N/A

COTO: COTO NUMBER	
<input type="checkbox"/> MOVIL PART RAL	THIS MATERIAL IS PROPERTY OF MAGNA COSMA. INTERNATIONAL RIGHTS ARE GRANTED TO USE SUCH MATERIAL FOR ANY PURPOSE OTHER THAN FURNISHING OF SERVICES AND SUPPLIES
<input checked="" type="checkbox"/> FIXED PART RAL	
<input type="checkbox"/> BLACK OXIDE	
<input type="checkbox"/> WITH OUT PAINT	
<input type="checkbox"/> POKA YOKO PAINT	

DESIGN SOURCE	BUILD SOURCE	CUSTOMER
MAGNA	MAGNA	FMX

DESIGNER	DETAILER	
F. ESCOBAR	KATMAR	

PROJECT MGR	DESIGN SUP.	CHECKER
F. ESCOBAR	F. ESCOBAR	F. ESCOBAR

SYSTEM NAME	
BEV3_RRC	

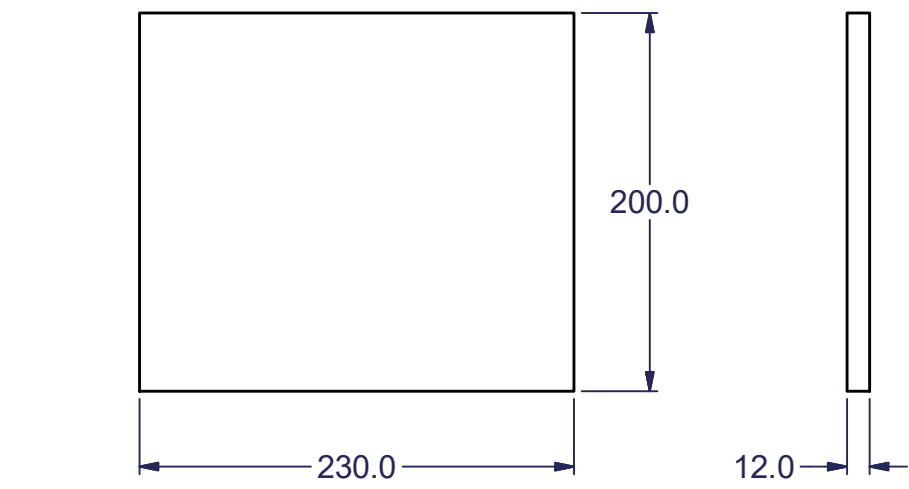
DESCRIPTION	
CRADLE	

SCALE	SHEET	RELEASE DATE
NONE	1 OF 2	3/1/2018

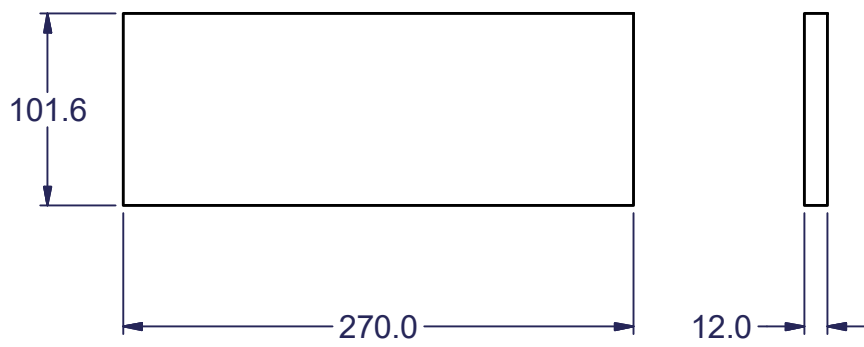
SHOWN	OPPOSITE
BEV3_RRC_ST019_Y-U03-0351-BSWCFW_Rev	

