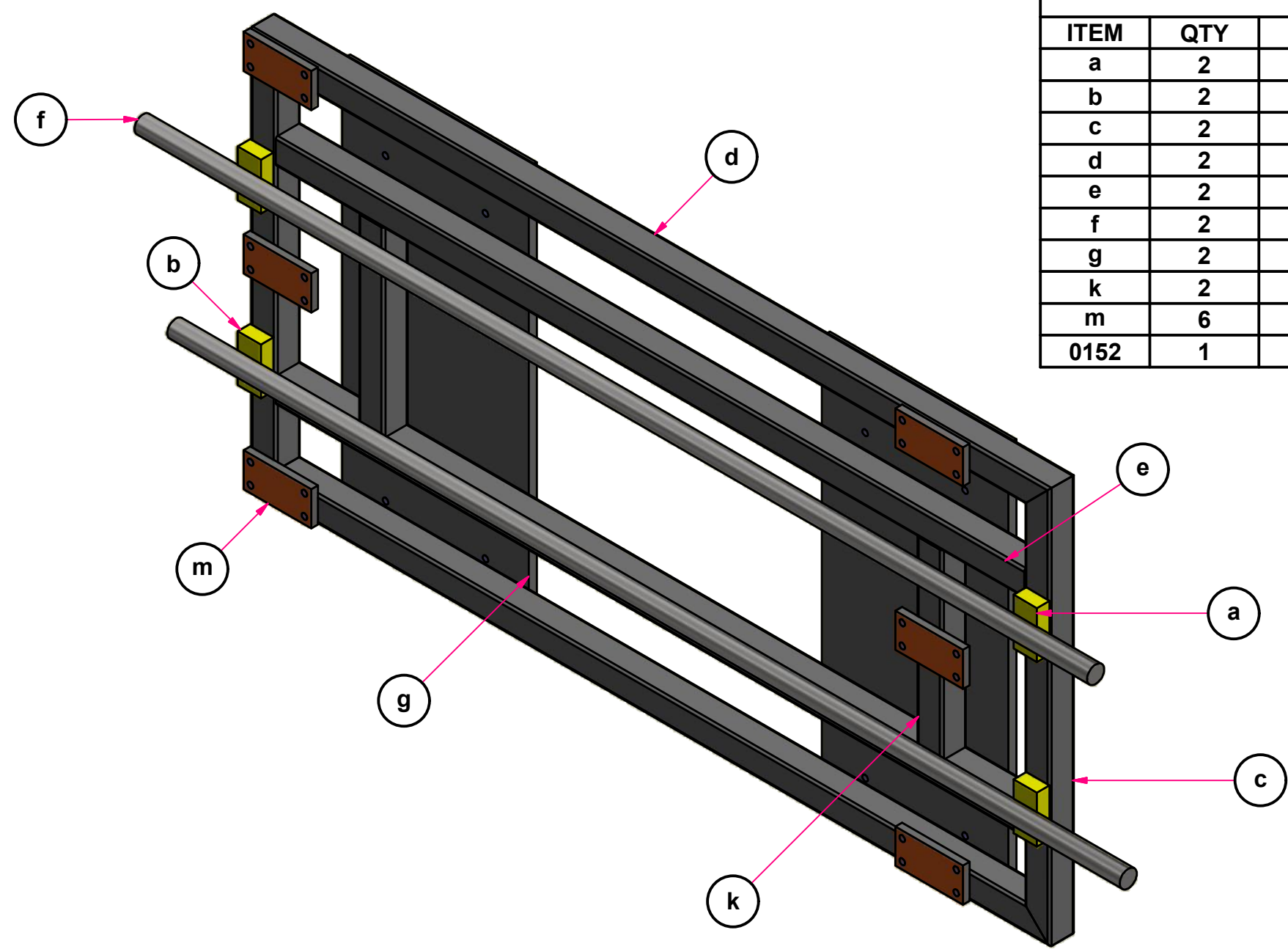


Hole Table			
HOLE	XDIM	YDIM	DESCRIPTION
A1	0.000	0.000	
A2	81.000	0.000	
A3	978.400	0.000	
A4	1059.400	0.000	
A5	0.000	30.000	
A6	81.000	30.000	
A7	978.400	30.000	
A8	1059.400	30.000	
A9	154.700	32.600	
A10	304.700	32.600	
A11	874.700	32.600	
A12	154.700	92.600	
A13	304.700	92.600	
A14	874.700	92.600	
A15	1024.700	92.600	
A16	0.000	280.300	
A17	81.000	280.300	
A18	978.400	280.300	
A19	1059.400	280.300	
A20	0.000	310.300	
A21	81.000	310.300	
A22	978.400	310.300	
A23	1059.400	310.300	
A24	154.700	481.600	
A25	304.700	481.600	
A26	874.700	481.600	
A27	1024.700	481.600	
A28	154.700	541.600	
A29	304.700	541.600	
A30	874.700	541.600	
A31	0.000	543.600	
A32	81.000	543.600	
A33	978.400	543.600	
A34	1059.400	543.600	
A35	0.000	573.600	
A36	81.000	573.600	
A37	978.400	573.600	
A38	1059.400	573.600	
B1	1024.700	32.600	M10x1.5 - TAP - THRU HOLES
B2	1024.700	541.600	M10x1.5 - TAP - THRU HOLES FAR SIDE



Stock List			
