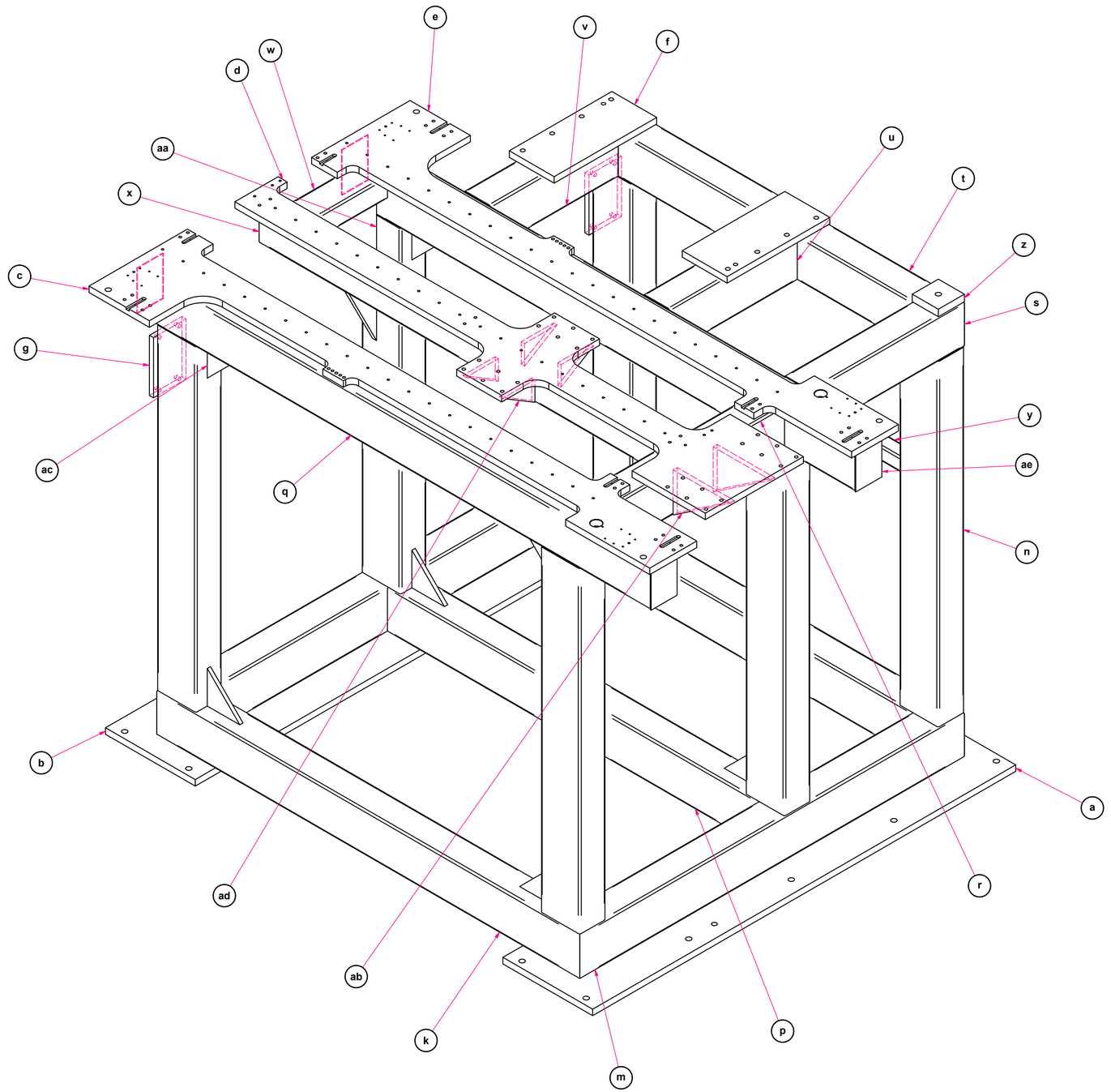
51 BASE FRAME
WELDED CONST. - STRESS RELIEVE



Stock List			
ITEM	QTY	MATERIAL	DESCRIPTION
a	1	HR-HRS	1" X 350.0 mm X 1650.0 mm LG
b	1	HR-HRS	1" X 350.0 mm X 1650.0 mm LG
c	1	HR-HRS	1" X 384.0 mm X 2046.0 mm LG
d	1	HR-HRS	1" X 382.0 mm X 1969.0 mm LG
e	1	HR-HRS	1" X 384.0 mm X 2046.0 mm LG
f	2	HR-HRS	1" X 175.0 mm X 400.0 mm LG
g	2	HR-HRS	3/4" X 5" X 8" LG
k	2	STL TUBE	6" x 4" x 1/4" x 1650.0 mm LG
m	2	STL TUBE	6" X 4" X 1/4" X 1500.0 mm LG
n	6	STL TUBE	6" X 4" X 1/4" X 1234.0 mm LG
p	1	STL TUBE	6" X 4" X 1/4" X 1447.0 mm LG
q	2	STL TUBE	6" X 4" X 1/4" X 2000.0 mm LG
r	1	STL TUBE	6" X 4" X 1/4" X 697.0 mm LG
s	1	STL TUBE	6" X 4" X 1/4" X 600.0 mm LG
t	1	STL TUBE	6" X 4" X 1/4" X 1350.0 mm LG
v	1	STL TUBE	6" X 4" X 1/4" X 600.0 mm LG
u	1	STL TUBE	6" X 4" X 1/4" X 499.0 mm LG
w	1	STL TUBE	3" X 4" X 1/4" X 399.0 mm LG
x	1	STL TUBE	3" X 4" X 1/4" X 1548.0 mm LG
y	1	STL TUBE	2" X 2" X 3/16" X 1045.0 mm LG
z	1	HR-HRS	1" X 4" X 4" LG
aa	1	HR-HRS	5/8" X 254.0 mm X 500.0 mm LG
ab	2	HR-HRS	5/8" X 6" X 225.0 mm LG
ac	10	HR-HRS	1/2" X 5" X 5" LG
ad	4	HR-HRS	1/2" X 3" X 5" LG
ae	4	HR-HRS	1/8" X 4" X 6" LG
51	1	W/C	BASE FRAME

COSMA INNOVATIVE MANUFACTURING SOLUTIONS

REV	CHANGE	CHK'D	DATE

UNIT No.: 02
WEIGHT (KG): N/A

COTO 202115

DESIGN SOURCE	BUILD SOURCE	CUSTOMER
MAGNA	MAGNA	NAVISTAR

DESIGNER	DETAILER	
ISRAEL E.	3D&2DGROUP	3RD ANGLE PROYECTION

PROJECT MGR.	DESIGN SUP.	CHECKER
A. RANGEL	CAVARGAS	CAVARGAS

SYSTEM NAME: E79 CAB NEXT GEN
DESCRIPTION: CABINE

SCALE	SHEET	RELEASE DATE
NONE	1 OF 7	3/1/2018

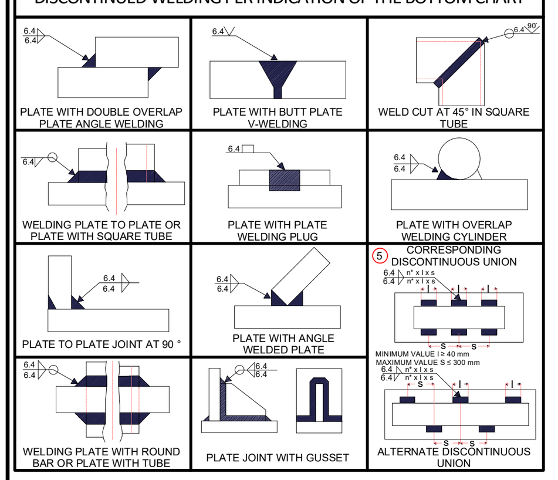
DRAWING No.
SHOWN: E79_CAB_ST020_G0251-BFWCFX
OPPOSITE

C:\Wksp\2021-1\504 Mechanical Design\4.4 Design 100%\4.4.1 Concept\E79_CAB_ST020_G\E79_CAB_ST020_G2DEF9_CAB_ST020_G0251-BFWCFX.idw

Aplica:CIMS FID-08-1, VER.3
Resp: L. Luna Fecha: 10/07/2020

"ONLY FOR WELDMENTS"

