

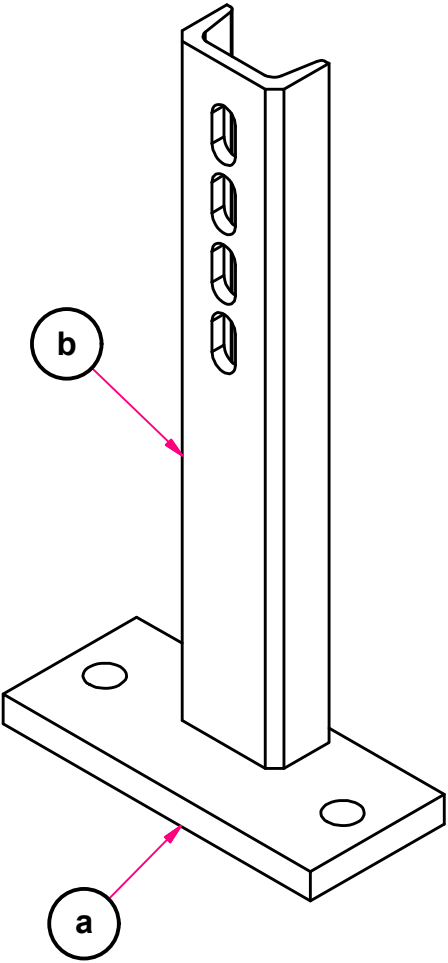
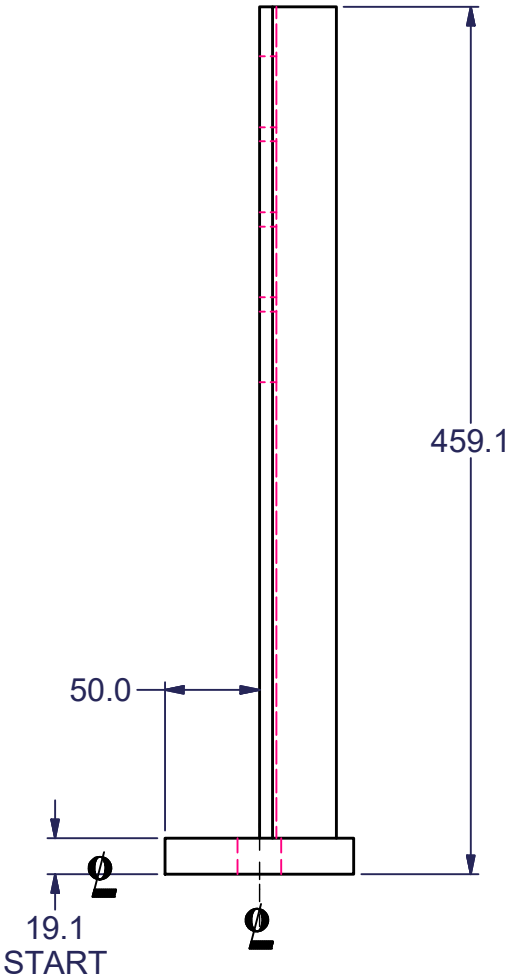
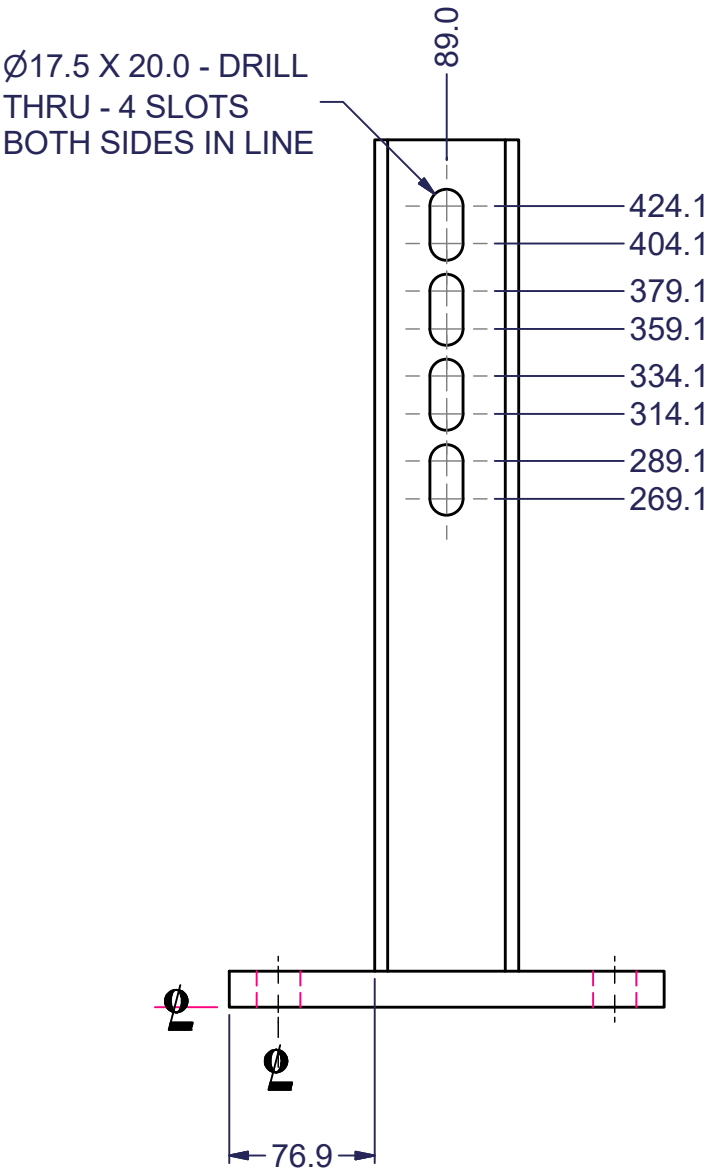
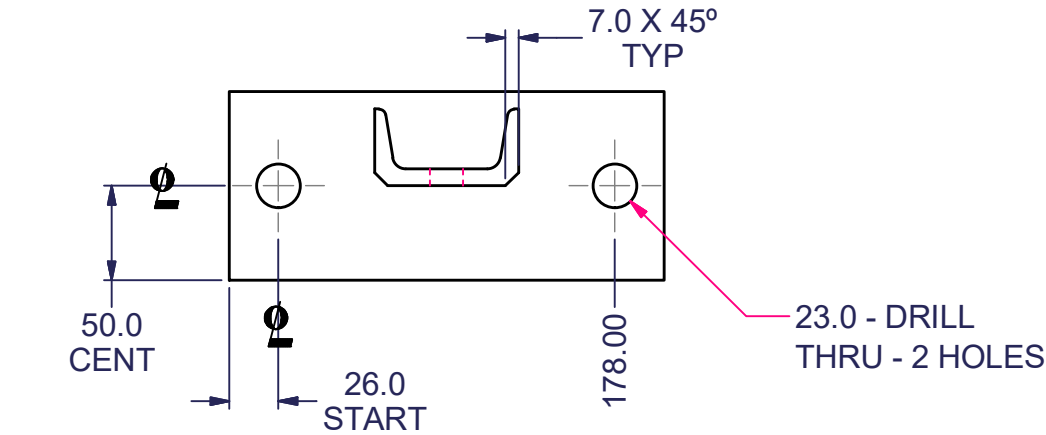
0251