ITEM	QTY	MATERIAL	DESCRIPTION
a	2	HR-HRS	3/4" x 35.0mm x 70.0mm LG
b	2	HR-HRS	3/4" x 35.0mm x 70.0mm LG
c	2	SQ TUBE	1 1/2" x 1 1/2" x 1/8" x 600.0 mm LG
d	2	SQ TUBE	1 1/2" x 1 1/2" x 1/8" x 1200.0 mm LG
e	2	SQ TUBE	1 1/2" x 1 1/2" x 1/8" x 1125.0 mm LG
f	2	ROUND TUBE	1" DIA x 1430.0 mm LG
g	2	HR-HRS	1/2" x 280.0mm x 575.0mm LG
k	2	SQ TUBE	1 1/2" x 1 1/2" x 1/8" x 275.0 mm LG
m	6	HR-HRS	1/2" x 2" x 4" LG
0152	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 "H"

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, IE. 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.

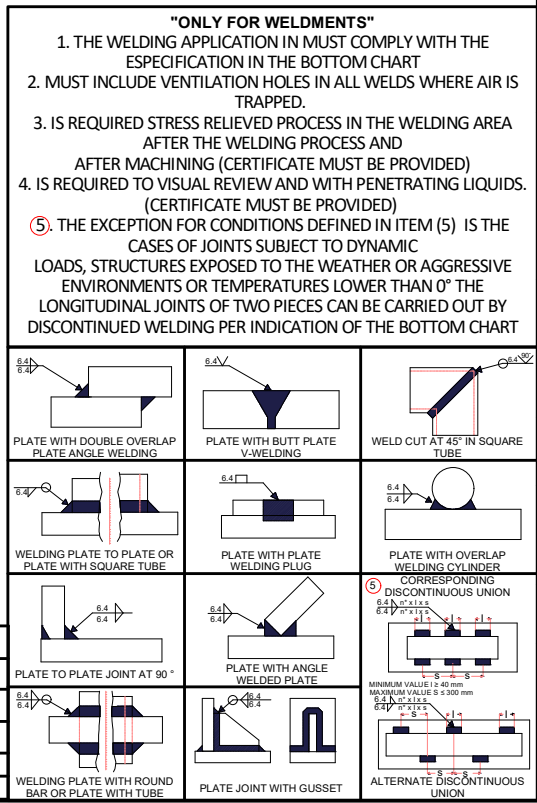
FOR BASES: APPLY CONTINUOUS WELDING AROUND OUTER SIDE. FOR SUPPORTS APPLY CONTINUOUS WELDING. ELIMINATE SPORADIC AFTER WELDING. WELDMENT CONSTRUCTION MUST BE STRESS RELIEVED BY NORMALIZED. WELDMENT CONSTRUCTION MUST BE MILLING AND DRILLING AFTER WELDING AND STRESS RELIEVED. APPLY MICRO WIRE WELD 0.45mm. WIRE DIAMETER. BREAK SHARP EDGES.