0351

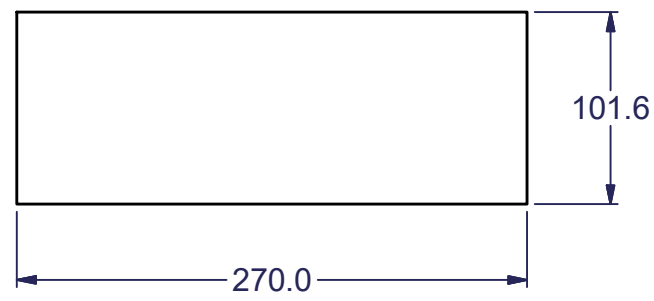
BRACKET SUPPORT
WELDED CONST. - STRESS RELIEVE



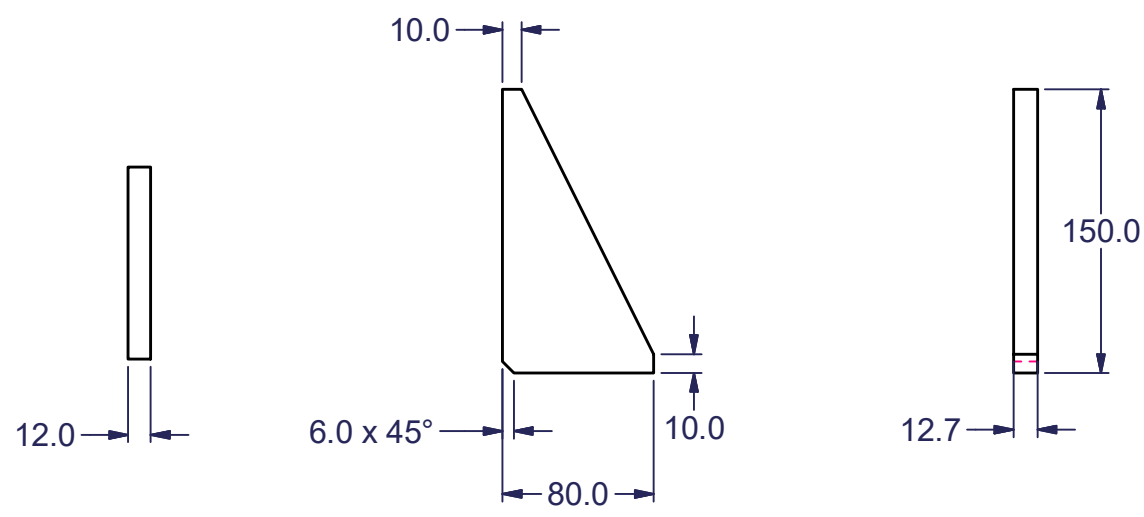
Item "a"



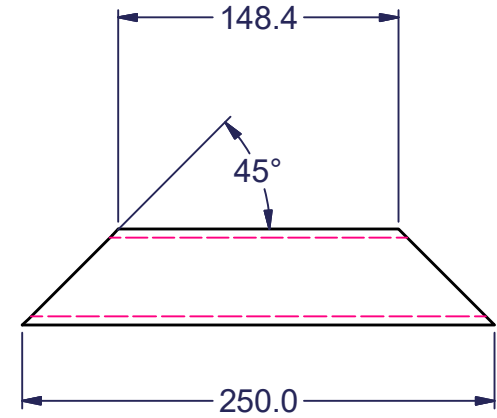
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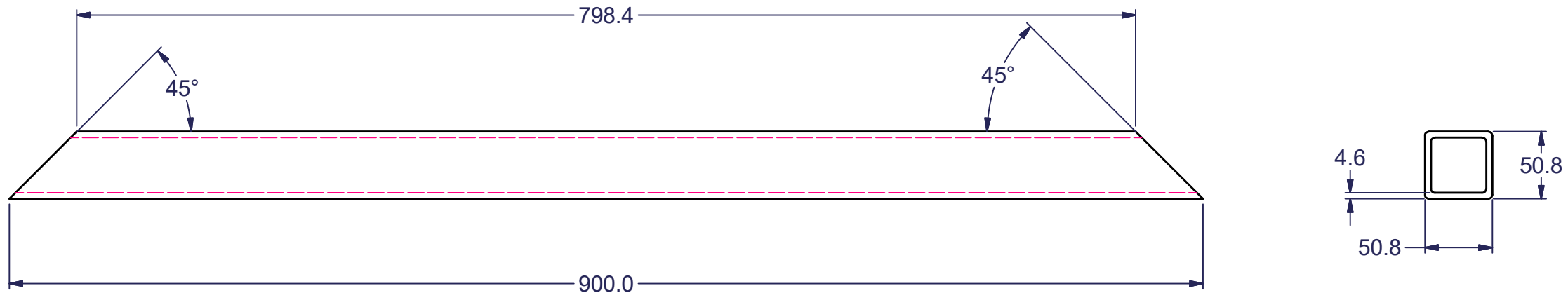
Item "c"