BRACKET SUPPORT SHN  
WELDED CONST. - STRESS RELIEVE

0255

BRACKET SUPPORT OPP  
WELDED CONST. - STRESS RELIEVE

Stock List			
ITEM	QTY	MATERIAL	DESCRIPTION
a	1	Generic	3/4" x 100.0mm x 230.0mm LG
b	1	Steel, Mild	1 3/4" x 3" x 440.0mm LG
0251	1	W/C	BRACKET SUPPORT
0255	1	W/C	BRACKET SUPPORT



ONLY FOR MANUFACTURING	
PROCESS	STATUS
CUT	
WELDING	
STRESS RELIEVED	
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 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.

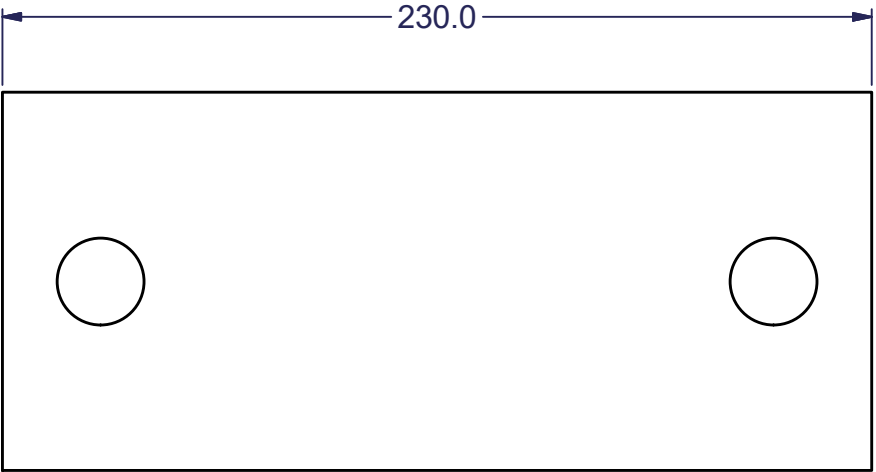
MARK IDENTIFICATION AND MATERIAL NUMBERS ON DETAILS. PAINT IDENTIFICATION NUMBERS ON STRUCTURAL WORK.