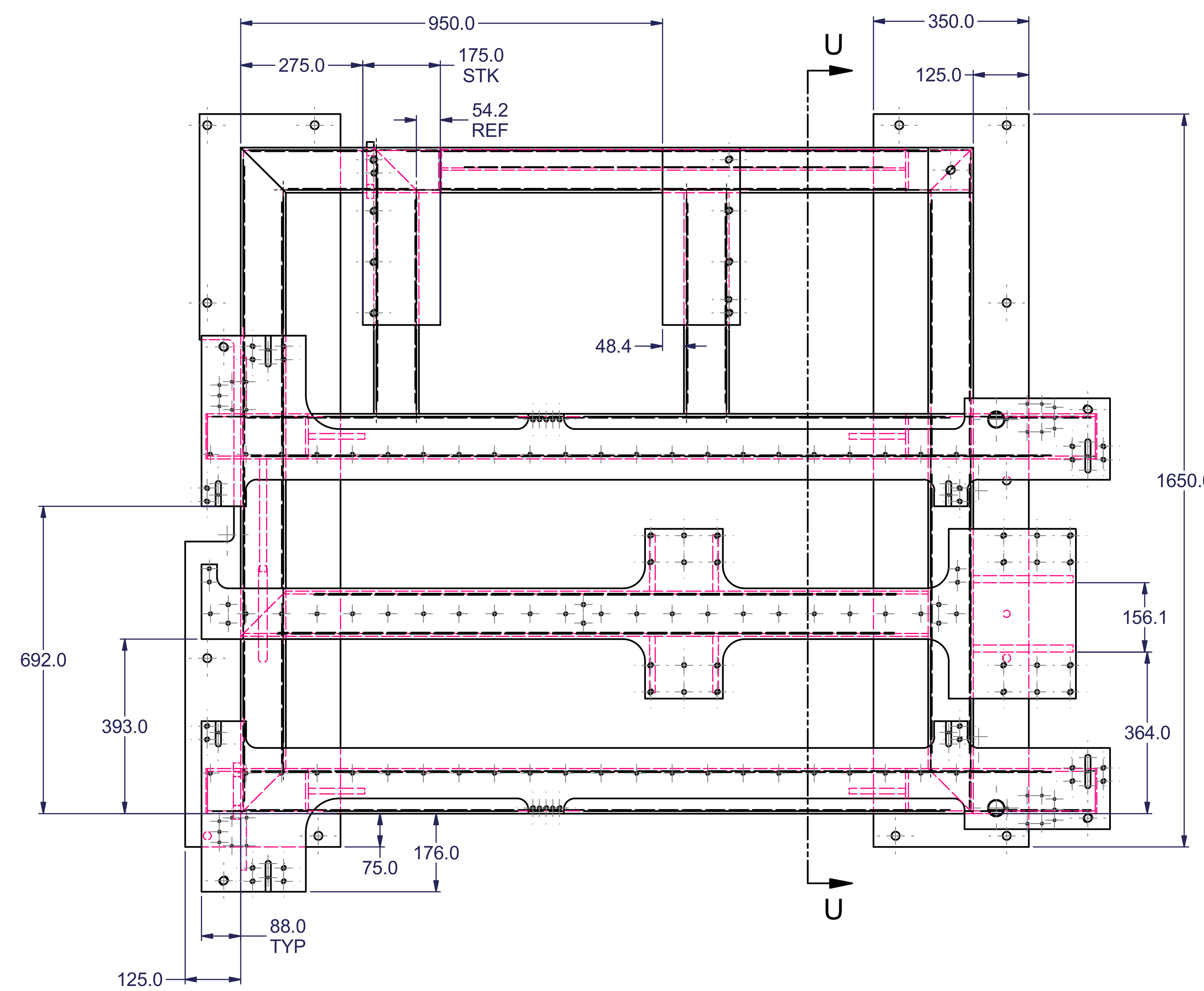
1. THE WELDING APPLICATION IN MUST COMPLY WITH THE ESPECIFICATION IN THE BOTTOM CHART
2. MUST INCLUDE VENTILATION HOLES IN ALL WELDS WHERE AIR IS TRAPPED.
3. IS REQUIRED STRESS RELIEVED PROCESS IN THE WELDING AREA AFTER THE WELDING PROCESS AND AFTER MACHINING (CERTIFICATE MUST BE PROVIDED)
4. IS REQUIRED TO VISUAL REVIEW AND WITH PENETRATING LIQUIDS. (CERTIFICATE MUST BE PROVIDED)
5. THE EXCEPTION FOR CONDITIONS DEFINED IN ITEM (5) IS THE CASES OF JOINTS SUBJECT TO DYNAMIC LOADS, STRUCTURES EXPOSED TO THE WEATHER OR AGGRESSIVE ENVIRONMENTS OR TEMPERATURES LOWER THAN 0° THE LONGITUDINAL JOINTS OF TWO PIECES CAN BE CARRIED OUT BY DISCONTINUED WELDING PER INDICATION OF THE BOTTOM CHART

