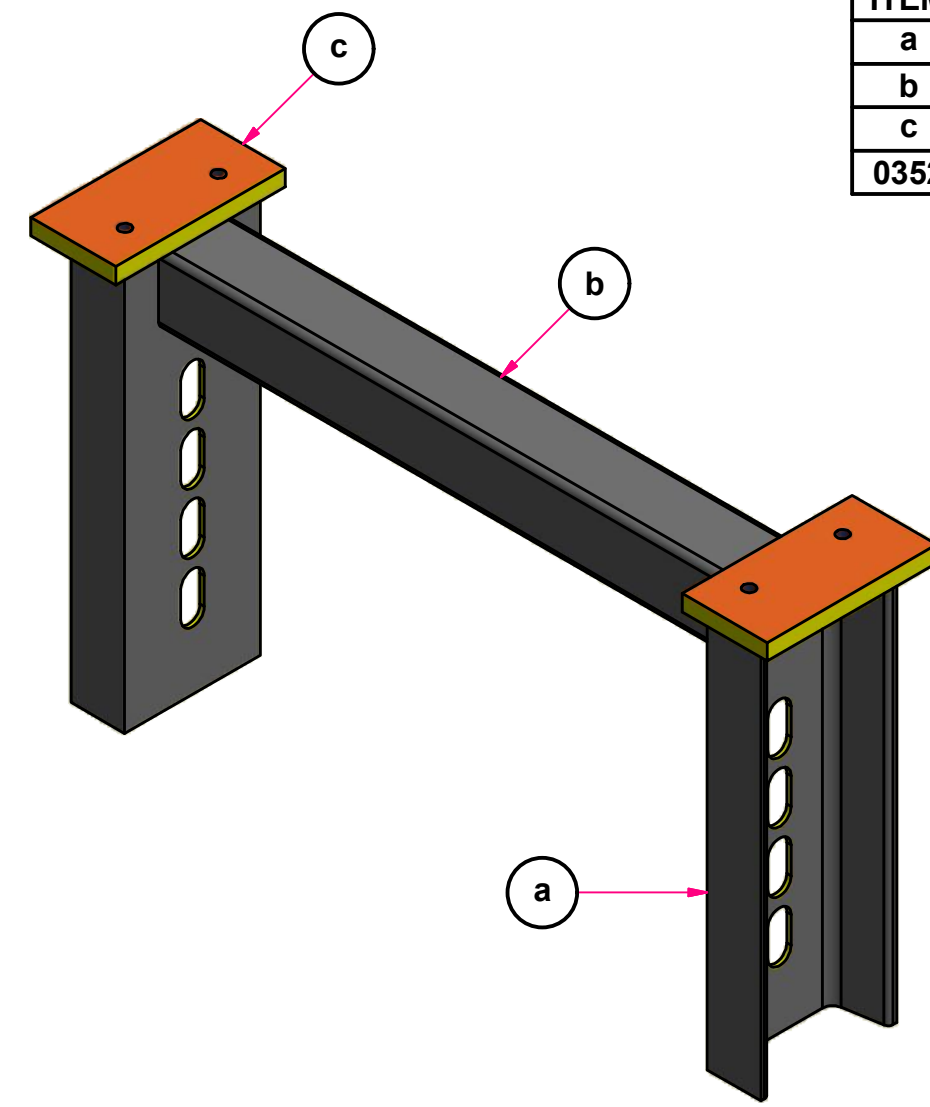
