

Stock List				
ITEM	QTY	MATERIAL	DESCRIPTION	
a	2	HRS	3/4" x 100.0mm x 230.0mm LG	
b	2	HRS	1 3/4" x 3" x 3/8" x 440.0mm LG	
c	1	SQ TUBE	2" x 4" x 3/16" x 445.0mm LG	
0251	1	W/C	BRACKET SUPPORT	

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 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
0.03 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 "1"

WELDMENTS
ALL WELD FILLETS 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 (IE: TUBING CAPPIED 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):	13.19 kg

COTO: COTO NUMBER

☐ MOVIL PART RAL

☒ FIXED PART RAL

☐ BLACK OXIDE

☐ WITH OUT PAINT

☐ 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
MAGNA	MAGNA	FMX

DESIGNER	DETAILER	3RD ANGLE PROJECTION
F. ESCOBAR	KATMAR	
PROJECT MGR	DESIGN SUP.	CHECKER
F. ESCOBAR	F. ESCOBAR	F. ESCOBAR

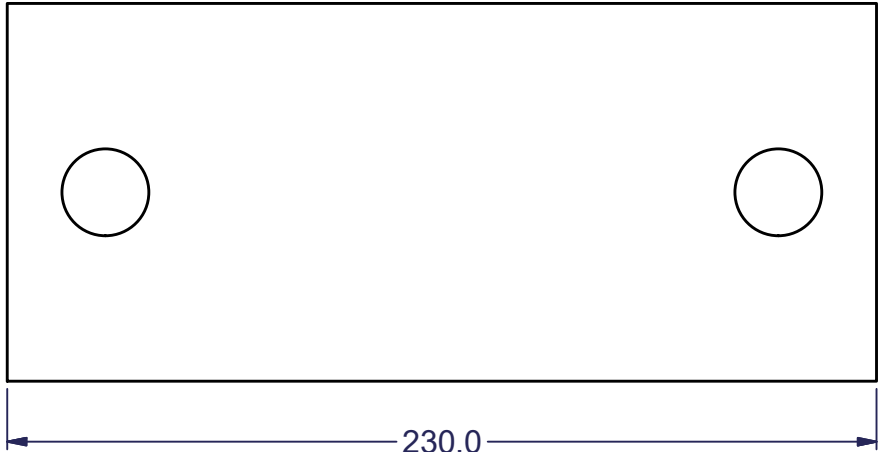
SYSTEM NAME	BEV3_RRC
DESCRIPTION	CRADLE

SCALE	SHEET	RELEASE DATE
NONE	1 OF 4	3/1/2018

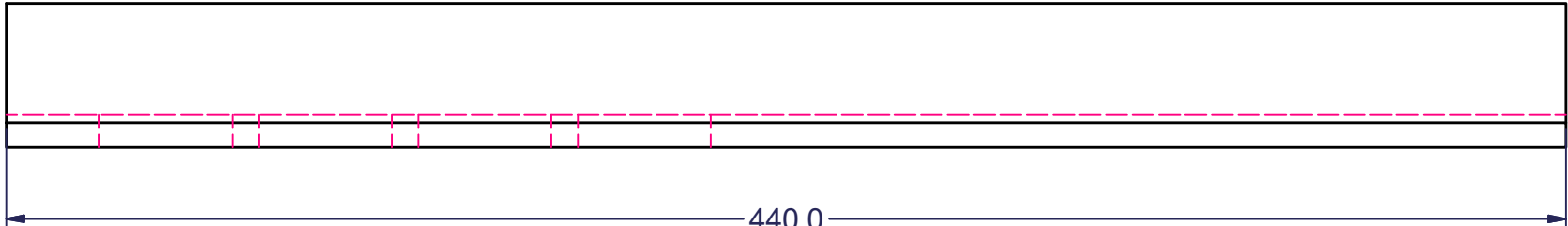
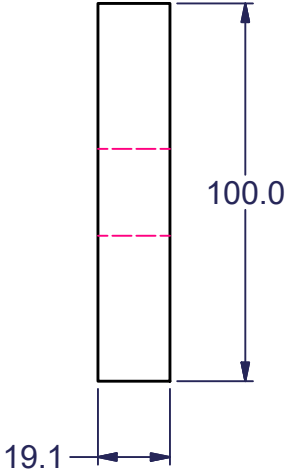
3	SHOWN
BEV3_RRC_ST018_Y-U02-0251-BSWCWF	OPPOSITE

