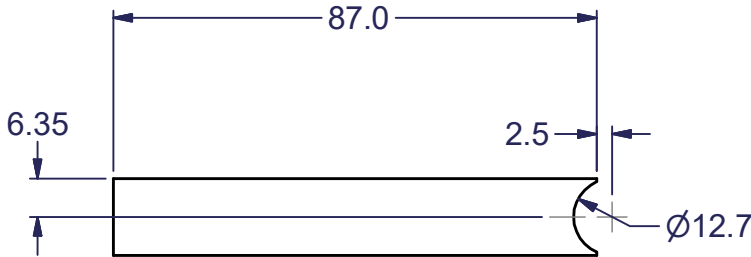
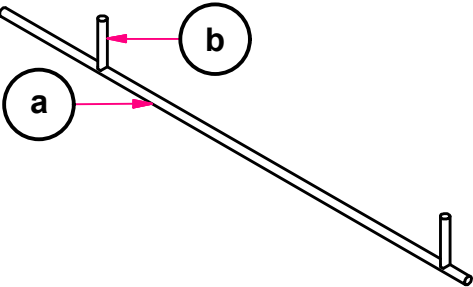
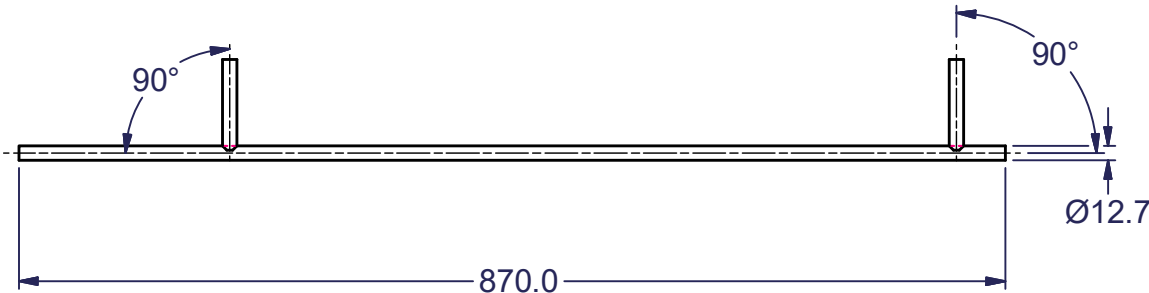
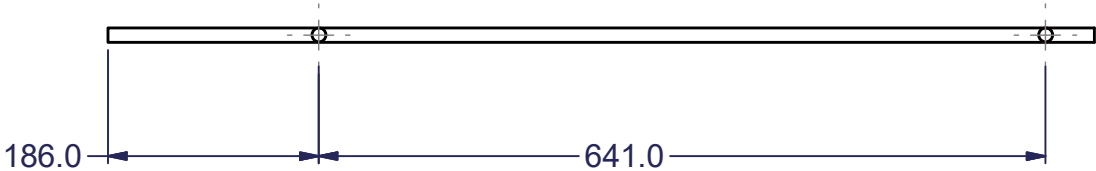


157

BRACKET SUPPORT
WELDED CONST. - STRESS RELIEVE



DATUM "b"



FAVOR DE
NO PINTAR

Stock List			
ITEM	QTY	MATERIAL	DESCRIPTION
a	1	CRS	1/2" DIA. x 870.0mm LG.
b	2	CRS	1/2" DIA. x 87.0mm LG.
157	1	W/C	BRACKET SUPPORT

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 0.5 MICRONS
ALL GROUND 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 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 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.
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.

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.:	UNIT NUMBER
WEIGHT (KG):	N/A

COTO: 202022	
<input type="checkbox"/> MOVIL PART RAL <input type="checkbox"/> FIXED PART RAL <input type="checkbox"/> BLACK OXIDE <input checked="" type="checkbox"/> WITH OUT PAINT <input type="checkbox"/> POKA YOKE PAINT	THIS MATERIAL IS PROPERTY OF MAGNA COSMA INTERNATIONALNO RIGHTS ARE GRANTEDTO USE SUCH MATERIAL FOR ANY PURPOSE OTHER THAN FURNISHING OF SERVICES AND SUPPLIES

DESIGN SOURCE	BUILD SOURCE	CUSTOMER
		CUSTOMER NAME

DESIGNER D. NAME	DETAILER D. NAME	3RD ANGLE PROJECTION
PROJECT MGR. PM NAME	DESIGN SUP. F. NAME	CHECKER CK NAME

SYSTEM NAME PROJECT NAME	
DESCRIPTION PRODUCT NAME	

SCALE NONE	SHEET 1 OF 1	RELEASE DATE 9/24/2021
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DRAWING NO. BEV3	SHOWN RRC_ST019_Y-U01-0157-BSWC FW_RevA2
OPPOSITE	