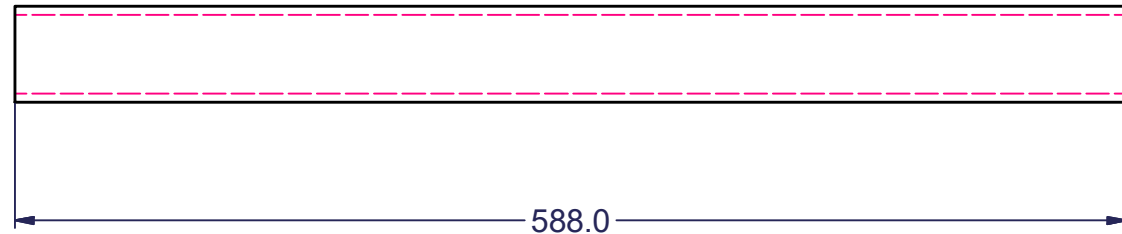
Item "d"



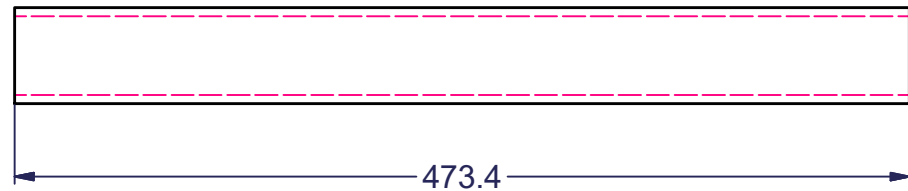
Item "f"



