

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
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 TOOLERANCES SHALL BE:

1 PLACE MACHINING 0.3
1 PLACE FABRICATION 1.5
2 PLACE 0.002 BETWEEN MACHINED SURFACES
0.003 BETWEEN SINGLE DOWEL AND A HEEL SURFACE
0.003 BETWEEN DOWELS IN THE SAME PLANE
0.002 BETWEEN DOWELS OF DIFFERENT PLANES
0.001 TO SCREW HOLES, NON ACCUMULATIVE
ALL O SURFACES MUST BE FINISHED EXCEPT FOR COLD
DRAWN SURFACES.

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

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


CRITICAL FEATURES ARE MARKED WITH **

WELDMENTS.

ALL WELD FILLETS TO BE 1/4 INCH
ALL "Y" GROOVES TO BE 1/8 INCH AS SHOWN
ADD FORM FILLS IN ALL WELDMENTS WHERE TRAPPED
OR, IF POSSIBLY, LEAVE UNFILLED TO BE STRESS RELIEVED
BOXED VENTS EXCEPT SPOTFACE SCREW AND / OR BOLT
HEADS WHEN CLEARANCE FOR SCREW AND / OR BOLT
HEADS AND / OR WASHERS IS REQUIRED UNDER WELD BEADS.

**FOR BASES APPLY CONTINUOUS
WELDING AROUND OUTER SIDE. FOR SUPPORTS APPLY
CONTINUOUS WELDING. ELIMINATE SCRAP AFTER WELDING.
CONTINUOUS CONSTRUCTION SHOULD BE STRESS RELIEVED
NORMALIZED. WELDMENT CONSTRUCTION MUST BE MILLING
AND TURNING AFTER WELDING. WELDING DIAMETER SHALL BE
MICRO WELD 0.4mm. WIRE DIAMETER BREAK SHARP EDGES**

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

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

DRAWING No.	SCALE NONE	SHEET 1 OF 1	RELEASE DATE 3/1/2018
	SHOWN BEV3_RRC_ST017_Y-U02-0252-BSWCWF OPPOSITE		

ONLY FOR MANUFACTURING	
PROCESS	STATUS
CUT	
WELDING	
STRESS RELIEVED	
MACHINING	
PAINT	

"ONLY FOR WELDMENTS"

1. THE WELDING APPLICATION MUST COMPLY WITH THE SPECIFICATION IN THE BOTTOM CHART

2. MUST INCLUDE VENTILATION HOLES IN ALL WELDS WHERE AIR IS "TRAPPED"

3. REQUIRED STRUTS RELIEVED PRESS IN THE WELDING AREA AFTER THE WELDING PROCESS AND

4. AFTER FINISHING OPERATIONS MUST BE PROVIDED

5. IS REQUIRED TO VISUAL REVIEW AND WITH PENETRATING LIQUID (CERTIFICATE MUST BE PROVIDED)

6. THE EXCEPTION FOR CONDITIONS DEFINED IN ITEM 5 IS THE CASES OF JOINTS SUBJECT TO DYNAMIC LOADS, STRUTS EXPOSED TO AGGRESSIVE ENVIRONMENTS OR TEMPERATURES LOWER THAN THE LONGITUDINAL JOINTS OF TWO PIECES CAN BE CARRIED OUT BY DISCONTINUED WELDING PER INDICATION OF THE BOTTOM CHART

1. PLATE WITH DOUBLE OVERLAP PLATE AND STRUTS

2. PLATE WITH DOUBLE OVERLAP PLATE AND STRUTS

3. WELDING PLATE TO MATCHING OR PLATE WITH DOUBLE OVERLAP PLATE AND STRUTS

4. PLATE WITH DOUBLE OVERLAP PLATE AND STRUTS

5. PLATE WITH DOUBLE OVERLAP PLATE AND STRUTS

6. PLATE WITH DOUBLE OVERLAP PLATE AND STRUTS

7. PLATE WITH DOUBLE OVERLAP PLATE AND STRUTS

8. PLATE WITH DOUBLE OVERLAP PLATE AND STRUTS

9. PLATE WITH DOUBLE OVERLAP PLATE AND STRUTS

10. PLATE WITH DOUBLE OVERLAP PLATE AND STRUTS

11. PLATE WITH DOUBLE OVERLAP PLATE AND STRUTS

12. PLATE WITH DOUBLE OVERLAP PLATE AND STRUTS