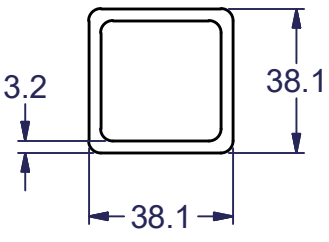
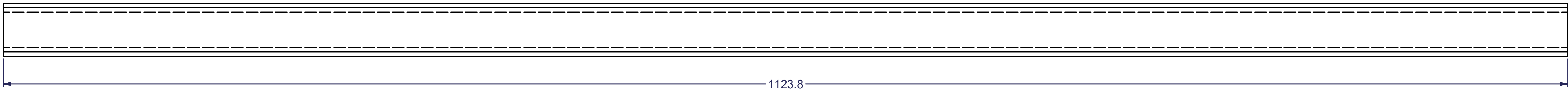
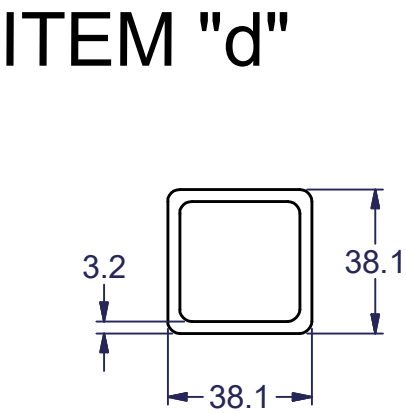
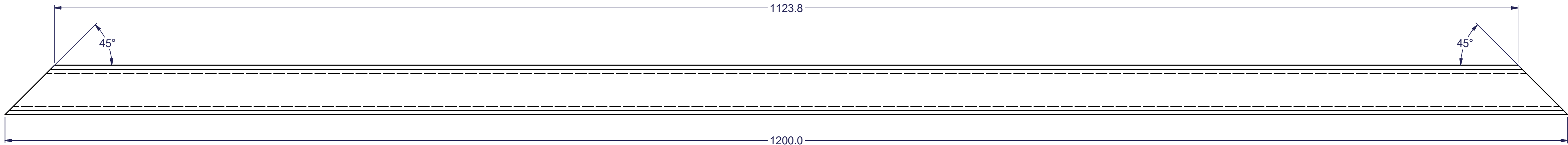