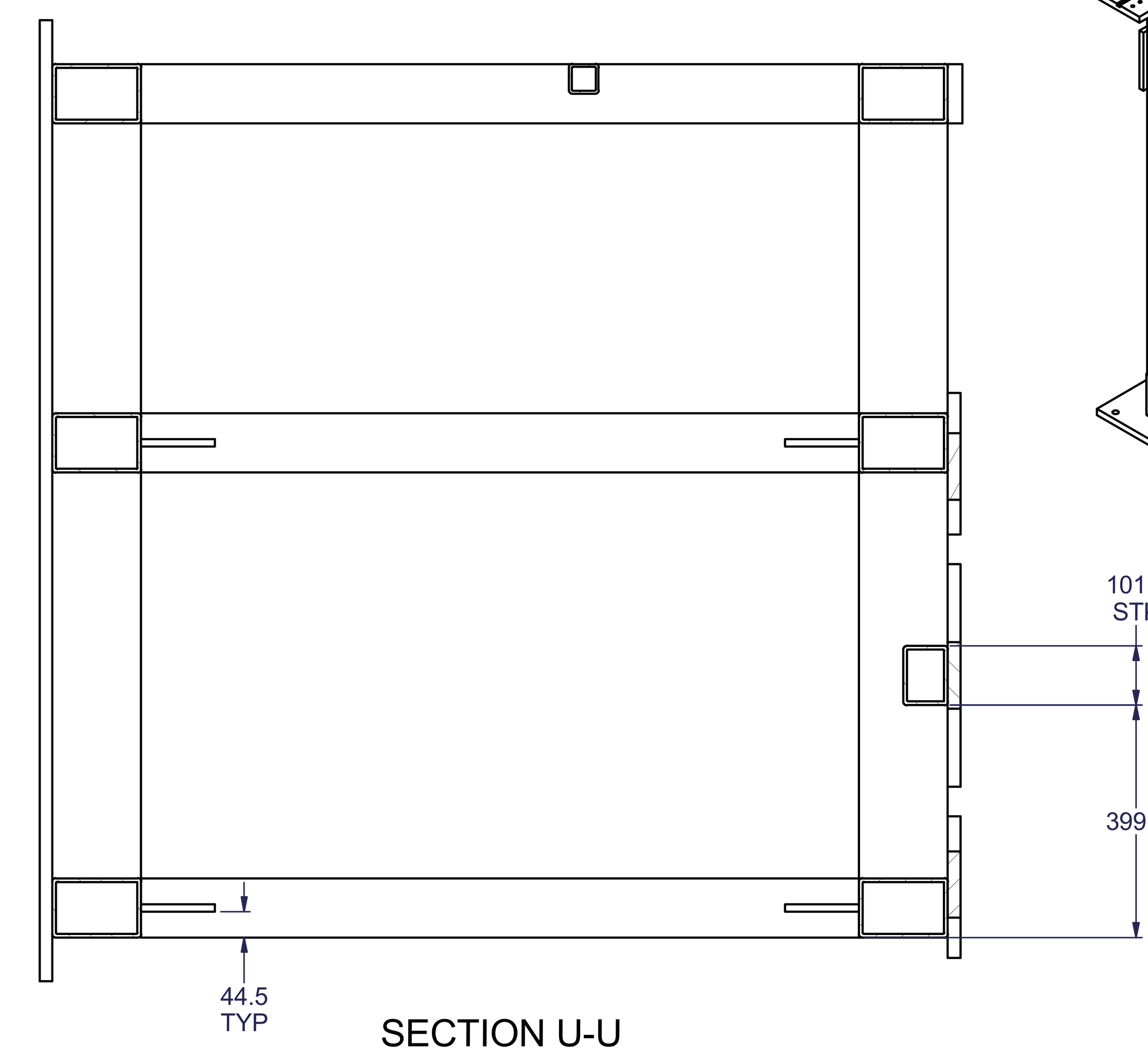


ONLY FOR MANUFACTURING

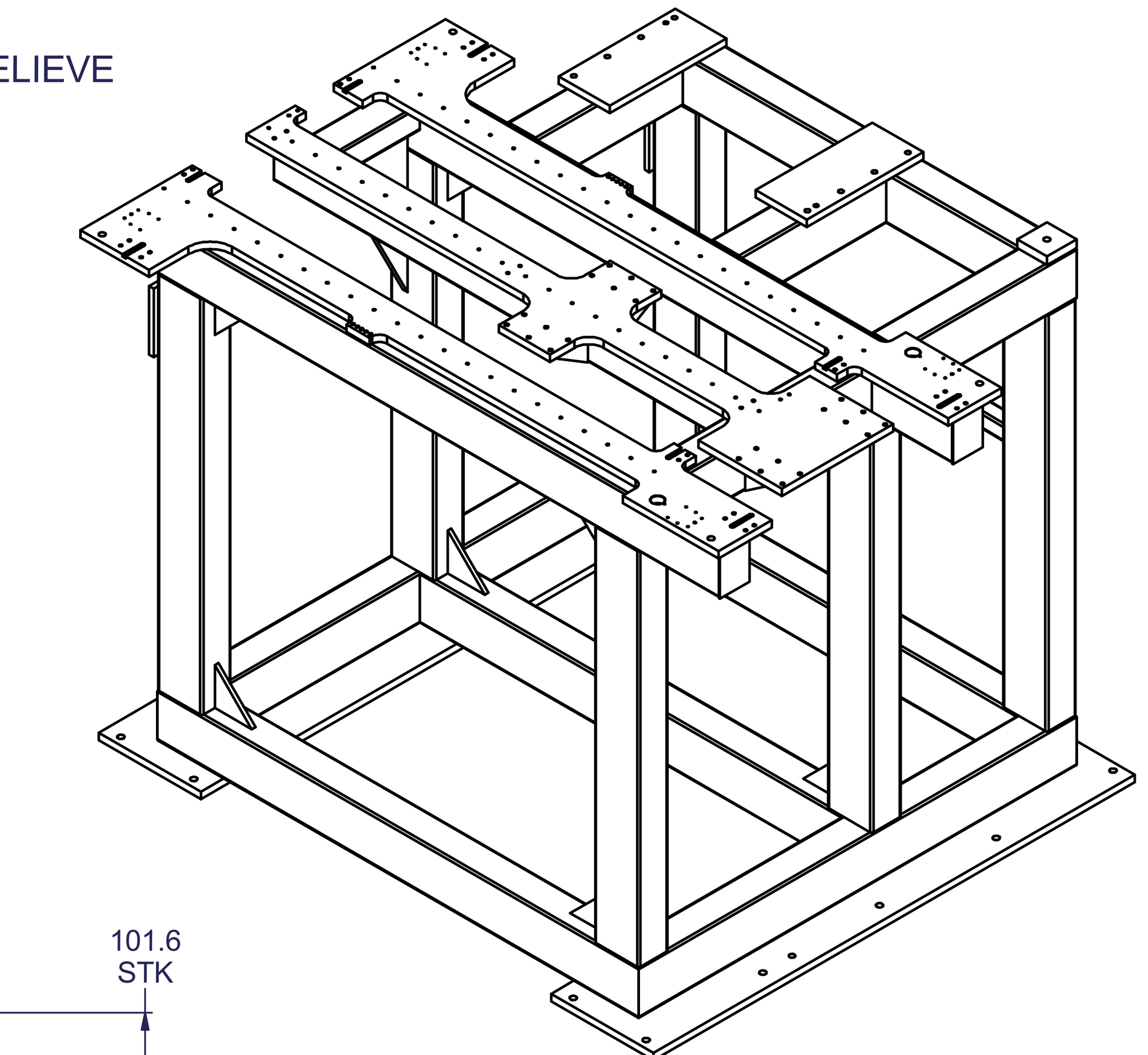
PROCESS	STATUS
CUT	
WELDING	
STRESS RELIEVED	
MACHINING	
PAINT	

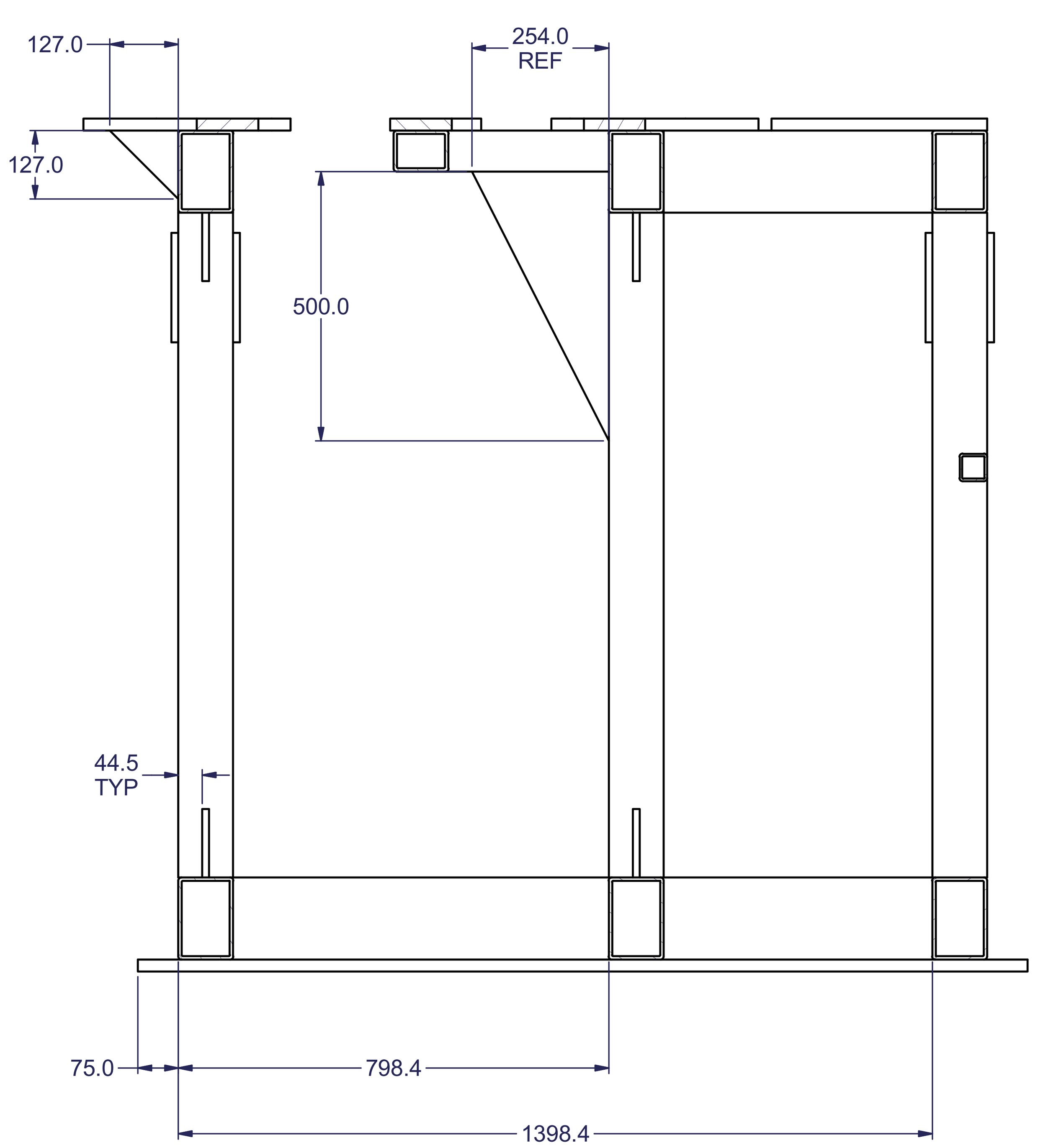
51 BASE FRAME
WELDED CONST. - STRESS RELIEVE



