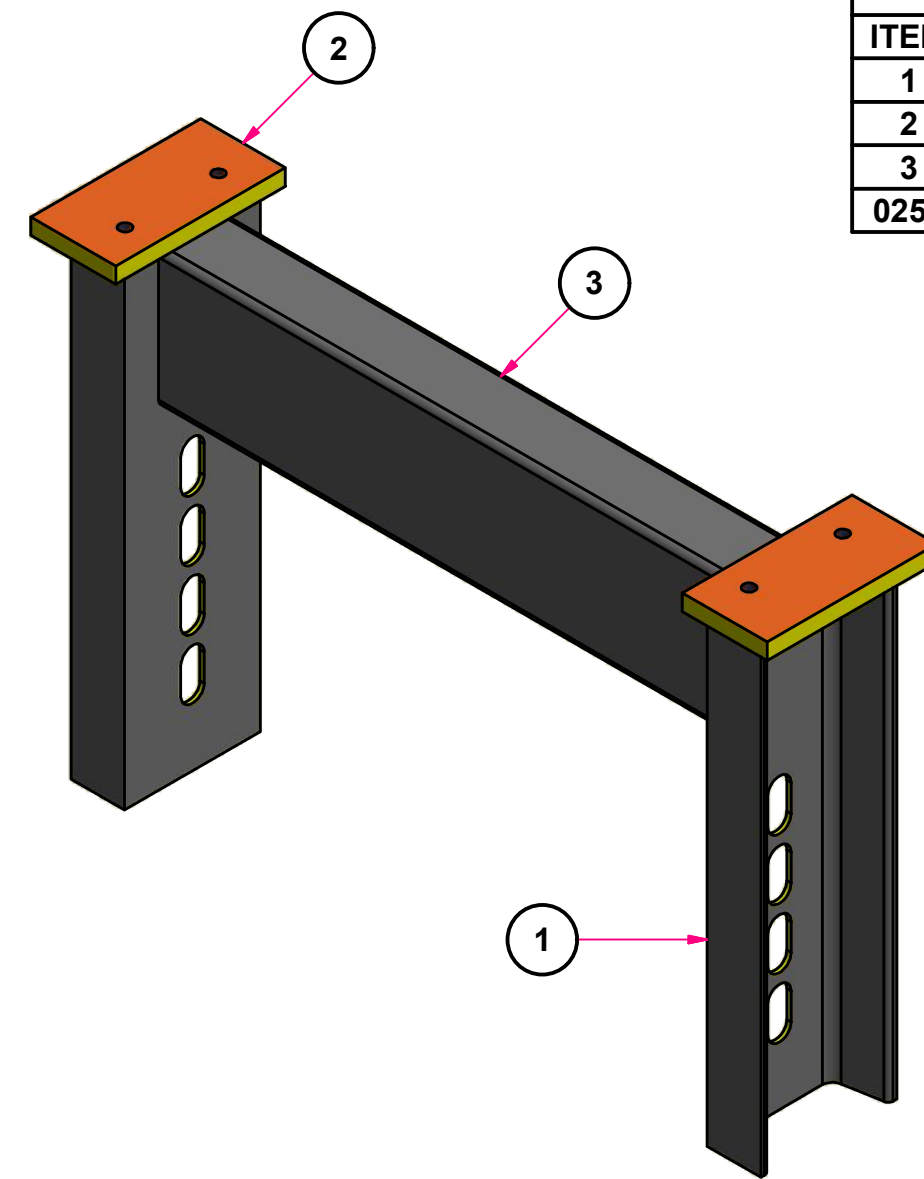