ONLY FOR MANUFACTURING

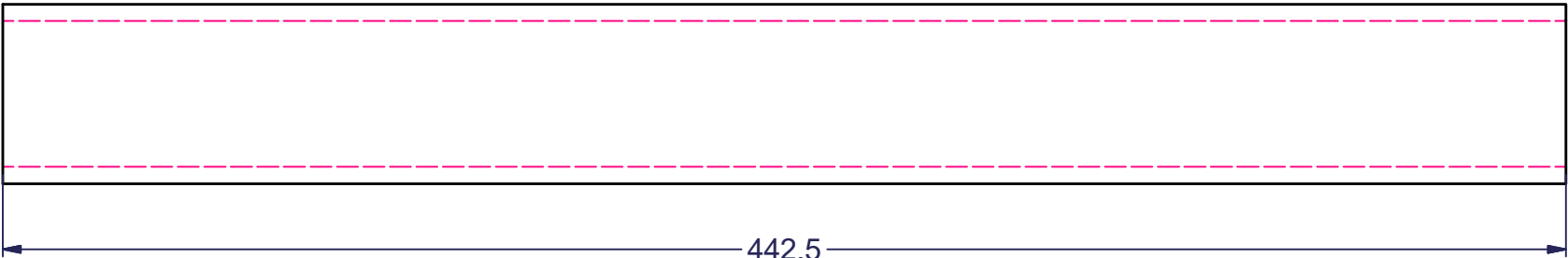
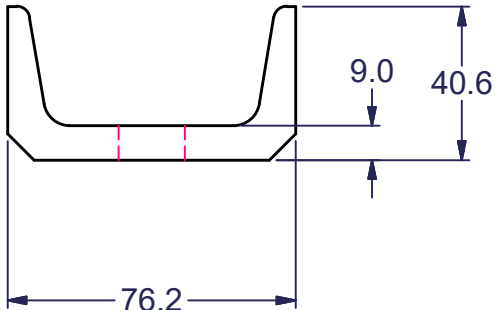
PROCESS	STATUS
CUT	
WELDING	
STRESS RELIEVED	
MACHINING	
PAINT	



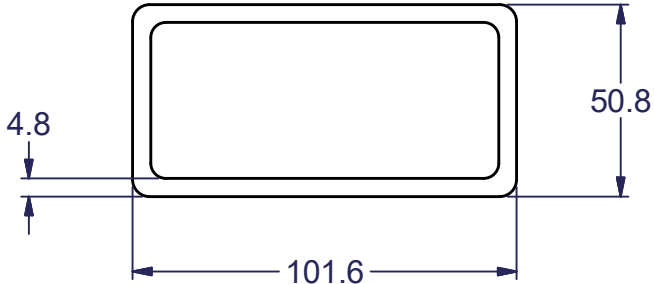
Item "a"



Item "b"



Item "c"



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REV	CHANGE	CHK'D	DATE
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CRITICAL FEATURES ARE MARKED WITH "*"			
UNIT No.:		03	
WEIGHT (KG):		0.42 kg	
COTO: COTO NUMBER			
<input type="checkbox"/> MOVIL PART RAL		THIS MATERIAL IS PROPERTY OF MAGNA COSMA INTERNATIONALNO RIGHTS ARE GRANTEDTO 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 YOKE PAINT			
DESIGN SOURCE		BUILD SOURCE	CUSTOMER
			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	2 OF 4	3/1/2018	
DRAWING	SHOWN		
	BEV3_RRC_ST018_Y-U02-0251-BSWCFFW-a		
OPPOSITE			