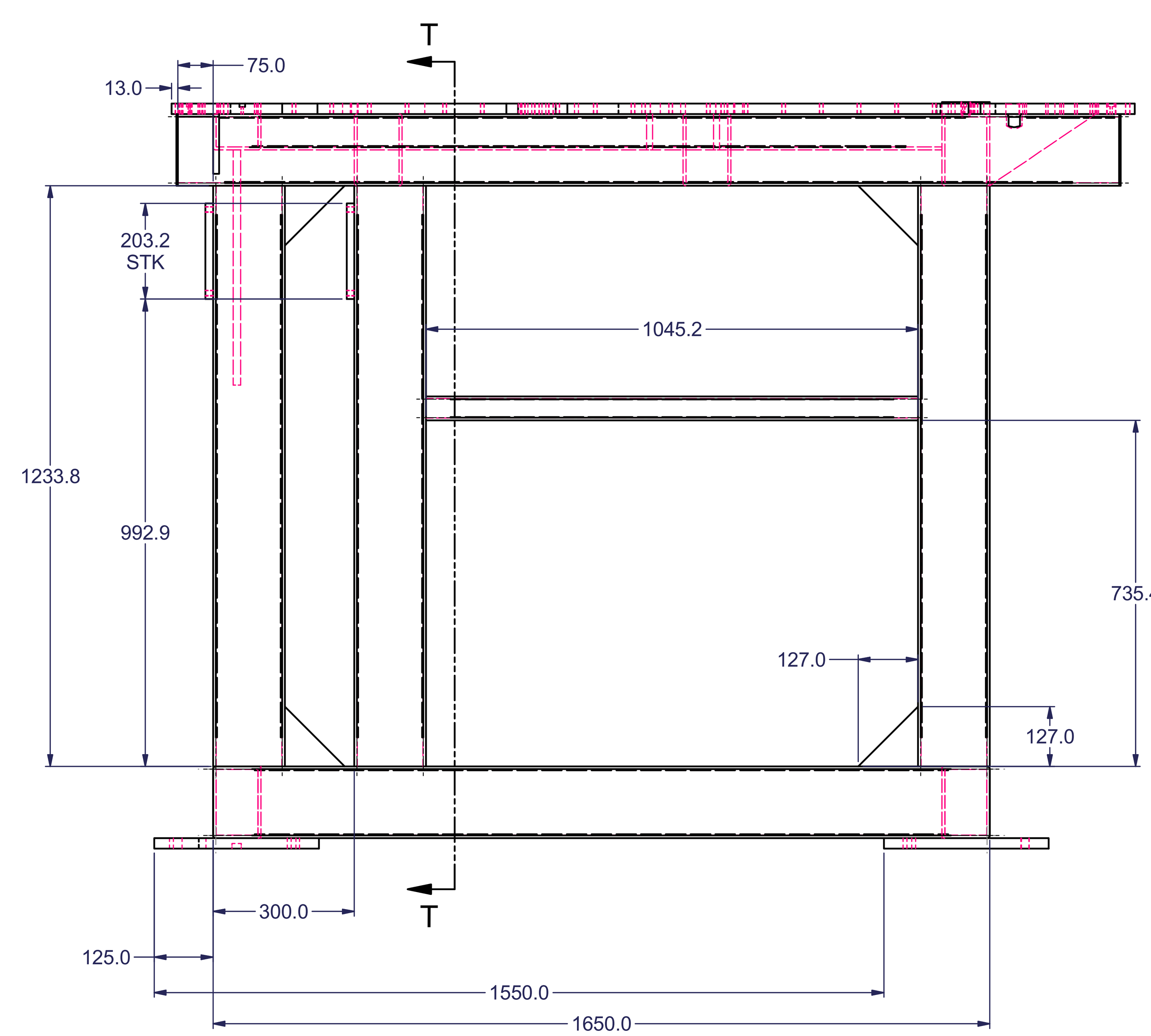


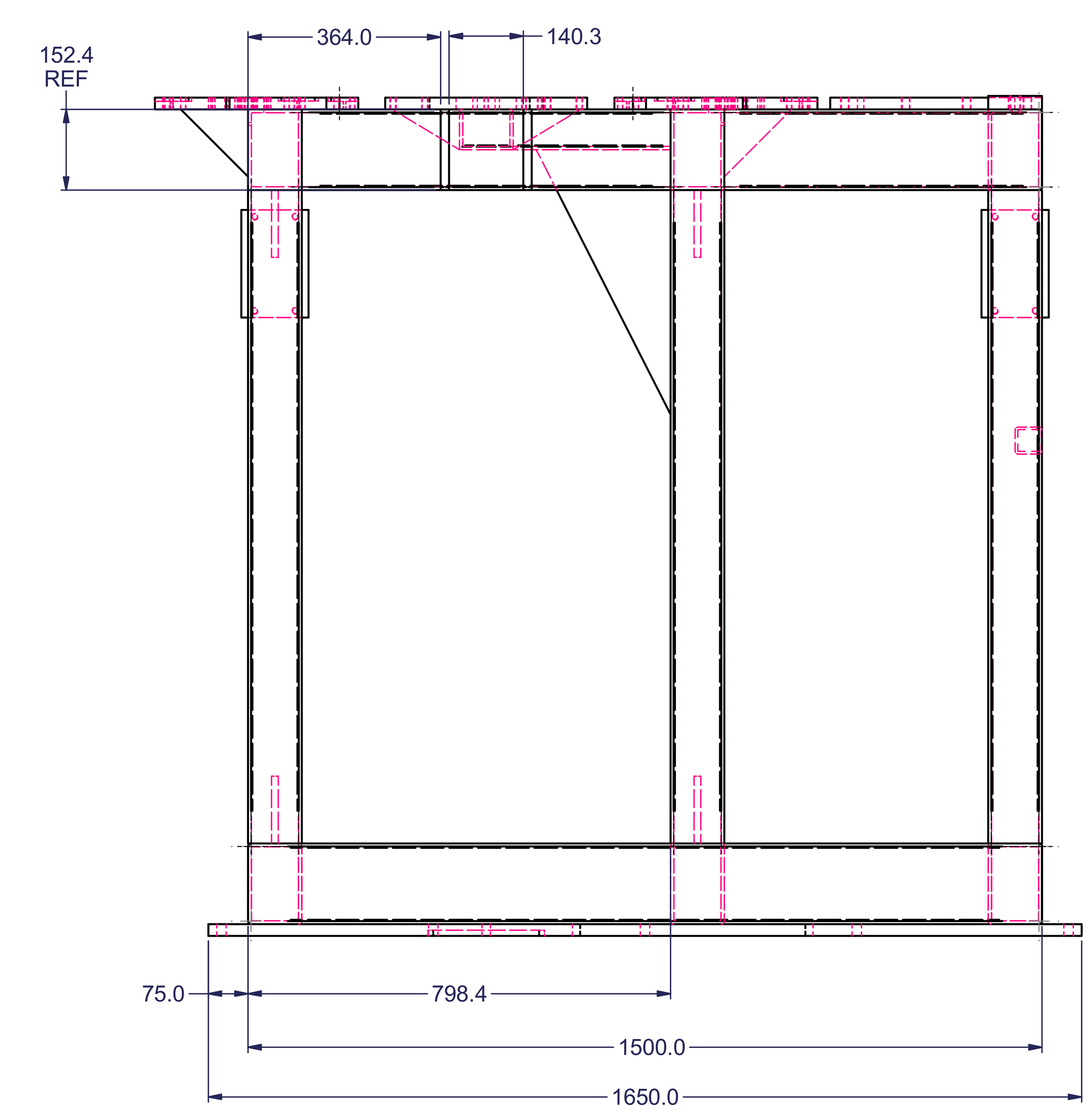
SECTION U-U
SCALE .1





SECTION T-T
SCALE .1





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 INDENTIFICATION AND MATERIAL NUMBERS ON DETAILS.
PAINT INDENTIFICATION 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):	N/A

COTO: 202115

☐ MOVIL PART RAL ■ FIXED PART RAL ☐ BLACK OXIDE ☐ WITH OUT PAINT ☐ 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
MAGNA	MAGNA	NAVISTAR

DESIGNER	DETAILER	
ISRAEL E.	3D&2DGROUP	3RD ANGLE PROYECTION

PROJECT MGR.	DESIGN SUP.	CHECKER
A. RANGEL	CAVARGAS	CAVARGAS

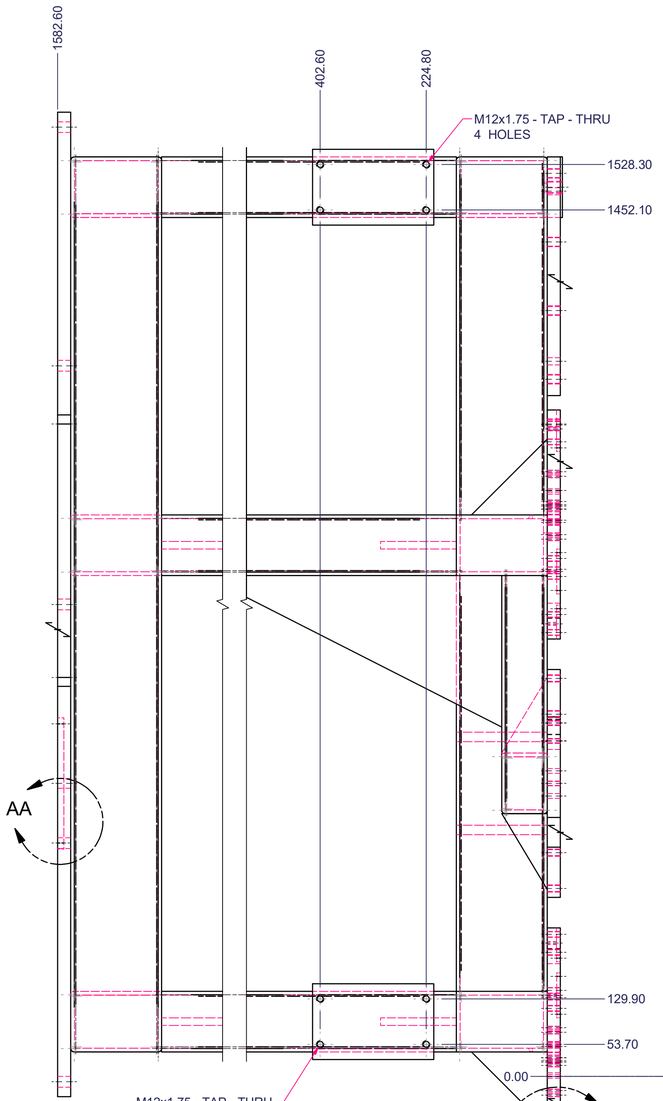
SYSTEM NAME: E79 CAB NEXT GEN

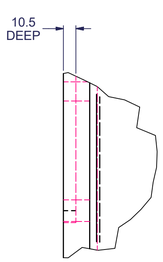
DESCRIPTION: CABINE

SCALE	SHEET	RELEASE DATE
NONE	2 OF 7	3/1/2018

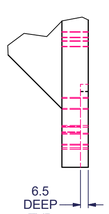
DRAWING No.
SHOWN: E79_CAB_ST020_G0251-BFWCFX
OPPOSITE