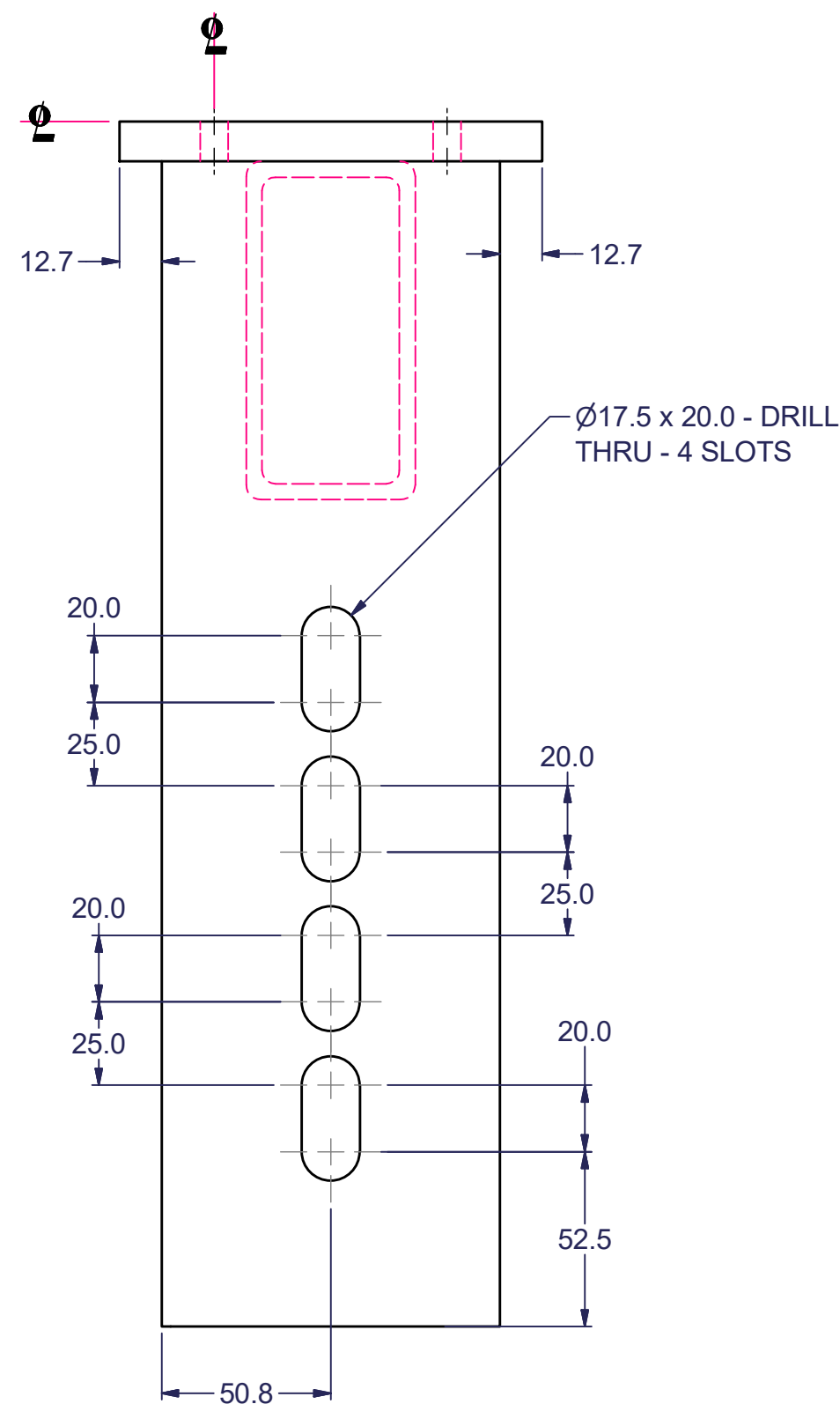
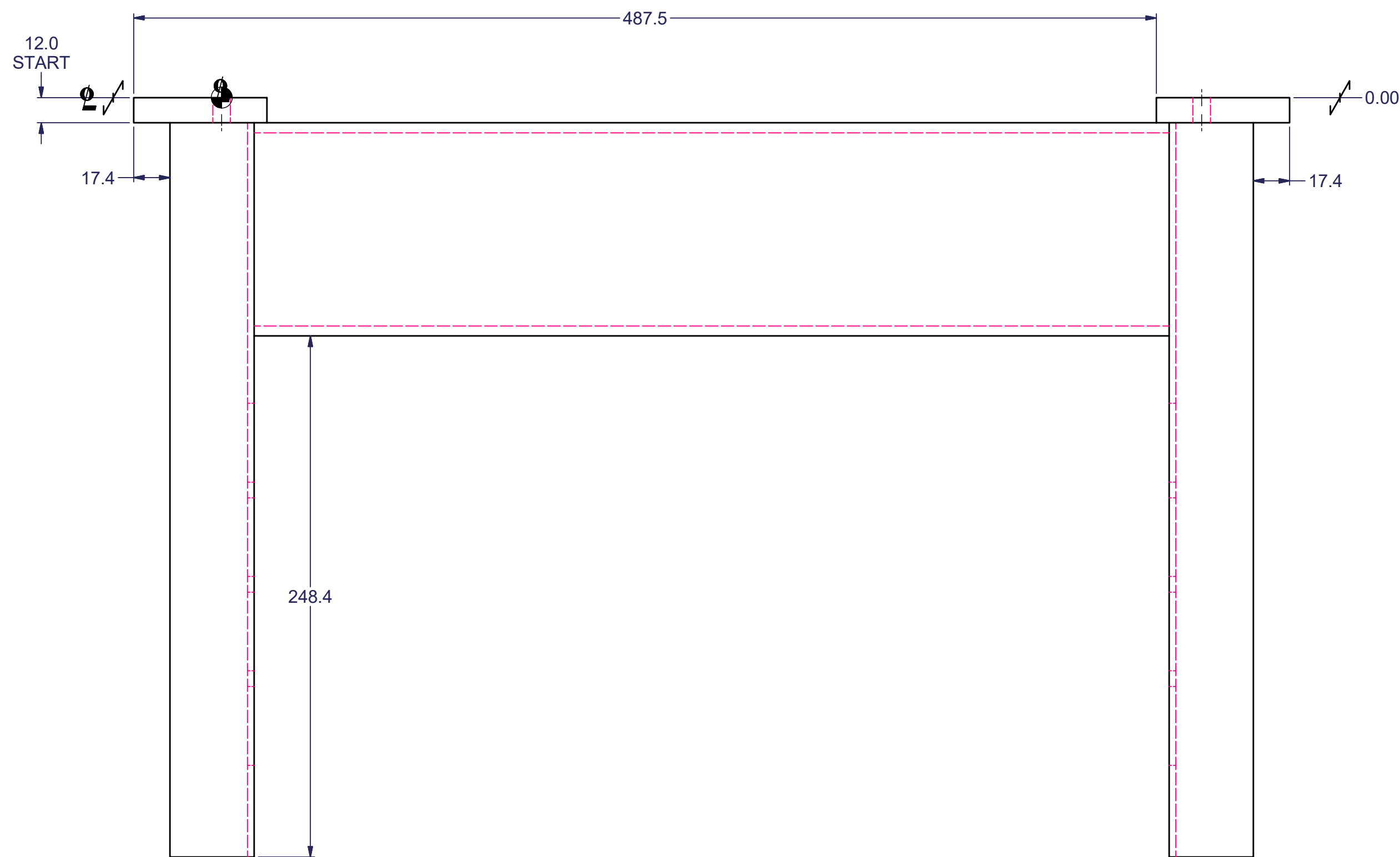