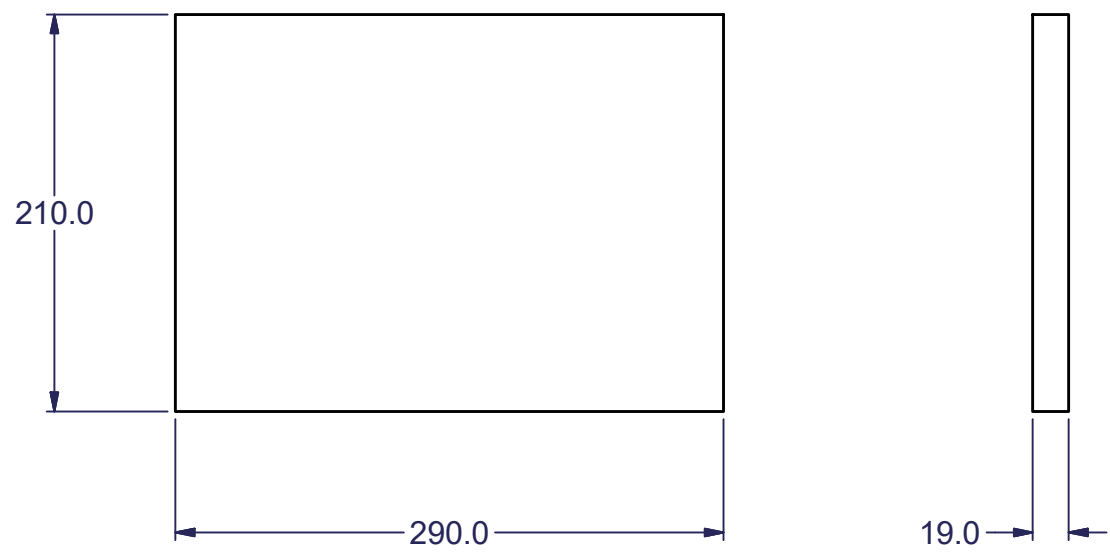
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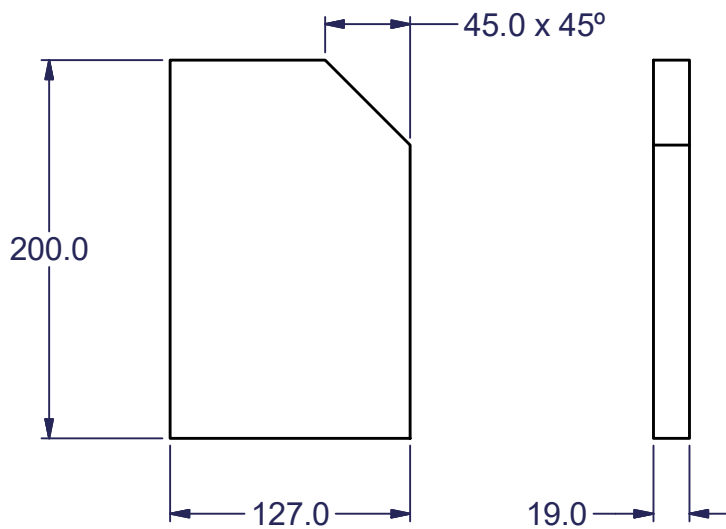
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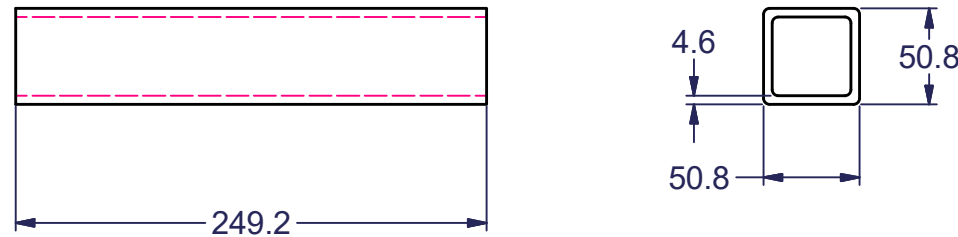
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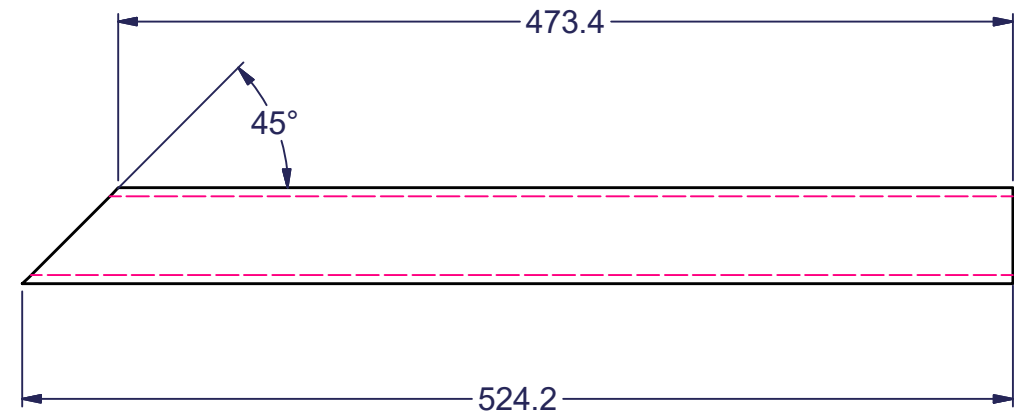
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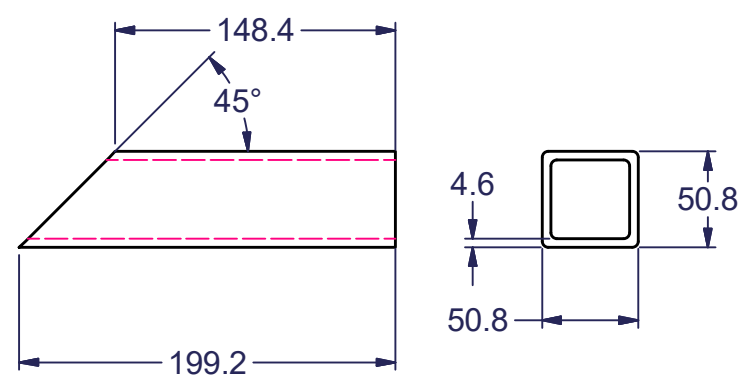
Item "n"