CRITICAL FEATURES ARE MARKED WITH "\*"

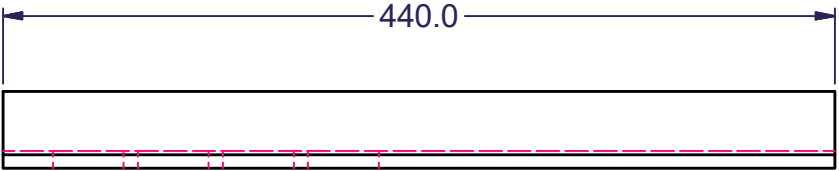
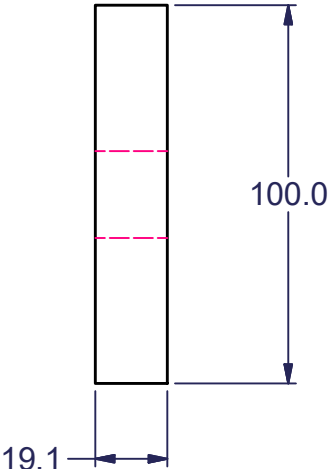
WELDMENTS:  
ALL WELD FILLETS TO BE 1/4 INCH.  
ALL "V" GROOVES TO BE 90 EXCEPT AS SHOWN.  
ADD VENT HOLES IN ALL WELDMENTS WHERE TRAPPED AIR IS A POSSIBILITY, I.E. TUBING CAPPED AT BOTH ENDS, BOXED FORMS ETC. SPOTFACE SCREW AND / OR BOLT HOLES WHEN CLEARANCE FOR SCREW AND / OR BOLT HEAD AND / OR WASHERS 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.

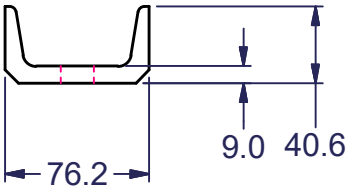
UNIT No.:	02	
WEIGHT (KG):	4.24 kg	
COTO: COTO NUMBER		
<input type="checkbox"/> MOVIL PART RAL <input checked="" type="checkbox"/> FIXED PART RAL <input type="checkbox"/> BLACK OXIDE <input type="checkbox"/> WITH OUT PAINT <input type="checkbox"/> POKA YOKE PAINT	THIS MATERIAL IS PROPERTY OF MAGNA COSMA INTERNATIONALNO RIGHTS ARE GRANTEDTO USE SUCH MATERIAL FOR ANY PURPOSE OTHER THAN FURNISHING OF SERVICES AND SUPPLIES	
DESIGN SOURCE	BUILD SOURCE	CUSTOMER
		BEV3_RRC
DESIGNER	DETAILER	3RD ANGLE PROJECTION
F.ESCOBAR	KATMAR	
PROJECT MGR.	DESIGN SUP.	CHECKER
	F. ESCOBAR	F. ESCOBAR
SYSTEM NAME		
BEV3_RRC		
DESCRIPTION		
CRADLE		
SCALE	SHEET	RELEASE DATE
NONE	1 OF 2	3/1/2018
SHOWN	BEV3_RRC_ST017_Y-U02-0251-BSWCFFW_RevA2	
OPPOSITE	BEV3_RRC_ST017_Y-U02-0255-BSWCFFW_RevA2	



Item "a"



Item "b"



COSMA INNOVATIVE MANUFACTURING SOLUTIONS			
REV	CHANGE	CHK'D	DATE
<p>THIS DRAWING MAY USE BOTH INCH AND METRIC UNITS OF MEASUREMENT (*INDICATES INCH DIMENSIONS)</p> <p>MAXIMUM ALLOWANCE ROUGHNESS OF ALL METRIC.</p> <p>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</p> <p>ALL O SURFACES MUST BE FINISHED EXCEPT FOR COLD DRAWN SURFACES.</p> <p>ALL EDGES OF PART CONTACT SURFACES ON LOCATING BLOCKS AND FINGERS TO HAVE .12R INCH / 3.00 mm AFTER SPOTTING.</p> <p>MARK IDENTIFICATION AND MATERIAL NUMBERS ON DETAILS. PAINT IDENTIFICATION NUMBERS ON STRUCTURAL WORK.</p> <p>CRITICAL FEATURES ARE MARKED WITH "*"</p>			
UNIT No.:		02	
WEIGHT (KG):		N/A	
COTO: COTO NUMBER			
<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 GRANTEDTO USE SUCH MATERIAL FOR ANY PURPOSE OTHER THAN FURNISHING OF SERVICES AND SUPPLIES	
DESIGN SOURCE	BUILD SOURCE	CUSTOMER	
		BEV3_RRC	
DESIGNER	DETAILER	3RD ANGLE PROYECTION	
F.ESCOBAR	KATMAR		
PROJECT MGR.	DESIGN SUP.	CHECKER	
	F. ESCOBAR	F. ESCOBAR	
SYSTEM NAME			
BEV3_RRC			
DESCRIPTION			
CRADLE			
SCALE	SHEET	RELEASE DATE	
NONE	2 OF 2	3/1/2018	
DRAWING SHOWN			
OPPOSITE			