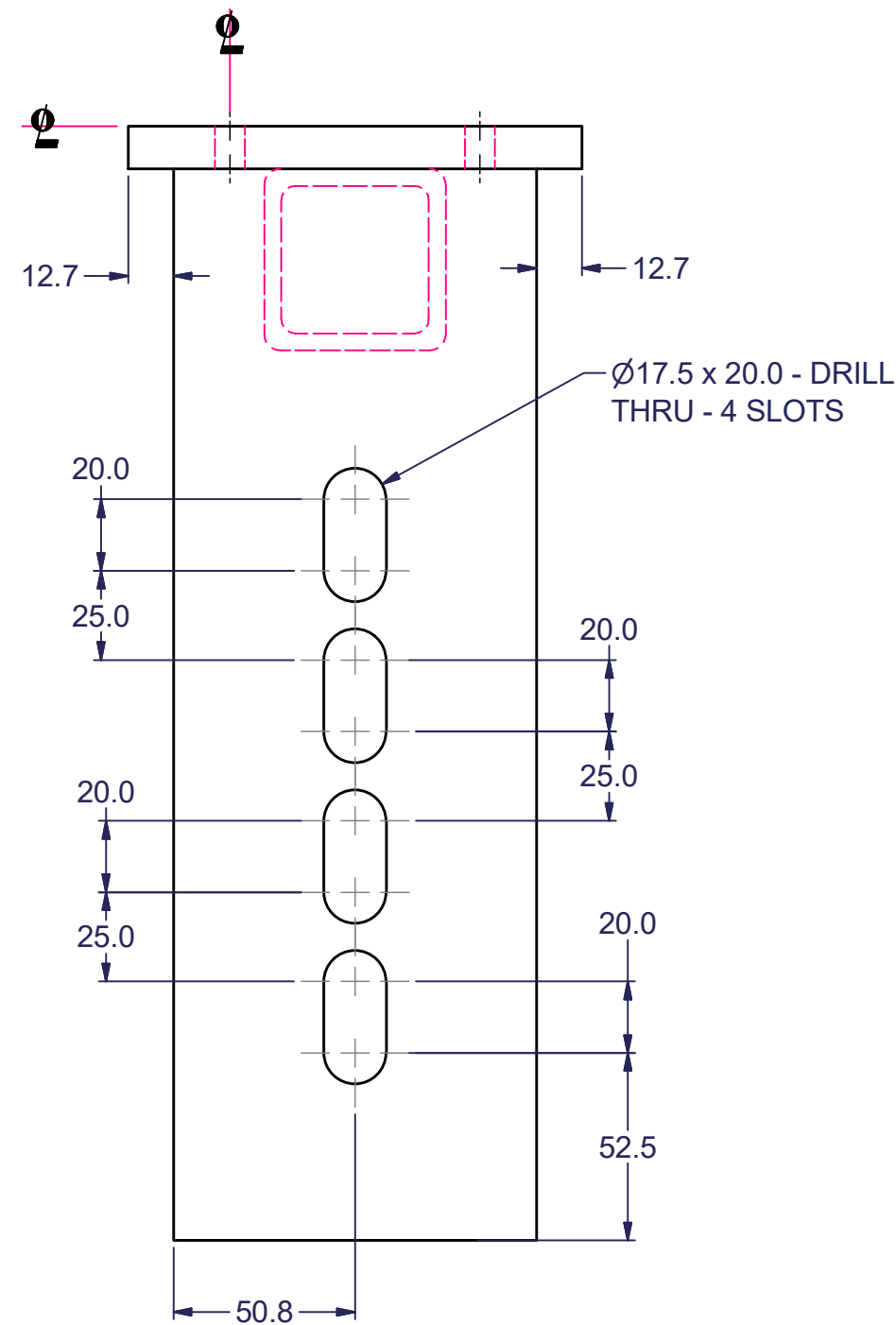
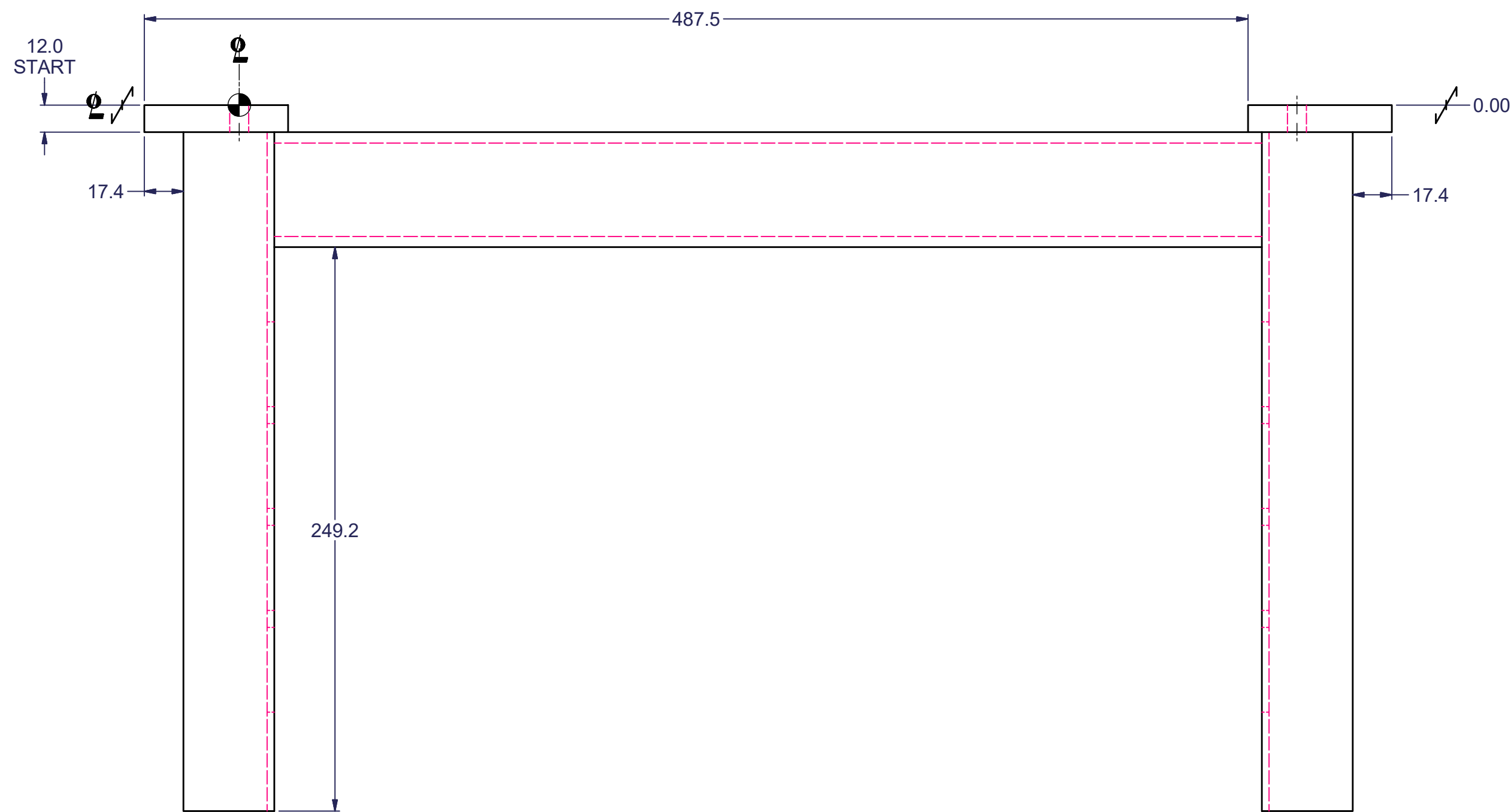