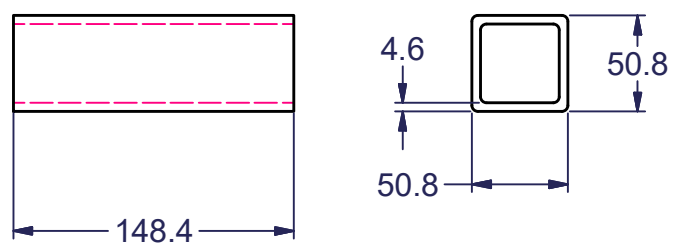
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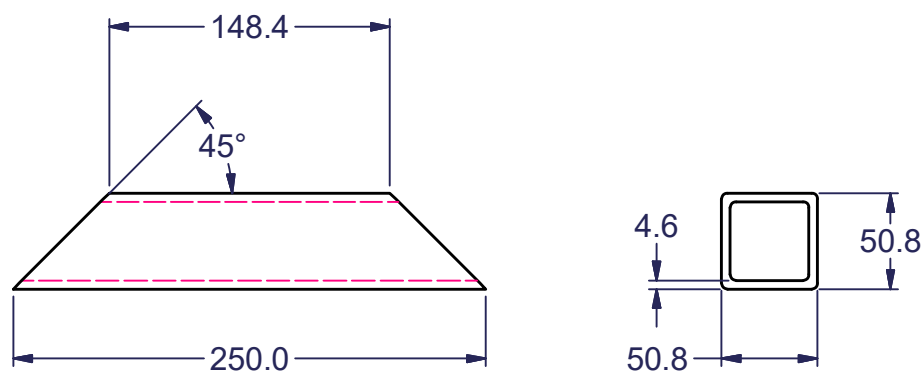
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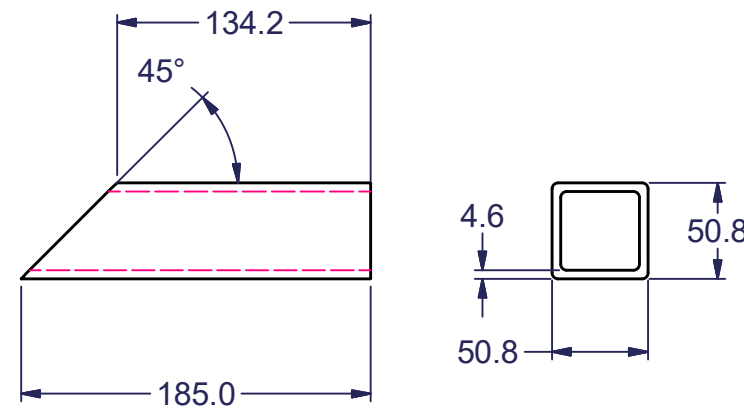
Item "r"