C:\Wksp\2021-15\04 Mechanical Design\4.4 Design 100%\4.4.1 Concept\E79_CAB_ST020_G\E79_CAB_ST020_G\2D\E79_CAB_ST020_G0251-BFWCFX.idw

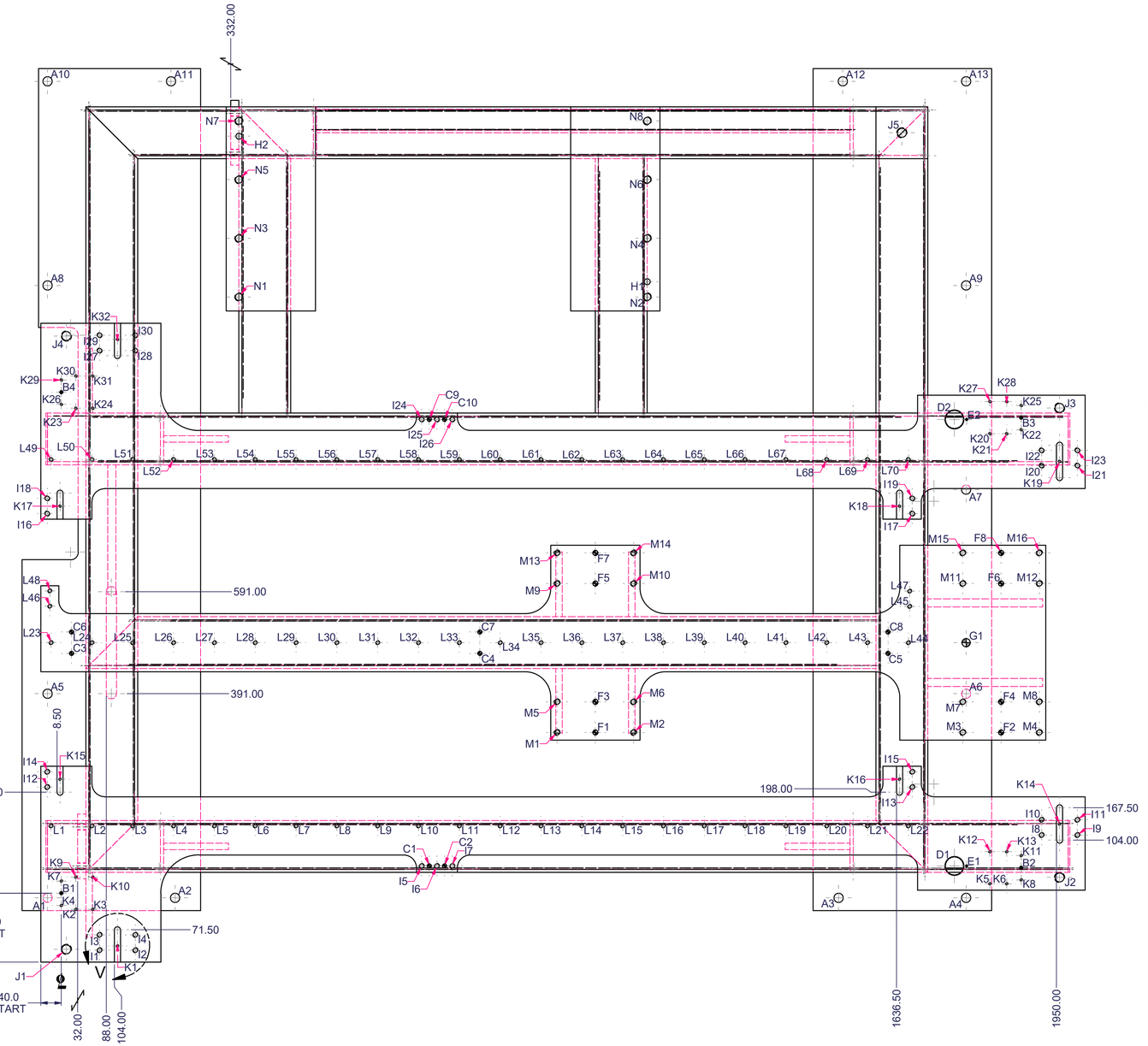


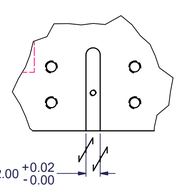


DETAIL AA
SCALE 0.40 : 1



DETAIL AB
SCALE 0.40 : 1





DETAIL V
SCALE 0.40 : 1

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

CRITICAL FEATURES ARE MARKED WITH "*"

UNIT No.:	02
WEIGHT (KG):	N/A

COTO: 202115

- ☐ MOVIL PART RAL
- ☐ FIXED PART RAL
- ☐ BLACK OXIDE
- ☐ WITH OUT PAINT
- ☐ POKA YOKE PAINT

DESIGN SOURCE	BUILD SOURCE	CUSTOMER
MAGNA	MAGNA	NAVISTAR

DESIGNER	DETAILER	
ISRAEL E.	3D&2DGROUP	3RD ANGLE PROYECTION

PROJECT MGR.	DESIGN SUP.	CHECKER
A. RANGEL	CAVARGAS	CAVARGAS

SYSTEM NAME: E79 CAB NEXT GEN

DESCRIPTION: CABINE

SCALE	SHEET	RELEASE DATE
NONE	3 OF 7	3/1/2018

DRAWING No.: SHOWN: E79_CAB_ST020_G0251-BFWCFX

OPPOSITE

C:\Wksp\2021-10\04 Mechanical Design\4.4 Design 10\Wt4.4.1 Concept\E79_CAB_ST020_G\E79_CAB_ST020_G\2\E79_CAB_ST020_G0251-BFWCFX.idw

Aplica:CIMS FID-08-1, VER.3
Resp: L. Luna Fecha: 10/07/2020

Hole Table			
HOLE	XDIM	YDIM	DESCRIPTION
A1	-27.00	-9.00	Ø18 -DRILL THRU - HOLES
A2	223.00	-9.00	
A3	1523.00	-9.00	
A4	1773.00	-9.00	
A5	-27.00	391.00	
A6	1773.00	391.00	
A7	1773.00	791.00	
A8	-27.00	1191.00	
A9	1773.00	1191.00	
A10	-27.00	1591.00	
A11	214.82	1591.00	
A12	1531.18	1591.00	
A13	1773.00	1591.00	
B1	0.00	0.00	FOR Ø6 -DWL H7- THRU - HOLES
B2	1881.00	50.00	
B3	1881.00	932.00	
B4	0.00	982.00	
C1	721.00	53.50	FOR Ø8 -DWL H7- THRU - HOLES
C2	751.00	53.50	
C3	20.00	470.00	
C4	820.00	470.00	
C5	1620.00	470.00	
C6	20.00	512.00	
C7	820.00	512.00	
C8	1620.00	512.00	
C9	721.00	928.50	
C10	751.00	928.50	
D1	1750.00	53.50	FOR Ø35 -DWL H7- THRU - HOLES
D2	1750.00	928.50	
E1	1774.00	53.50	FOR Ø4 -DWL H7- THRU - HOLES
E2	1774.00	928.50	
F1	1046.50	315.00	FOR Ø10 -DWL H7- THRU - HOLES
F2	1841.50	315.00	
F3	1046.50	375.00	
F4	1841.50	375.00	
F5	1046.50	607.00	
F6	1841.50	607.00	
F7	1046.50	667.00	
F8	1841.50	667.00	
G1	1773.00	491.00	FOR Ø16 -DWL H7- THRU - HOLES
H1	1148.00	1198.50	FOR Ø12 -DWL H7- THRU - HOLES
H2	348.00	1483.50	