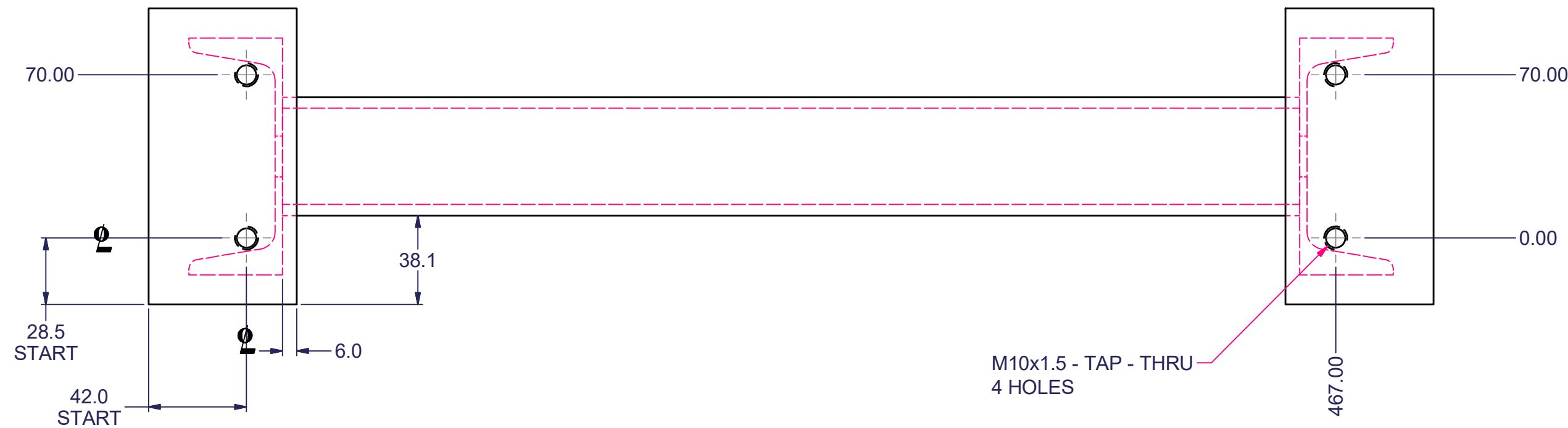