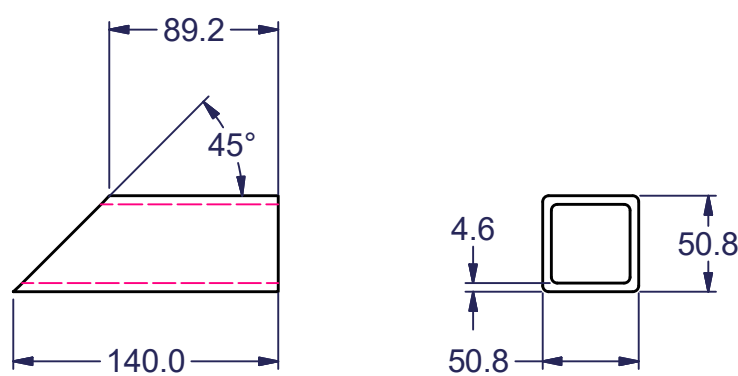
Item "s"



Item "t"



Item "u"



Item "v"

COSMA INNOVATIVE MANUFACTURING SOLUTIONS			
REV	CHANGE	CHKD	DATE
THIS DRAWING MAY USE BOTH INCH AND METRIC UNITS OF MEASUREMENT (*INDICATES INCH DIMENSIONS)			
MAXIMUM ALLOWANCE ROUGHNESS OF ALL METRIC:			
1 PLACE: mm FINISH DIMENSIONS TO BE 3.2 MICRONS			
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3 PLACE: mm FINISH DIMENSIONS TO BE 0.8 MICRONS			
ALL DIMENSIONS TO BE 0.4 MICRONS			
METRIC - EXCEPT AS NOTED TOLERANCES SHALL BE:			
1 PLACE: MACHINING: 0.3			
1 PLACE: FABRICATION: 1.5			
2 PLACE: 0.08 BETWEEN MACHINED SURFACES			
0.03 BETWEEN SINGLE DOWEL AND A HEEL SURFACE			
0.10 BETWEEN DOWELS IN THE SAME PLANE			
0.10 BETWEEN DOWELS IN DIFFERENT PLANES			
0.10 TO SCREW HOLES: NON ACCUMULATIVE			
ALL 0 SURFACES MUST BE FINISHED EXCEPT FOR COLD DRAWN SURFACES			
ALL EDGES OF PART CONTACT SURFACES ON LOCATING BLOCKS AND FINGERS TO HAVE: .12R INCH / 3.00 mm AFTER SPOTTING.			
MARK IDENTIFICATION AND MATERIAL NUMBERS ON DETAILS.			
PAINT IDENTIFICATION NUMBERS ON STRUCTURAL WORK.			
CRITICAL FEATURES ARE MARKED WITH "H"			
UNIT No.:		03	
WEIGHT (KG):		4.30 kg	
COTO: COTO NUMBER			
<input type="checkbox"/> MOVIL PART RAL			
<input checked="" type="checkbox"/> FIXED PART RAL			
<input type="checkbox"/> BLACK OXIDE			
<input type="checkbox"/> WITH OUT PAINT			
<input type="checkbox"/> POKA YOKE PAINT			
DESIGN SOURCE		BUILD SOURCE	CUSTOMER
MAGNA		MAGNA	FMX
DESIGNER	DETAILER	3RD ANGLE PROJECTION	
F. ESCOBAR	KATMAR		
PROJECT MGR	DESIGN SUP.	CHECKER	
F. ESCOBAR	F. ESCOBAR	F. ESCOBAR	
SYSTEM NAME			
BEV3_RRC			
DESCRIPTION			
CRADLE			
SCALE	SHEET	RELEASE DATE	
NONE	2 OF 2	3/1/2018	
SHOWN			
OPPOSITE			