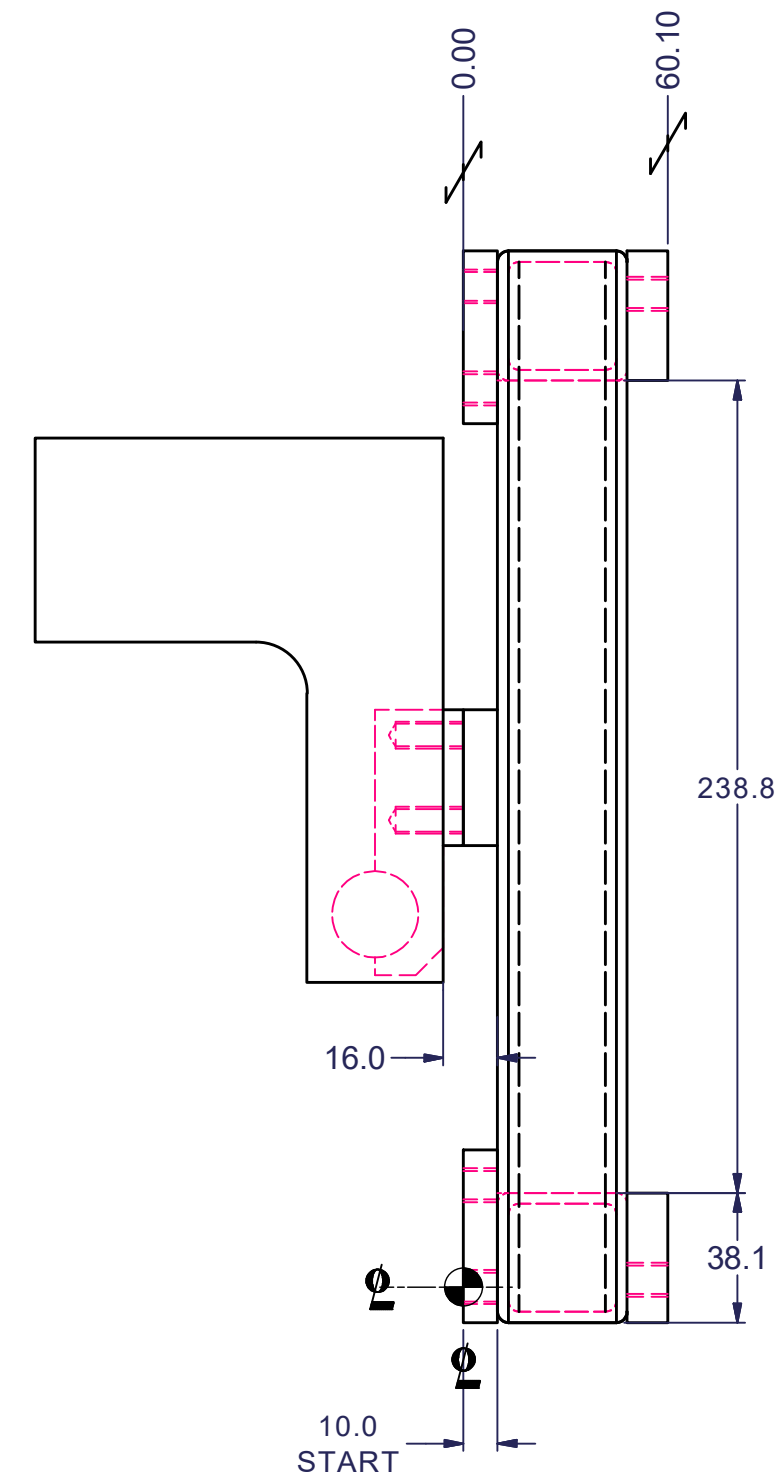


Stock List			
ITEM	QTY	MATERIAL	DESCRIPTION
a	2	HR-HRS	1/2" x 40.0mm x 75.0mm LG
b	1	ROUND TUBE	1" DIA x 960.0 mm LG
c	1	HR-HRS	1/2" x 120.0mm x 160.0mm LG
d	2	HR-HRS	1/2" x 1 1/2" x 140.0mm LG
e	2	HR-HRS	1" x 35.0mm x 80.0mm LG
f	2	SQ TUBE	1 1/2" x 1 1/2" x 1/8" x 630.0 mm LG
g	2	SQ TUBE	1 1/2" x 1 1/2" x 1/8" x 320.0 mm LG
k	2	SQ TUBE	1 1/2" x 1 1/2" x 1/8" x 240.0 mm LG
m	4	HR-HRS	1/2" x 2" x 4" LG
0151	1	W/C	BRACKET SUPPORT



