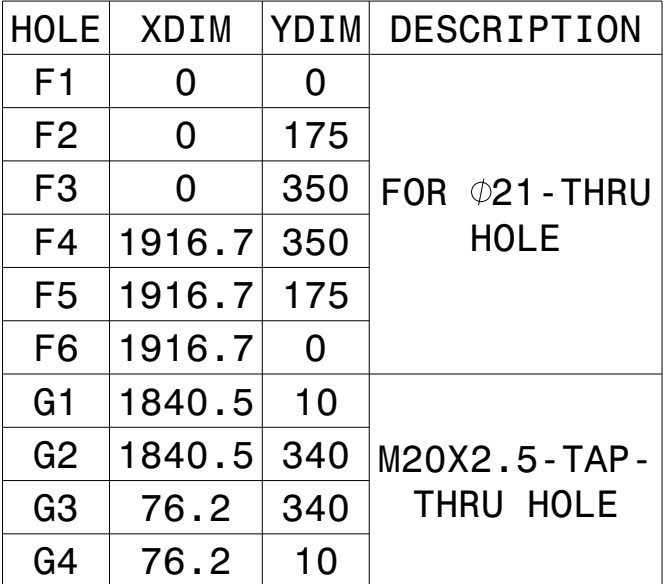
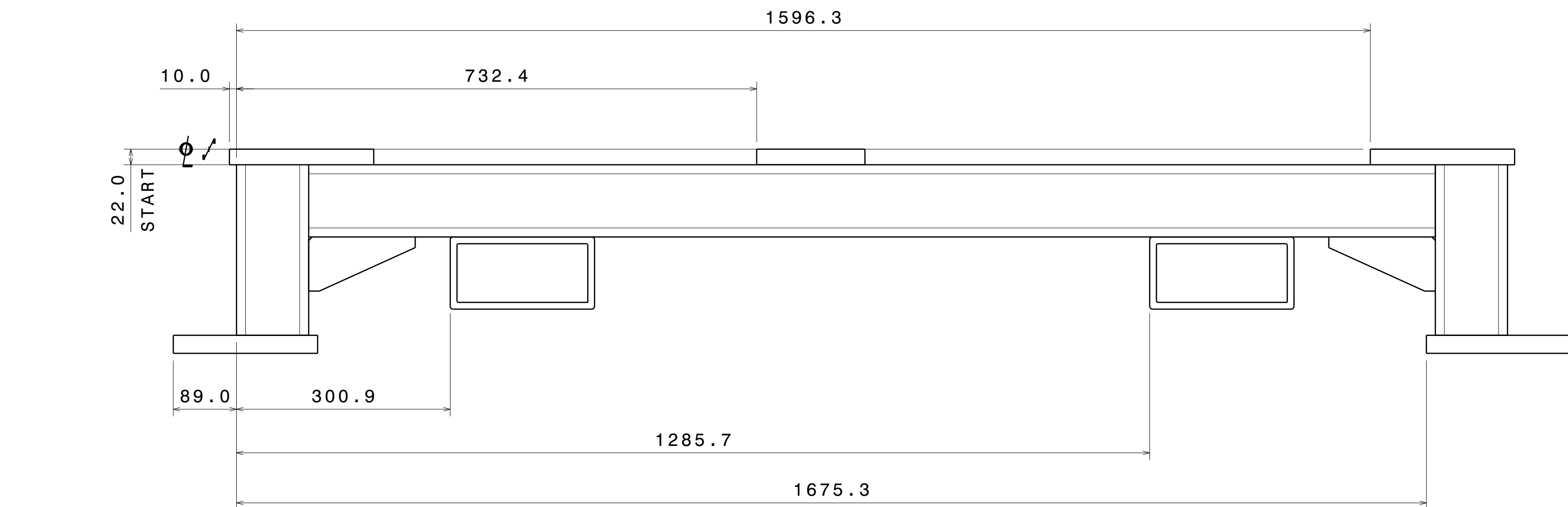


STOCK LIST			
ITEM	QTY	MATERIAL	DESCRIPTION
a	2	HRS	1"x8"x400.0mm LG.
b	2	RECT TUBE	8"x4"x1/4"x240.0mm LG.
c	1	RECT TUBE	8"x4"x1/4"x1586.3mm LG.
d	1	HRS	1"x8"x470.0mm LG.
e	2	RECT TUBE	8"x4"x3/8"x390.0mm LG.
f	2	HRS	1/2"x3"x150.0mm LG.
g	1	HRS	1"x6"x120.0mm LG.
h	1	HRS	1"x8"x442.0mm LG.
151	1	W/C	BRACKET SUPPORT