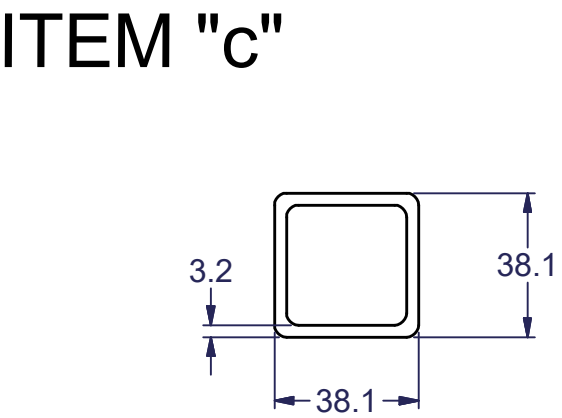
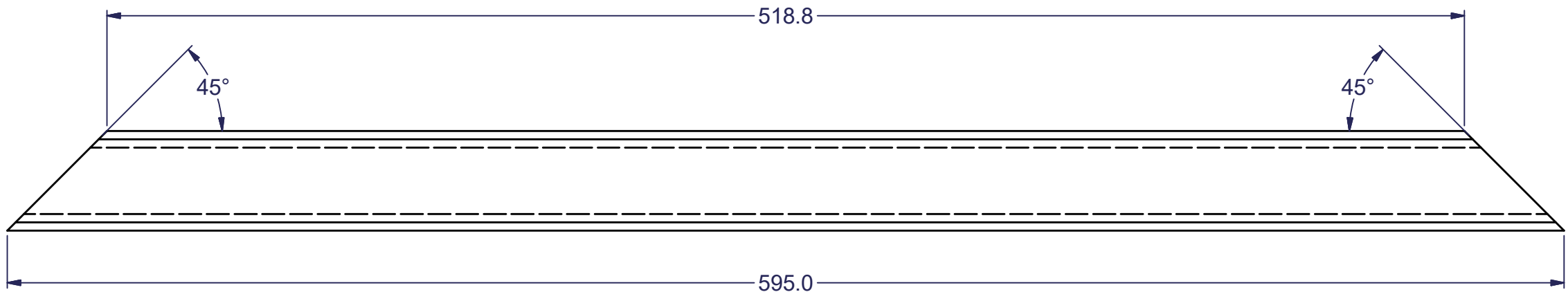
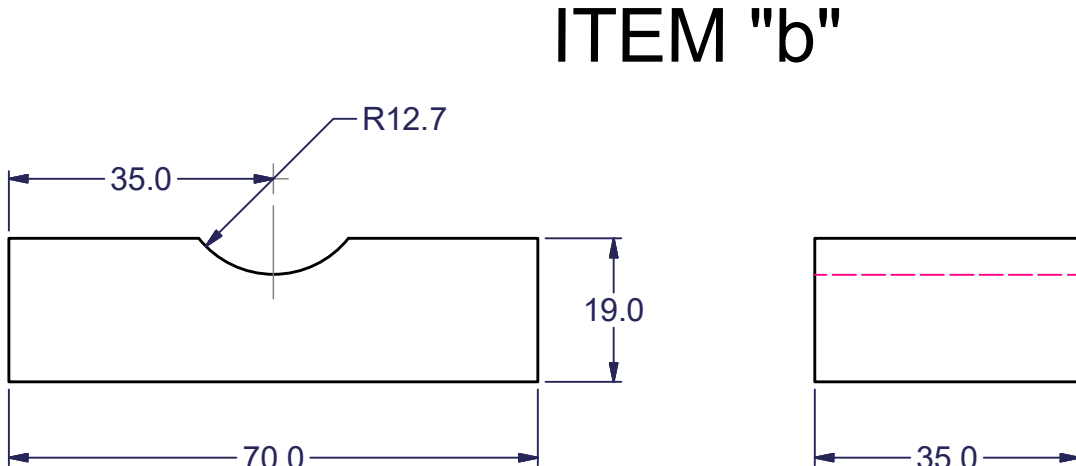
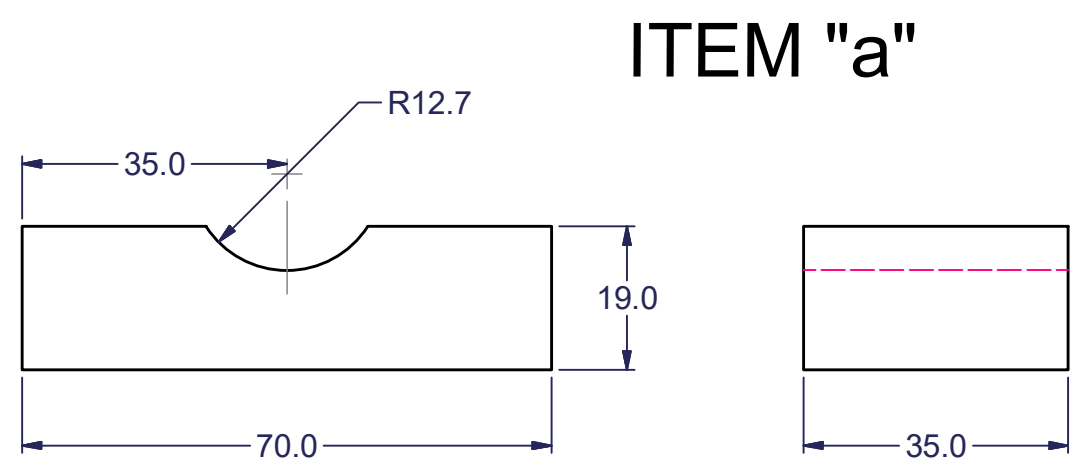
UNIT No.:	UNIT NUMBER
WEIGHT (KG):	N/A

