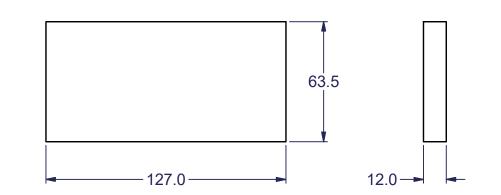


ITEM "b"



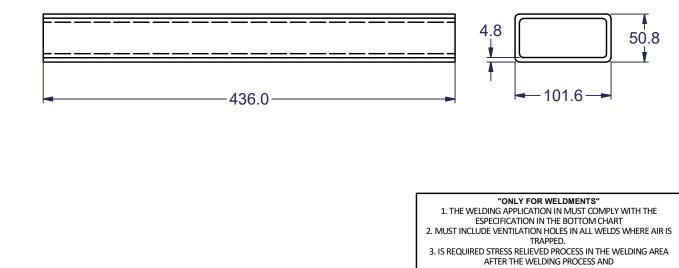
ITEM "c

AFTER MACHINING (CERTIFICATE MUST BE PROVIDED)

4. IS REQUIRED TO VISUAL REVIEW AND WITH PENETRATING LIQUIDS.

(CERTIFICATE MUST BE PROVIDED) (5). THE EXCEPTION FOR CONDITIONS DEFINED IN ITEM (5) IS THE CASES OF JOINT'S SUBJECT TO DYNAMIC
LOADS, STRUCTURES EXPOSED TO THE WEATHER OR AGGRESSIVE
ENVIRONMENTS OR TEMPERATURES LOWER THAN 0° THE

LONGITUDINAL JOINTS OF TWO PIECES CAN BE CARRIED OUT BY DISCONTINUED WELDING PER INDICATION OF THE BOTTOM CHART



MANUFACTURING

PROCESS STATUS

WELDING

COSMA INNOVATIVE MANUFACTURING SOLUTIONS CHK'D CHANGE

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

MAXIMUM ALLOWANCE ROUGHNESS OF ALL

Stock List

DESCRIPTION

2" x 4" x 3/16" x 440.0mm LG

1 3/4" x 4" x 350.0mm LG

1/2" x 2 1/2" x 5" LG

BRACKET SUPPORT

MATERIAL

HR-HRS

HR-HRS

W/C

MAXIMOM 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 0.5 MICRONS
ALL GROUND SURFACES TO BE 0.4 MICRONS.
METRIC - EXCEPT AS NOTED TOLERANCES SHALL BE:

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 O SURFACES MUST BE FINISHED EXCEPT FOR COLD

ALL O 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 INDENTIFICATION AND MATERIAL NUMBERS ON DETAILS.

PAINT INDENTIFICATION NUMBERS ON STRUCTURAL WORK.

CRITICAL FEATURES ARE MARKED WITH "*"

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, I.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.

WELDING AROUND OUTER SIDE. FOR SUPPORTS APPLY CONTINUOUS WELDING. ELIMINATE SCRAP AFTER WELDING. 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 NUMBER UNIT No.: WEIGHT (KG): 11.53 kg

COTO: 202202 ☐ MOVIL PART RAL ■ FIXED PART RAL

☐ POKA YOKE PAINT

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DESIGN SOURCE | BUILD SOURCE | CUSTOMER **MAGNA FORMEX**

DESIGNER DETAILER 3RD ANGLE PROYECTION K. MAR K. MAR DESIGN SUP. E. TORRES E. TORRES A. RANGEL

DESCRIPTION BEV3 NONE

ୁଞ୍ଚାଚ୍ଚ ଓ BEV3_RRC_ST017_Y-U02-0252-BSWCFW

RELEASE DATE

FID-08-1, VER.4 Fecha: 09/09/2021 Resp: L. Luna