Hole Table			
HOLE	XDIM	YDIM	DESCRIPTION
I1	75.00	-111.50	M10x1.5 - TAP - THRU HOLES
I2	145.00	-111.50	
I3	75.00	-81.50	
I4	145.00	-81.50	
I5	706.00	53.50	
I6	736.00	53.50	
I7	766.00	53.50	
I8	1921.00	114.00	
I9	1991.00	114.00	
I10	1921.00	144.00	
I11	1991.00	144.00	
I12	-27.50	208.00	
I13	1667.50	208.00	
I14	-27.50	238.00	
I15	1667.50	238.00	
I16	-27.50	744.00	
I17	1667.50	744.00	
I18	-27.50	774.00	
I19	1667.50	774.00	
I20	1921.00	838.00	
I21	1991.00	838.00	
I22	1921.00	868.00	
I23	1991.00	868.00	
I24	706.00	928.50	
I25	736.00	928.50	
I26	766.00	928.50	
I27	75.00	1063.50	
I28	145.00	1063.50	
I29	75.00	1093.50	
I30	145.00	1093.50	
J1	10.00	-110.00	M20x2.5 - TAP - THRU HOLES
J2	1956.00	31.00	
J3	1956.00	951.00	
J4	10.00	1092.00	
J5	1647.20	1490.20	
K1	110.00	-103.25	M5x0.8 - TAP - THRU HOLES
K2	28.50	-31.50	
K3	61.50	-31.50	
K4	0.00	-23.88	
K5	1819.50	18.50	
K6	1852.50	18.50	
K7	0.00	23.88	
K8	1881.00	26.12	
K9	28.50	31.50	
K10	61.50	31.50	

Hole Table			
HOLE	XDIM	YDIM	DESCRIPTION
K11	1881.00	73.88	M5x0.8 - TAP - THRU HOLES
K12	1819.50	81.50	
K13	1852.50	81.50	
K14	1956.00	135.75	
K15	-2.50	223.50	
K16	1642.50	223.50	
K17	-2.50	758.50	
K18	1642.50	758.50	
K19	1956.00	846.25	
K20	1819.50	900.50	
K21	1852.50	900.50	
K22	1881.00	908.12	
K23	28.50	950.50	
K24	61.50	950.50	
K25	1881.00	955.88	
K26	0.00	958.12	
K27	1819.50	963.50	
K28	1852.50	963.50	
K29	0.00	1005.88	
K30	28.50	1013.50	
K31	61.50	1013.50	
K32	110.00	1085.25	
L1	-20.00	132.00	M8x1.25 - TAP - THRU HOLES
L2	60.00	132.00	
L3	140.00	132.00	
L4	220.00	132.00	
L5	300.00	132.00	
L6	380.00	132.00	
L7	460.00	132.00	
L8	540.00	132.00	
L9	620.00	132.00	
L10	700.00	132.00	
L11	780.00	132.00	
L12	860.00	132.00	
L13	940.00	132.00	
L14	1020.00	132.00	
L15	1100.00	132.00	
L16	1180.00	132.00	
L17	1260.00	132.00	
L18	1340.00	132.00	
L19	1420.00	132.00	
L20	1500.00	132.00	
L21	1580.00	132.00	
L22	1660.00	132.00	
L23	-20.00	491.00	

Hole Table			
HOLE	XDIM	YDIM	DESCRIPTION
L24	60.00	491.00	M8x1.25 - TAP - THRU HOLES
L25	140.00	491.00	
L26	220.00	491.00	
L27	300.00	491.00	
L28	380.00	491.00	
L29	460.00	491.00	
L30	540.00	491.00	
L31	620.00	491.00	
L32	700.00	491.00	
L33	780.00	491.00	
L34	860.00	491.00	
L35	940.00	491.00	
L36	1020.00	491.00	
L37	1100.00	491.00	
L38	1180.00	491.00	
L39	1260.00	491.00	
L40	1340.00	491.00	
L41	1420.00	491.00	
L42	1500.00	491.00	
L43	1580.00	491.00	
L44	1660.00	491.00	
L45	1662.50	562.00	
L46	-22.50	562.50	
L47	1662.50	592.00	
L48	-22.50	592.50	
L49	-20.00	850.00	
L50	60.00	850.00	
L51	140.00	850.00	
L52	220.00	850.00	
L53	300.00	850.00	
L54	380.00	850.00	
L55	460.00	850.00	
L56	540.00	850.00	
L57	620.00	850.00	
L58	700.00	850.00	
L59	780.00	850.00	
L60	860.00	850.00	
L61	940.00	850.00	
L62	1020.00	850.00	
L63	1100.00	850.00	
L64	1180.00	850.00	
L65	1260.00	850.00	
L66	1340.00	850.00	
L67	1420.00	850.00	
L68	1500.00	850.00	

Hole Table			
HOLE	XDIM	YDIM	DESCRIPTION
L69	1580.00	850.00	M8x1.25 - TAP - THRU HOLES
L70	1660.00	850.00	
M1	971.50	315.00	M12x1.75 - TAP - THRU HOLES
M2	1121.50	315.00	
M3	1766.50	315.00	
M4	1916.50	315.00	
M5	971.50	375.00	
M6	1121.50	375.00	
M7	1766.50	375.00	
M8	1916.50	375.00	
M9	971.50	607.00	
M10	1121.50	607.00	
M11	1766.50	607.00	
M12	1916.50	607.00	
M13	971.50	667.00	
M14	1121.50	667.00	
M15	1766.50	667.00	
M16	1916.50	667.00	
N1	348.00	1168.50	M16x2 - TAP - THRU HOLES
N2	1148.00	1168.50	
N3	348.00	1283.50	
N4	1148.00	1283.50	
N5	348.00	1398.50	
N6	1148.00	1398.50	
N7	348.00	1513.50	
N8	1148.00	1513.50	

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 INDENTIFICATION AND MATERIAL NUMBERS ON DETAILS. PAINT INDENTIFICATION NUMBERS ON STRUCTURAL WORK.

CRITICAL FEATURES ARE MARKED WITH "*"

UNIT No.:	**02**
WEIGHT (KG):	N/A

COTO: 202115

- ☐ MOVIL PART RAL
- ☐ FIXED PART RAL
- ☐ BLACK OXIDE
- ☐ WITH OUT PAINT
- ☐ POKA YOKE PAINT

DESIGN SOURCE	BUILD SOURCE	CUSTOMER
MAGNA	MAGNA	NAVISTAR

DESIGNER	DETAILER	
ISRAEL E.	3D&2DGROUP	3RD ANGLE PROYECTION

PROJECT MGR.	DESIGN SUP.	CHECKER
A. RANGEL	CAVARGAS	CAVARGAS

SYSTEM NAME: E79 CAB NEXT GEN

DESCRIPTION: CABINE

SCALE	SHEET	RELEASE DATE
NONE	4 OF 7	3/1/2018

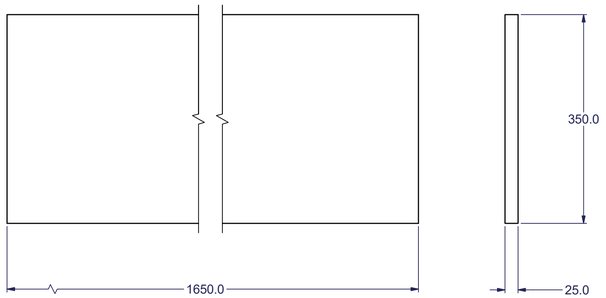
DRAWING No.: SHOWN: E79_CAB_ST020_G0251-BFWCFX

OPPOSITE

C:\Wksp\2021-15\04 Mechanical Design\4.4 Design 100%\4.4.1 Concept\E79_CAB_ST020_G\E79_CAB_ST020_G\2D\E79_CAB_ST020_G0251-BFWCFX.idw

Aplica:CIMS FID-08-1, VER.3
Resp: L. Luna Fecha: 10/07/2020

ITEM "a"



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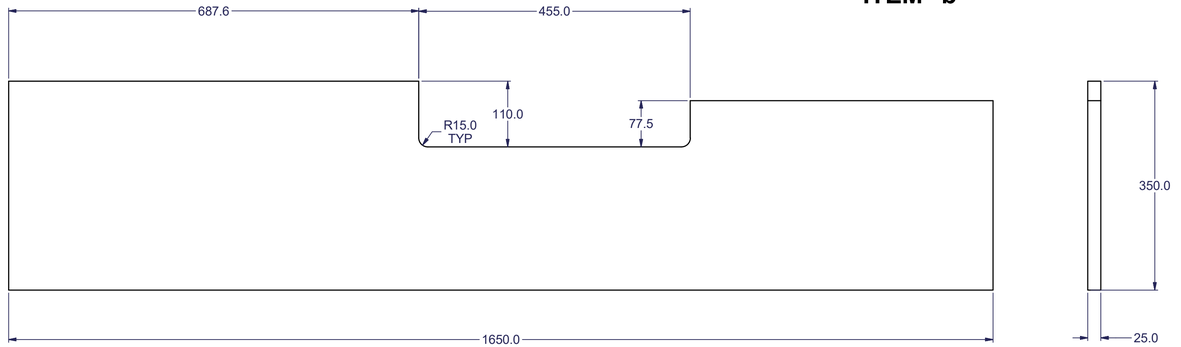