COTO: 202202	
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<input type="checkbox"/> BLACK OXIDE	
<input type="checkbox"/> WITH OUT PAINT	
<input type="checkbox"/> POKA YOKE PAINT	

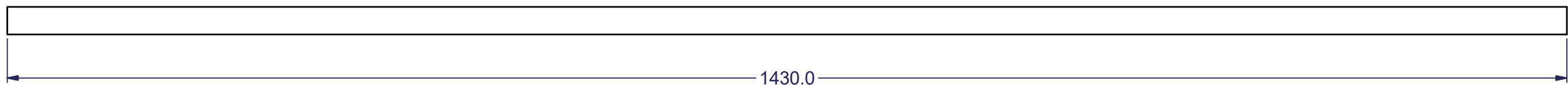
DESIGN SOURCE	BUILD SOURCE	CUSTOMER
MAGNA	MAGNA	FORMEX
DESIGNER K. MAR	DETAILER K. MAR	3RD ANGLE PROJECTION
PROJECT MGR. A. RANGEL	DESIGN SUP. E. TORRES	CHECKER E. TORRES
SYSTEM NAME RRC		
DESCRIPTION BEV3		
SCALE NONE	SHEET 1 OF 2	RELEASE DATE 3/1/2018
DRAWING No. BEV3_RRC_ST017_Y-U01-0152-BSWCWF	SHOWN OPPOSITE	

ONLY FOR MANUFACTURING	
PROCESS	STATUS
CUT	
WELDING	
STRESS	
DRILLING	
MACHINING	
PAINT	

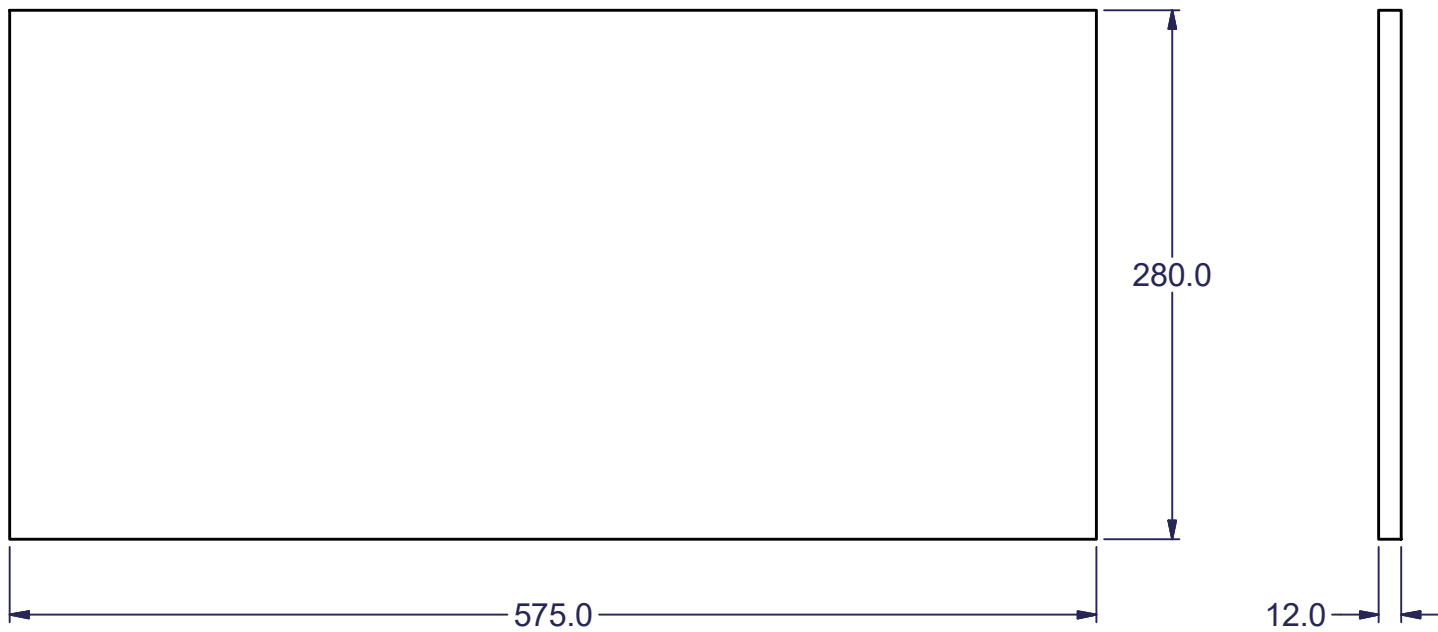
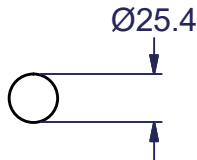