Hole Table			
HOLE	XDIM	YDIM	DESCRIPTION
A1	0.000	0.000	M10x1.5 - TAP - THRU HOLES
A2	81.000	0.000	
A3	525.400	0.000	
A4	606.400	0.000	
A5	0.000	30.000	
A6	81.000	30.000	
A7	525.400	30.000	
A8	606.400	30.000	
A9	0.000	264.200	
A10	81.000	264.200	
A11	525.400	264.200	
A12	606.400	264.200	
A13	0.000	294.200	
A14	81.000	294.200	
A15	525.400	294.200	
A16	606.400	294.200	
B1	250.700	2.200	M10x1.5 - TAP - THRU HOLES FAR SIDE
B2	285.700	2.200	
B3	320.700	2.200	
B4	355.700	2.200	
B5	250.700	292.000	
B6	285.700	292.000	
B7	320.700	292.000	
B8	355.700	292.000	
C1	150.300	137.272	M8x1.25 - TAP 20.0 DEEP HOLES FAR SIDE
C2	170.300	137.272	
C3	436.100	137.272	
C4	456.100	137.272	
C5	150.300	162.272	
C6	170.300	162.272	
C7	436.100	162.272	
C8	456.100	162.272	

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  
MATERIALS

1 PLACE MIN FINISH DIMENSIONS TO BE 3.2 MICRONS  
2 PLACE MIN FINISH DIMENSIONS TO BE 1.6 MICRONS  
3 PLACE MIN FINISH DIMENSIONS TO BE 0.8 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 MANGLED SURFACES  
0.05 BETWEEN POLISHED SURFACES AND A HEEL SURFACE  
0.03 BETWEEN DOWELS IN THE SAME PLANE  
0.10 BETWEEN DOWELS IN DIFFERENT PLANES  
0.05 TO SCREW HOLES, NON ACCUMULATIVE

ALL O SURFACES MUST BE FINISHED EXCEPT FOR COLD  
DRAWN SURFACES.

ALL EDGES OF PART CONTACT SURFACES ON LOCATING  
BUSHES AND FINGERS TO HAVE .12R INCH / 3.0mm  
AFTER SPOTTING.

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

CRITICAL FEATURES ARE MARKED WITH "R"

WELDMENTS.

ALL WELD FILLETS TO BE 1/4 INCH.  
ALL "V" GROOVES TO BE 30 DEGREE.  
ADVENT HOLES IN ALL SPOTWELDS WHERE TRAPPED  
AIR IS POSSIBLY, I.E. GROOVES, CRACKS, AND BOTH ENDS,  
BOXED FORMS IN ALL SPOTWELD SCREW AND / OR BOLT  
HOLES WHEN CLEARANCE FOR SCREW AND / OR BOLT  
HEADS AND WASHERS IS PRESCRIBED UPON BY WELD BEADS.

FOR BASES, APPLY CONTINUOUS  
WELDING AROUND OUTER SIDE. FOR SUPPORTS APPLY  
CONTINUOUS WELDING ELIMINATE SCRAP AFTER WELDING.  
CONTINUOUS WELDING CONSTRUCTION METHOD TO BE STRESS RELIEVED BY  
NORMALIZED. WELDMENT CONSTRUCTION METHOD TO BE MILLING  
AND DRILLING AFTER WELDING. WELDING DIAMETER SHALL BE MILLING  
MICRO WELD 0.45mm. WIRE DIAMETER BREAK SHARP EDGES


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

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  
INTERNATIONALNO RIGHTS  
ARE GRANTEDTO USE SUCH  
MATERIAL FOR ANY PURPOSE  
OTHER THAN FURNISHING OF  
SERVICES AND SUPPLIES

DESIGN SOURCE	BUILD SOURCE	CUSTOMER
 MAGNA	 MAGNA	FORMEX

DESIGNER K. MAR		DETAILER K. MAR		 3RD ANGLE PROJECTION
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R. MAR	R. MAR	PROTECTION
PROJECT MGR. A. RANGEL	DESIGN SUP. E. TORRES	CHECKER E. TORRES
SYSTEM NAME		