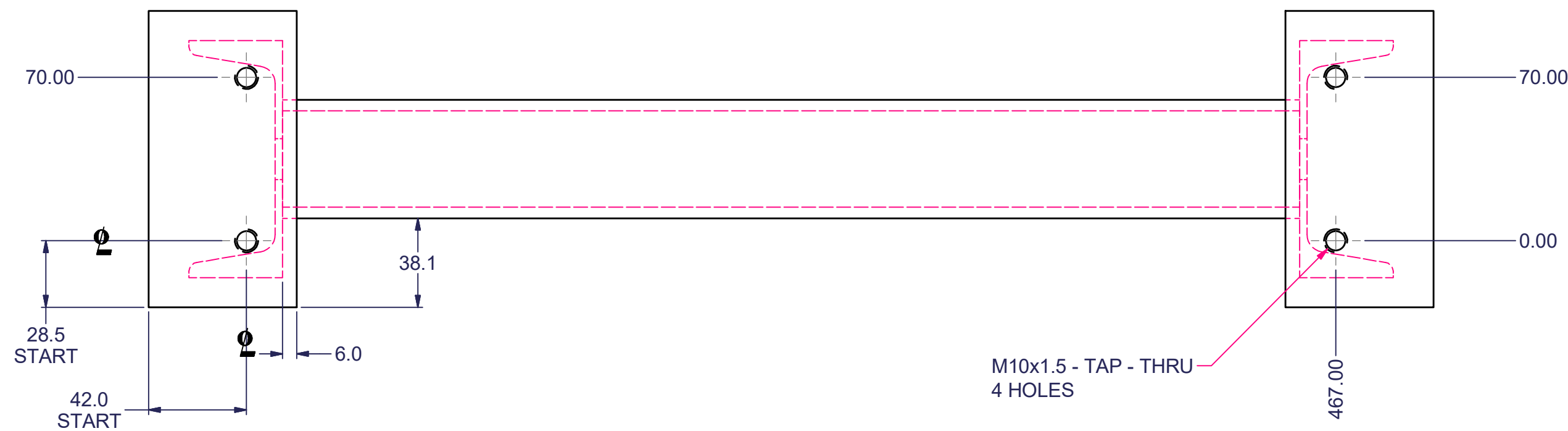