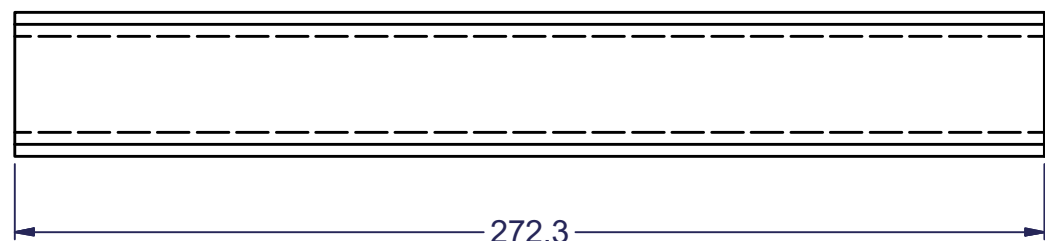
ITEM "e"



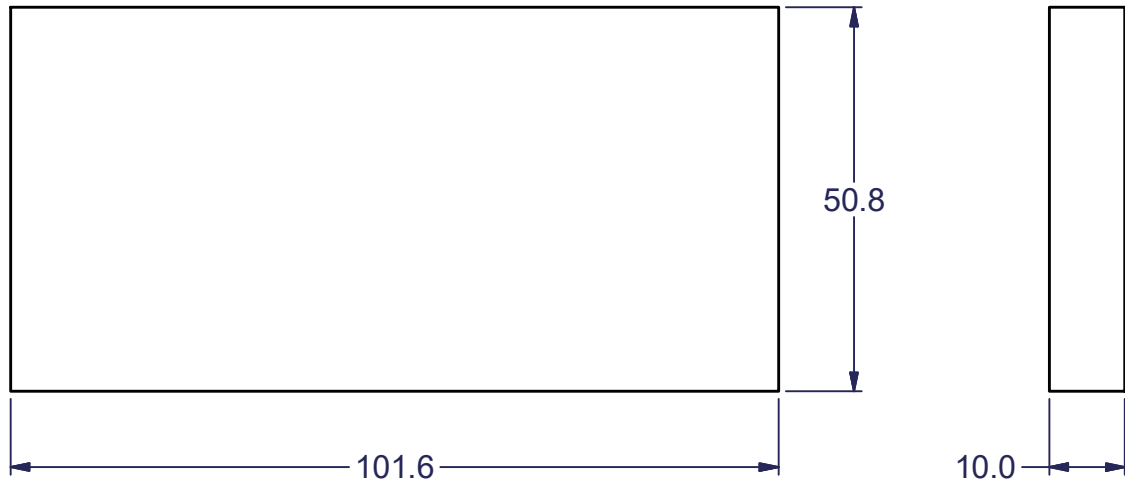
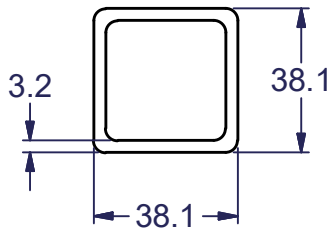
ITEM "f"



ITEM "g"



ITEM "k"



ITEM "m"

COSMA INNOVATIVE MANUFACTURING SOLUTIONS			
REV	CHANGE	CHK'D	DATE

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METRIC - EXCEPT AS NOTED TOLERANCES SHALL BE:

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1 PLACE FABRICATION :1.5
2 PLACE :0.06 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 0 SURFACES MUST BE FINISHED EXCEPT FOR COLD DRAWN SURFACES.

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

CRITICAL FEATURES ARE MARKED WITH "***"

UNIT No.:	UNIT	NUMBER
WEIGHT (KG):		0.34 kg

COTO: 202202

<input type="checkbox"/> MOVIL PART RAL <input 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. NO RIGHTS ARE GRANTED TO USE SUCH MATERIAL FOR ANY PURPOSE OTHER THAN FURNISHING OF SERVICES AND SUPPLIES.
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DESIGN SOURCE	BUILD SOURCE	CUSTOMER
		FORMEX

DESIGNER K. MAR	DETAILER K. MAR	
PROJECT MGR. A. RANGEL	DESIGN SUP. E. TORRES	CHECKER E. TORRES

SYSTEM NAME: RRC

DESCRIPTION: BEV3

SCALE NONE	SHEET 2 OF 2	RELEASE DATE 3/1/2018
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DRAWING No. BEV3_RRC_ST017_Y-U01-0152-BSWCFW-a	SHOWN OPPOSITE
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C:\Wksp\2022-0204 Mechanical Design\4.4 Design 100%4.4.1 Concept\BEV3_RRC_ST017_Y-U01-0152-BSWCFW.dwg