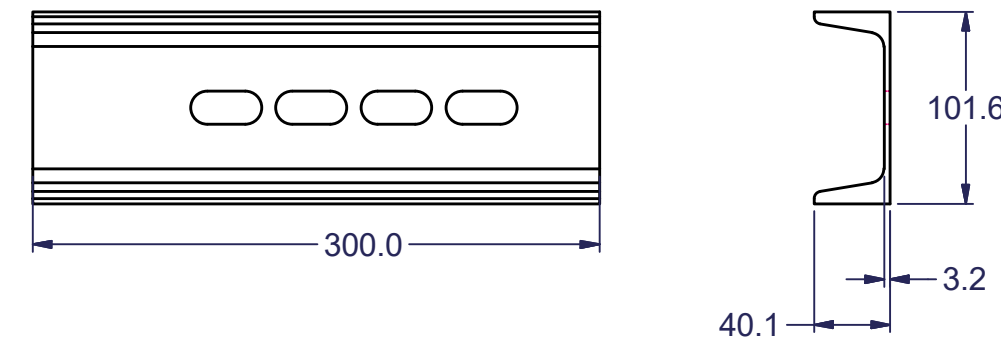
0352

BRACKET SUPPORT
WELDED CONST. - STRESS RELIEVE

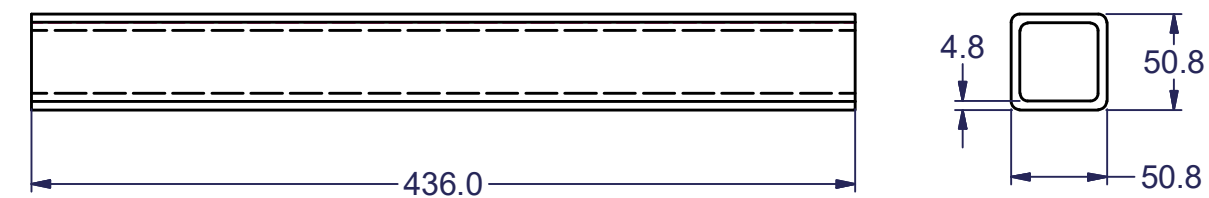


Stock List			
ITEM	QTY	MATERIAL	DESCRIPTION
a	2	HR-HRS	1 3/4" x 4" x 350.0mm LG
b	1	HR-HRS	1/2" x 2 1/2" x 5" LG
c	2	TUBE	2" x 2" x 3/16" x 440.0mm LG
0352	1	W/C	BRACKET SUPPORT

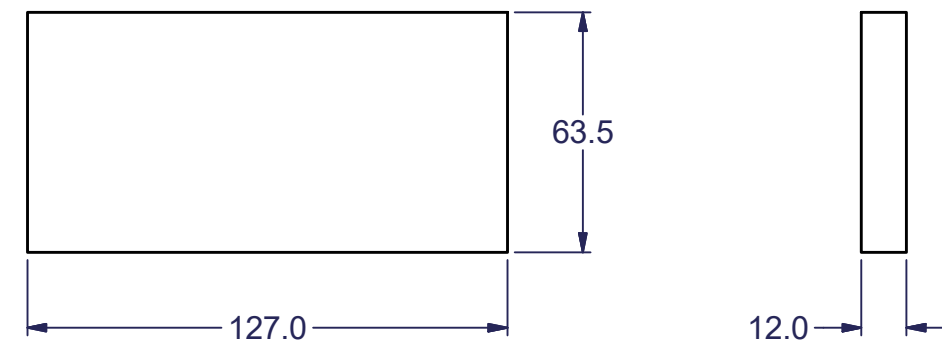
ITEM "a"