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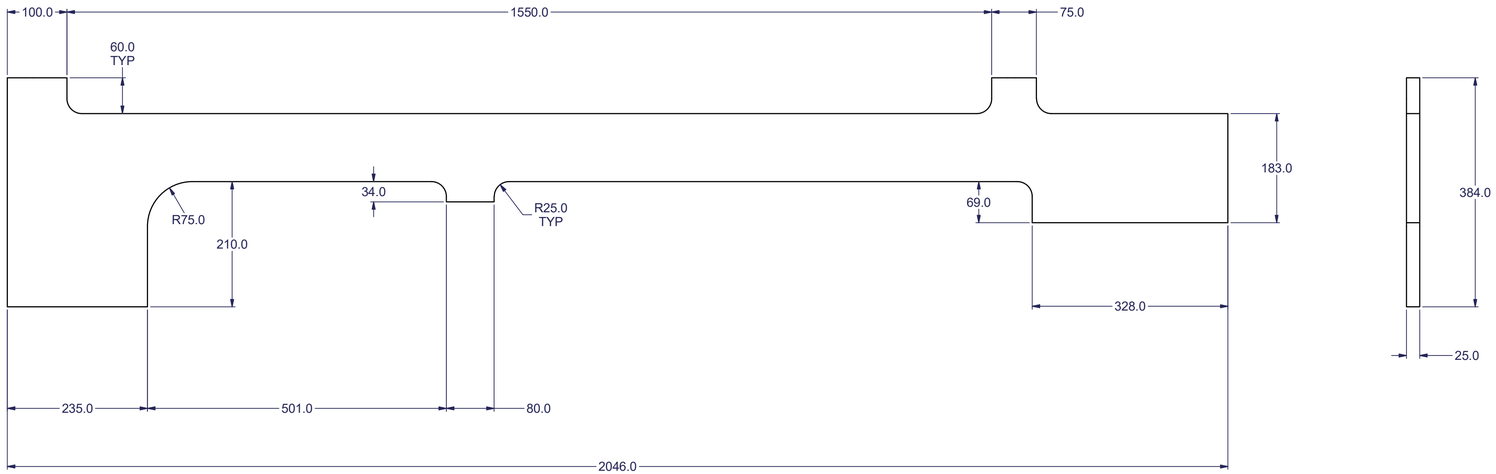

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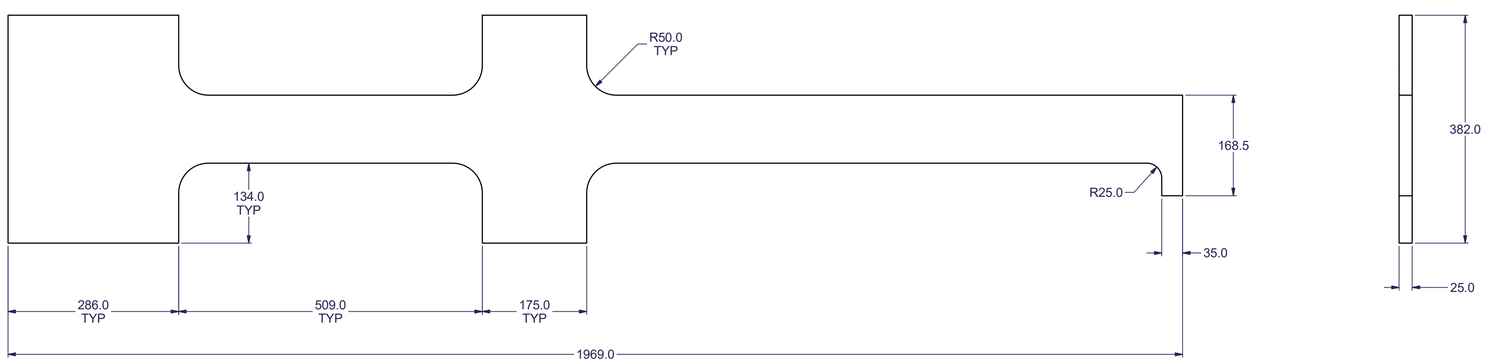


COSMA INNOVATIVE MANUFACTURING SOLUTIONS

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 INDENTIFICATION AND MATERIAL NUMBERS ON DETAILS.
PAINT INDENTIFICATION NUMBERS ON STRUCTURAL WORK.

CRITICAL FEATURES ARE MARKED WITH "*"

UNIT No.:	**02**
WEIGHT (KG):	99.39 kg

COTO: 202115

- ☐ MOVIL PART RAL
- ☐ FIXED PART RAL
- ☐ BLACK OXIDE
- ☐ WITH OUT PAINT
- ☐ POKA YOKE PAINT

DESIGN SOURCE	BUILD SOURCE	CUSTOMER
MAGNA	MAGNA	NAVISTAR

DESIGNER	DETAILER	
ISRAEL E.	3D&2DGROUP	3RD ANGLE PROYECTION

PROJECT MGR.	DESIGN SUP.	CHECKER
A. RANGEL	CAVARGAS	CAVARGAS

SYSTEM NAME: E79 CAB NEXT GEN

DESCRIPTION: CABINE

SCALE	SHEET	RELEASE DATE
NONE	5 OF 7	3/1/2018

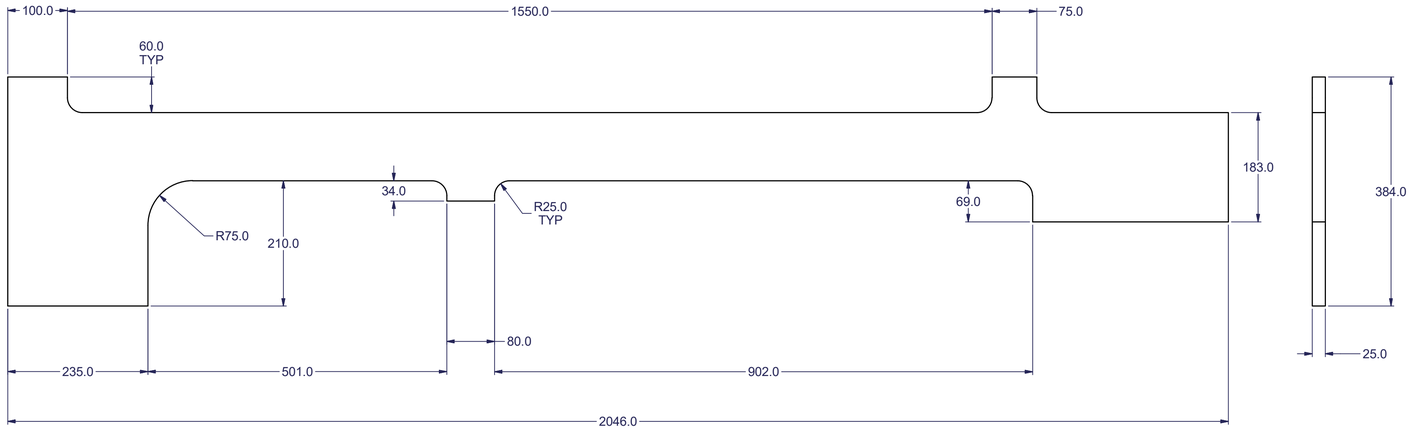
DRAWING No.: SHOWN: E79_CAB_ST020_G0251-BFWCFX-a

OPPOSITE

C:\Wisp\2021-15\04 Mechanical Design\4.4 Design 100%\4.4.1 Concept\E79_CAB_ST020_GE\E79_CAB_ST020_G\2D\E79_CAB_ST020_G0251-BFWCFX.idw

Aplica:CIMS FID-08-1, VER.3
Resp: L. Luna Fecha: 10/07/2020

ITEM "e"



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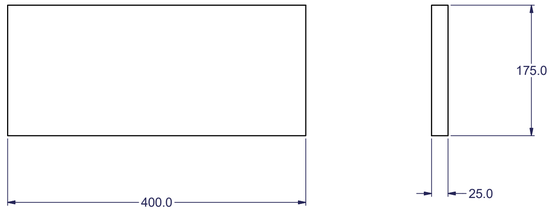

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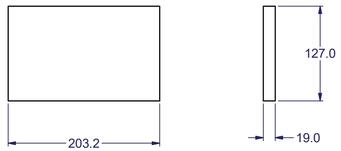

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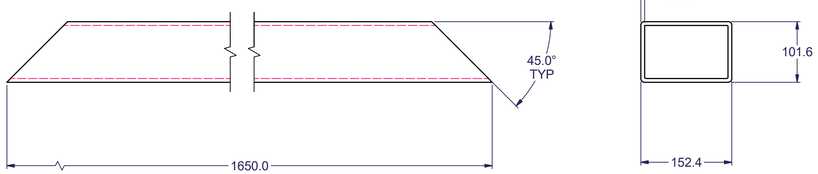

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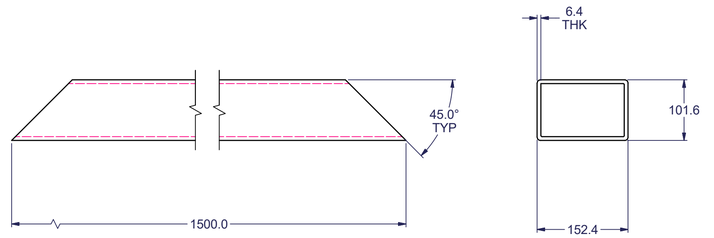