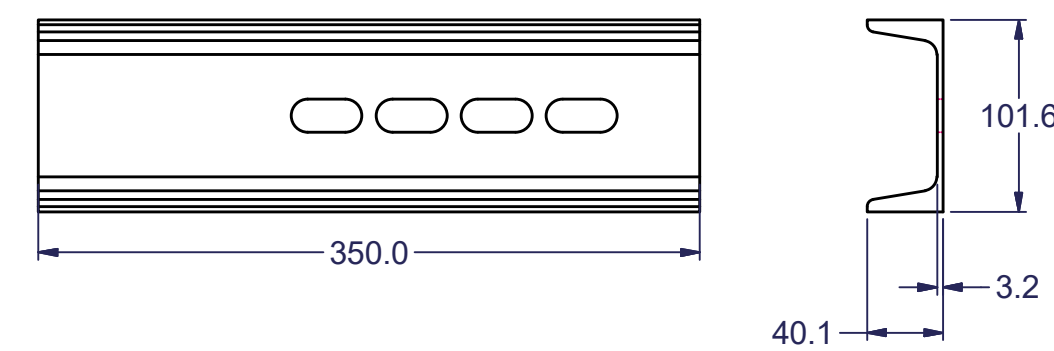
0252

BRACKET SUPPORT
WELDED CONST. - STRESS RELIEVE

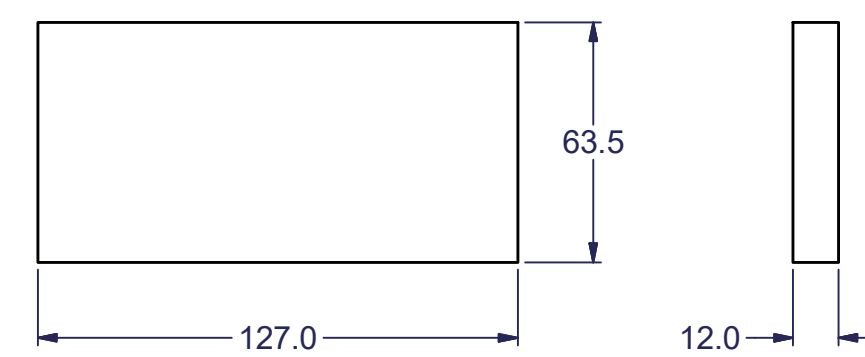


Stock List			
ITEM	QTY	MATERIAL	DESCRIPTION
1	2	HR-HRS	1 3/4" x 4" x 350.0mm LG
2	2	HR-HRS	1/2" x 2 1/2" x 5" LG
3	1	TUBE	2" x 4" x 3/16" x 440.0mm LG
0252	1	W/C	BRACKET SUPPORT