ONLY FOR MANUFACTURING	
PROCESS	STATUS
CUT	
WELDING	
STRESS	
RELIEVING	
MACHINING	
PAINT	

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 ## FINISH DIMENSIONS TO BE 3.2 MICRONS					
2 PLACE ## FINISH DIMENSIONS TO BE 1.6 MICRONS					
3 PLACE ## FINISH DIMENSIONS TO BE 0.5 MICRONS					
ALL 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 DRILL AND A HELL SURFACE					
0.03 BETWEEN DRILLS IN THE SAME PLANE					
0.10 BETWEEN DRILLS 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 ***					
WELDMENTS:					
ALL WELD FILLETS TO BE 1/4 INCH.					
ALL "V" GROOVES TO BE 90 EXCEPT AS SHOWN.					
AND VENT HOLES IN ALL WELDMENTS WHERE TRAPPED AIR IS A POSSIBILITY, I.E. TUBING CAPPED AT BOTH ENDS, BORED FORMS ETC. SPOTFACE SCREW AND / OR BOLT HOLES WHEN CLEARANCE FOR SCREW AND / OR BOLT HEAD AND / OR WADERS 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.:		01			
WEIGHT (KG):		160.8			
COTO: 20204					
<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 YOKE PAINT					
DESIGN SOURCE	BUILD SOURCE	CUSTOMER			
MAGNA	MAGNA	NAVISTAR			
DESIGNER	DETAILER	3RD ANGLE PROJECTION			
ONWARD	ONWARD				
PROJECT MGR.	DESIGN SUP.	CHECKER			
ALFREDO RANGEL	ONWARD	C.VARGAS			
SYSTEM NAME					
NVT Bus Cab E79					
DESCRIPTION					
Bus Cab E79					
SCALE	SHEET	RELEASE DATE			
1:4	01 OF 03	23-12-2021			
2 SHOW		E79 CAB ST230_L0151_BFWCFX			
3 OPPOSITE		--			



REF.	X	Y	Diameter
A1	0	0	FOR ?6-DWL-H7- THRU HOLE- TOOLING HOLE
A2	1600	0	
A3	1600	250	
A4	0	250	
B1	4	164.5	FOR ?10-DWL- H6-THRU HOLE
B2	4	94.5	
B3	702.5	94.5	
B4	1596	94.5	
B5	1596	164.5	
B6	702.5	164.5	
C1	0	23.88	M5X0.8-TAP- THRU HOLE
C2	0	-23.88	
C3	1600	-23.88	
C4	1600	23.88	
C5	1600	226.12	
C6	1600	273.88	
C7	0	273.88	
C8	0	226.12	
D1	-31	164.5	M12X1.75-TAP- THRU HOLE
D2	-31	94.5	
D3	39	94.5	
D4	39	164.5	
D5	667.5	94.5	
D6	737.5	94.5	
D7	737.5	164.5	
D8	667.5	164.5	
D9	1561	164.5	
D10	1561	94.5	
D11	1631	94.5	
D12	1631	164.5	
E1	-70	280	M20X2.5-TAP- THRU HOLE
E2	-70	-100	
E3	1640	-110	
E4	1680	300	

COSMA INNOVATIVE MANUFACTURING SOLUTIONS			
REV	CHANGE	CHK'D	DATE

THIS DRAWING MAY BE USED FOR BOTH INCH AND METRIC
UNITS OF MEASUREMENT ** INDICATES CHINESE DIMENSIONS)

MAXIMUM ALLOWANCE ROUGHNESS OF ALL METRIC.

1 PLACE ALL FINISH DIMENSIONS TO BE 3.2 MICRONS
2 PLACE ALL FINISH DIMENSIONS TO BE 1.6 MICRON.
3 PLACE ALL FINISH DIMENSIONS TO BE 0.8 MICRON
ALL DIMENSIONS ARE UNLESS OTHERWISE SPECIFIED
METRIC - EXCEPT AS NOTED TOLERANCES SHALL BE:
1. GRADE A SURFACES
2. PLACE FABRICATION 1/10
3. PLACE FINISHED SURFACES
4. 0.075 BETWEEN SINGLE HOLE AND A HOLE SURFACE
5. 0.075 BETWEEN TWO HOLES IN THE SAME PLATE
6. 0.075 BETWEEN HOLES IN DIFFERENT PLATES
7. 0.075 BETWEEN HOLES IN DIFFERENT PARTS
8. 0.015 SURFACES MUST BE FINISHED EXCEPT FOR COLD
DRAIN SURFACES.

ALL EDGES AT POINT CONTACT SURFACES ON LOCATING
BLOCKS AND PISTONS TO HAVE .125 INCH / 3.00 OR
AFTER SPOTTING.

MARK IDENTIFICATION AND MARK NUMBERS ON DETAILS.
PAINT IDENTIFICATION MARKS WITH PERMANENT MARK-
ING.

CRITICAL FEATURES ARE MARKED WITH **




MILWELDS:

ALL WELD FELLETS TO BE 1/4 INCH.
** CRITICAL WELDS TO BE X RAY EXAMINED.
AND VENT HOLES IN ALL MILWELDS WHEN SHOWN.
ALL WELDS TO BE 90 DEGREE BORE END JOINTS.
BONDED BOLTS ECT. SPOTFACE SCREW AND/OR BOLT
HOLES WHEN CLEARANCE FOR SCREW AND / OR BOLT
HEADS AND/OR HEADS OF NUTS AND BOLT HEADS.

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.:	01
WEIGHT (KG):	160.8

COTO: 20204	
<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 INTERNATIONALNO RIGHTS ARE GRANTEDO USE SUCH MATERIAL FOR ANY PURPOSE OTHER THAN FURNISHING OF SERVICES AND SUPPLIES

DESIGN SOURCE  MAGNA		BUILD SOURCE  MAGNA		CUSTOMER NAVISTAR
DESIGNER ONWARD	DETAILER ONWARD		3RD ANGLE PROJECTION	
PROJECT MGR. ALFREDO RANGEL		DESIGN SUP. ONWARD		CHECKER C. VARGAS
SYSTEM NAME NVT Bus Cab E79				

Bus Cab E79		
SCALE 1:5	SHEET 02 OF 03	RELEASE DATE 23-12-2021
DRAWING No.	SHOWN E79_CAB_ST230_L0151_BFWCFX	
	OPPOSITE --	

ONLY FOR MANUFACTURING	
PROCESS	STATUS
CUT	
WELDING	
STRESS RELIEVED	
MACHINING	
PAINT	