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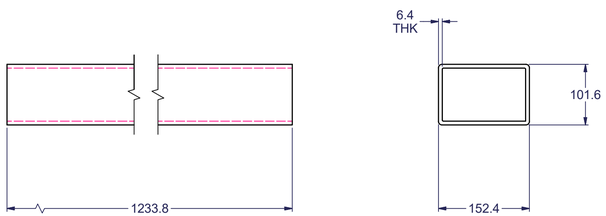

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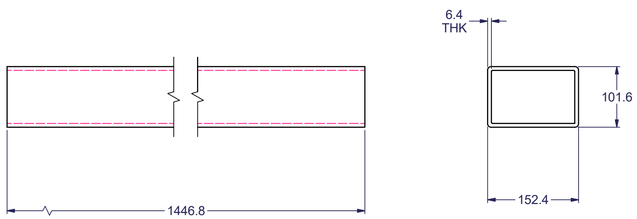

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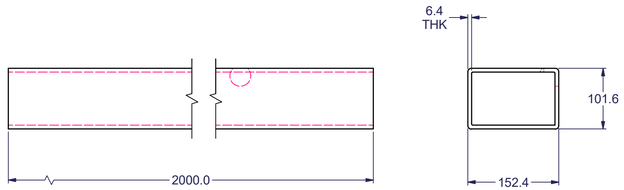

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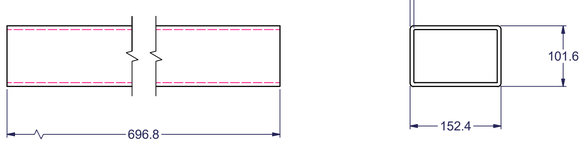

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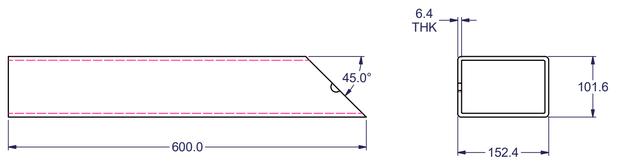

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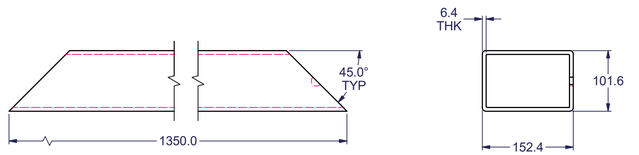

COSMA INNOVATIVE MANUFACTURING SOLUTIONS			
REV	CHANGE	CHK'D	DATE

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 INDENTIFICATION AND MATERIAL NUMBERS ON DETAILS.
PAINT INDENTIFICATION NUMBERS ON STRUCTURAL WORK.

CRITICAL FEATURES ARE MARKED WITH "*"

UNIT No.:	**02**
WEIGHT (KG):	54.61 kg

COTO: 202115

- ☐ MOVIL PART RAL
- ☐ FIXED PART RAL
- ☐ BLACK OXIDE
- ☐ WITH OUT PAINT
- ☐ POKA YOKE PAINT

DESIGN SOURCE	BUILD SOURCE	CUSTOMER
MAGNA	MAGNA	NAVISTAR

DESIGNER	DETAILER	
ISRAEL E.	3D&2DGROUP	3RD ANGLE PROYECTION

PROJECT MGR.	DESIGN SUP.	CHECKER
A. RANGEL	CAVARGAS	CAVARGAS

SYSTEM NAME: E79 CAB NEXT GEN

DESCRIPTION: CABINE

SCALE	SHEET	RELEASE DATE
NONE	6 OF 7	3/1/2018

DRAWING No.: SHOWN E79_CAB_ST020_G0251-BFWCFX-e

OPPOSITE

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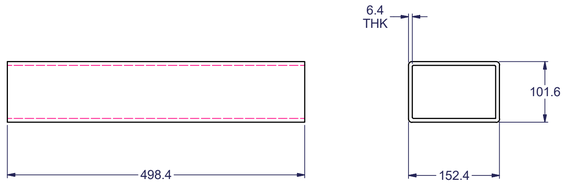
ITEM "u"



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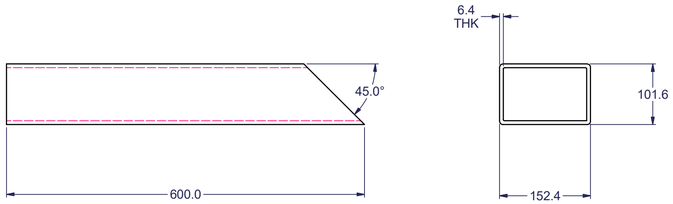

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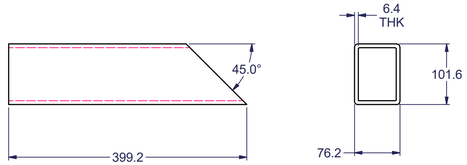

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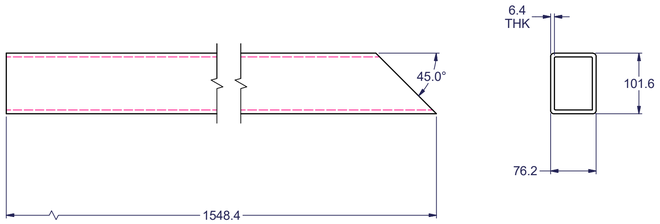

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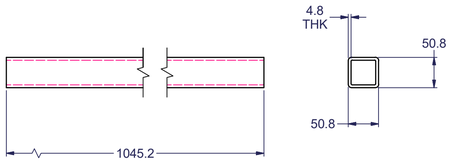

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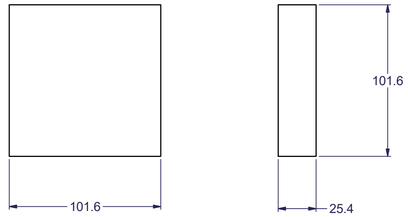

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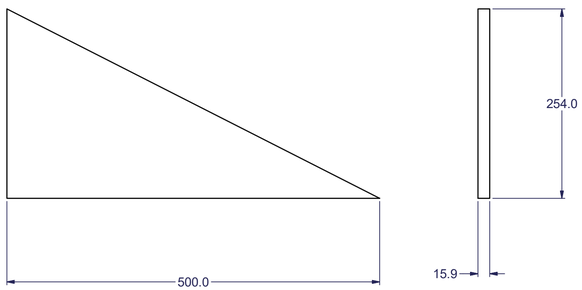

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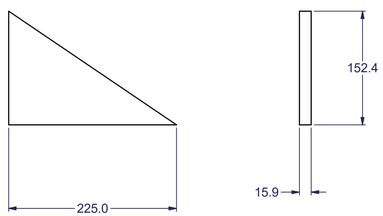

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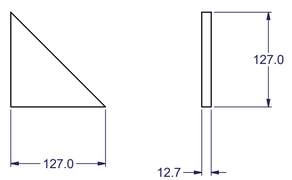

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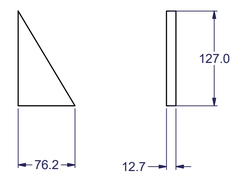

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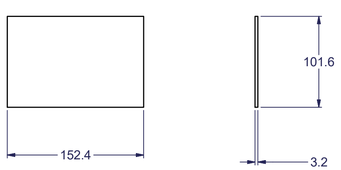

COSMA INNOVATIVE MANUFACTURING SOLUTIONS			
REV	CHANGE	CHK'D	DATE

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 INDENTIFICATION AND MATERIAL NUMBERS ON DETAILS.
PAINT INDENTIFICATION NUMBERS ON STRUCTURAL WORK.

CRITICAL FEATURES ARE MARKED WITH "*"

UNIT No.:	02
WEIGHT (KG):	11.89 kg

COTO: 202115

- ☐ MOVIL PART RAL
- ☐ FIXED PART RAL
- ☐ BLACK OXIDE
- ☐ WITH OUT PAINT
- ☐ POKA YOKE PAINT

DESIGN SOURCE	BUILD SOURCE	CUSTOMER
MAGNA	MAGNA	NAVISTAR

DESIGNER	DETAILER	
ISRAEL E.	3D&2DGROUP	3RD ANGLE PROYECTION

PROJECT MGR.	DESIGN SUP.	CHECKER
A. RANGEL	CAVARGAS	CAVARGAS

SYSTEM NAME: E79 CAB NEXT GEN

DESCRIPTION: CABINE

SCALE	SHEET	RELEASE DATE
NONE	7 OF 7	3/1/2018

DRAWING No.
SHOWN: E79_CAB_ST020_G0251-BFWCFX-u
OPPOSITE

C:\Wksp\2021-1504 Mechanical Design\4.4 Design 100%\4.4.1 Concept\E79_CAB_ST020_G\E79_CAB_ST020_G2D\E79_CAB_ST020_G0251-BFWCFX.idw

Aplica:CIMS FID-08-1, VER.3
Resp: L. Luna Fecha: 10/07/2020