ITEM "b"



ITEM "c



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 STRS RELIEVED PROCESS 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 HIGHLY 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

The diagrams illustrate various welding joint configurations and their corresponding stress relief methods:

- WELD JOINT WITH DOUBLE OVERLAP PLATE AND DOUBLE WELD**: Reference 1
- WELD JOINT WITH DOUBLE OVERLAP PLATE AND SINGLE WELD**: Reference 2
- WELD JOINT WITH DOUBLE OVERLAP PLATE AND SINGLE WELD**: Reference 3
- WELD JOINT WITH DOUBLE OVERLAP PLATE AND SINGLE WELD**: Reference 4
- WELD JOINT WITH DOUBLE OVERLAP PLATE AND SINGLE WELD**: Reference 5
- WELD JOINT WITH DOUBLE OVERLAP PLATE AND SINGLE WELD**: Reference 6
- WELD JOINT WITH DOUBLE OVERLAP PLATE AND SINGLE WELD**: Reference 7
- WELD JOINT WITH DOUBLE OVERLAP PLATE AND SINGLE WELD**: Reference 8
- WELD JOINT WITH DOUBLE OVERLAP PLATE AND SINGLE WELD**: Reference 9
- WELD JOINT WITH DOUBLE OVERLAP PLATE AND SINGLE WELD**: Reference 10
- WELD JOINT WITH DOUBLE OVERLAP PLATE AND SINGLE WELD**: Reference 11
- WELD JOINT WITH DOUBLE OVERLAP PLATE AND SINGLE WELD**: Reference 12

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 MICRONS
2 PLACE mm FINISH DIMENSIONS TO BE 6 MICRONS
3 PLACE .001 mm FINISH DIMENSIONS TO BE 5 MICRONS
ALL GROUND SURFACES TO BE 0.4 MICRONS.

METRIC - EXCEPT AS NOTED TOLERANCES SHALL BE:

1 PLACE MACHINING 0.3
2 PLACE FABRICATION 1.5

1 PLACE .08 BETWEEN SLIDING SURFACES
2 PLACE .03 BETWEEN SINGLE DOWEL AND A HEEL SURFACE
.03 BETWEEN DOWELS IN THE SAME PLANE
.01 BETWEEN DOWELS AND SURFACES OF PLAINES
.013 TO SCREW HOLES, NON ACCUMULATIVE

ALL SURFACES MUST BE FINISHED EXCEPT FOR COOLD
DRAWN SURFACES

ALL EDGES OF PART CONTACT SURFACES ON LOCATING
AND GUIDE FINGERS TO HAVE .125 INCH / 3.00 mm
AFTER SPOTTING.

MARK IDENTIFICATION AND MATERIAL NUMBERS ON DETAILS.
PART IDENTIFICATION NUMBERS ON STRUCTURAL WORK.

CRITICAL FEATURES ARE MARKED WITH ***



WELDMENTS:


ALL WELD FILLETS TO BE 1/4 INCH
1/8" GROOVES TO BE 90 DEGREE AS SHOWN.
ADJ VENT HOLES IN ALL WELDMENTS WHERE TRAPPED
AIR IS POSSIBILITY I.E. JAWING, CAPPED AT BOTH ENDS,
BOXED FORMS ETC. SPECIFY SCREW AND / OR SOLT
HOLES WHEN CLEARANCE FOR SCREW AND / OR SOLT
HOLES OR FOR WASHERS IS REQUIRED UPON BY EYE BEADS.

FOR BASES APPLY CONTINUOUS
WELDING AROUND OUTER SIDE. FOR SUPPORTS APPLY
WELDING WELDS. ELIMINATE SCRAP AFTER WELDING
WELDMENT CONSTRUCTION MUST BE STRESS RELIEVED BY
NORMALIZED. WELDMENT CONSTRUCTION MUST BE MILLING
AND / OR AFTER WELDING. WELDING MUST BE APPROVED
MICRO WIRE WELD 0.45mm. WIRE DIAMETER. BREAK SHARP EDGES.

UNIT No.:	UNIT NUMBER
WEIGHT (KG):	9.09 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
DRAWING No.	SHOWN	
	BEV3_RRC_ST017_Y-U03-0352-BSWCWF	
	OPPOSITE	