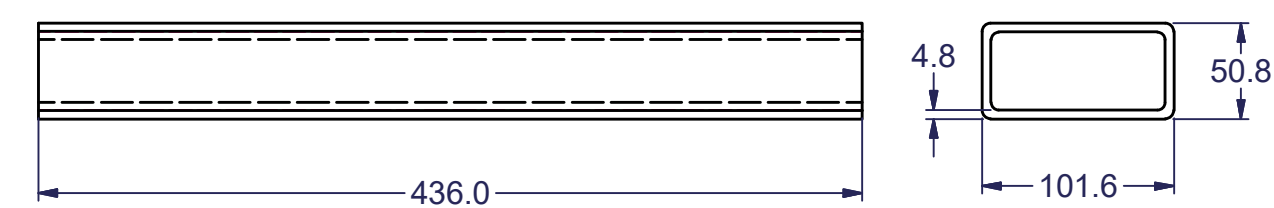
ITEM "a"



ITEM "b"



ITEM "c



COSMA INNOVATIVE MANUFACTURING SOLUTIONS			
REV	CHANGE	CHK'D	DATE

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

MAXIMUM ALLOWANCE ROUGHNESS OF ALL
MATERIALS

1 PLACE MIN FINISH DIMENSIONS TO BE 3.2 MICRONS
2 PLACE MIN FINISH DIMENSIONS TO BE 1.6 MICRONS
3 PLACE MIN 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 MANIPULATED SURFACES
0.05 BETWEEN DOWEL PINDED AND A HEEL SURFACE
0.03 BETWEEN DOWELS IN THE SAME PLANE
0.10 BETWEEN DOWELS IN DIFFERENT PLANES
0.10 TO SCREW HOLES, NON ACCUMULATIVE

ALL O SURFACES MUST BE FINISHED EXCEPT FOR COLD
DRAWN SURFACES.

ALL EDGES OF PART CONTACT SURFACES ON LOCATING
BUSHES AND FINGERS TO HAVE .12R INCH / 3.0mm
AFTER SPOTTING.

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

CRITICAL FEATURES ARE MARKED WITH "R"

WELDMENTS.



ALL WELD FILLETS TO BE 1/4 INCH.
ALL "V" GROOVES TO BE 30 DEGREE.


ADVENT HOOKS ALL SPOTWELDS WHERE TRAPPED
AND POSSIBLY, I.E. WHERE WELDED TO BOTH ENDS,
BOXED FORMS ALL SPOTWELD SCREW AND / OR BOLT
HOLES WHEN CLEARANCE FOR SCREW AND / OR BOLT
HEADS AND WASHERS IS REQUIRED UPON BY WELD BEADS.

FOR BASES, APPLY CONTINUOUS
WELDING AROUND OUTER SIDE. FOR SUPPORTS APPLY
CONTINUOUS WELDING ELIMINATE SCRAP AFTER WELDING.
CONTINUOUS WELDING CONSTRUCTION METHOD IS STRESS RELIEVED BY
NORMALIZED. WELDMENT CONSTRUCTION METHOD MUST BE MILLING
AND DRILL AFTER WELDING. DRILL DIA. 0.0005 INCHES
MICRO WELD DIA. 0.54mm. WIRE DIAMETER, BREAK SHARP EDGES

UNIT No.:	UNIT NUMBER
WEIGHT (KG):	11.53 kg

COTO: 202202	
<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	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

DESIGN SOURCE	BUILD SOURCE	CUSTOMER
		FORMEX

DESIGNER K. MAR	DETAILER K. MAR	 3RD ANGLE PROJECTION
PROJECT MGR. A. RANGEL	DESIGN SUP. E. TORRES	CHECKER E. TORRES
SYSTEM NAME		

	RRC
DESCRIPTION	BEV3

SCALE	SHEET	RELEASE DATE
NONE	1 OF 1	3/1/2018
NO. SHOWN	REV2 PRC ST018 X L102 0252 BSW/CEW	

DRAWING	BEV5_RRC_ST018_1-002-0252-BSWCFW
	OPPOSITE

Applica: CIMS EID: 08.1 VER: 4

ONLY FOR MANUFACTURING	
PROCESS	STATUS
CUT	
WELDING	
STRESS RELIEVED	
MACHINING	
PAINT	

[illegible]