	RRC
DESCRIPTION	BEV3

SCALE	SHEET	RELEASE DATE
NONE	1 OF 2	3/1/2018
0	SHOWN	

DRAWING NO.	BEV3_RRC_ST019_Y-U01-0151-BSWCFW
	OPPOSITE

ONLY FOR MANUFACTURING	
PROCESS	
CUT	
WELDING	
STRESS RELIEVED	
MACHINING	
PAINT	

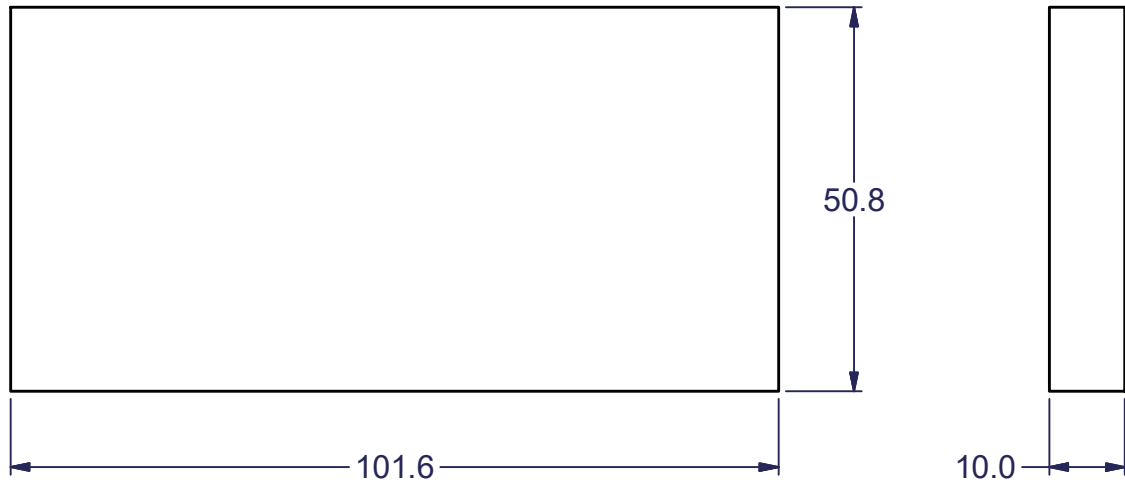
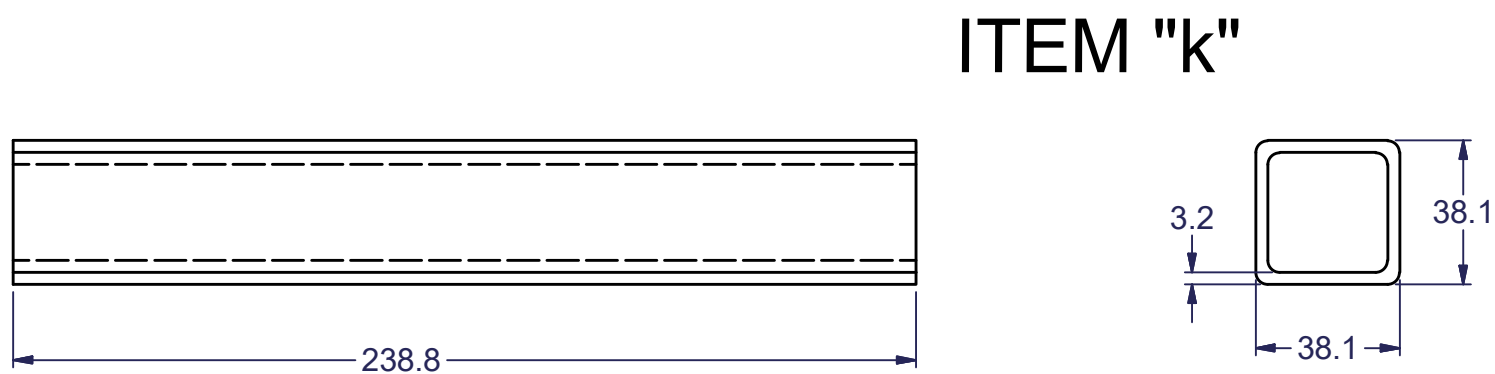
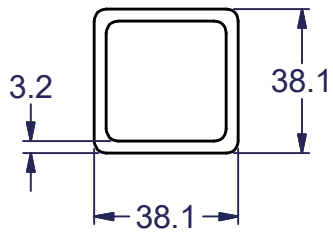
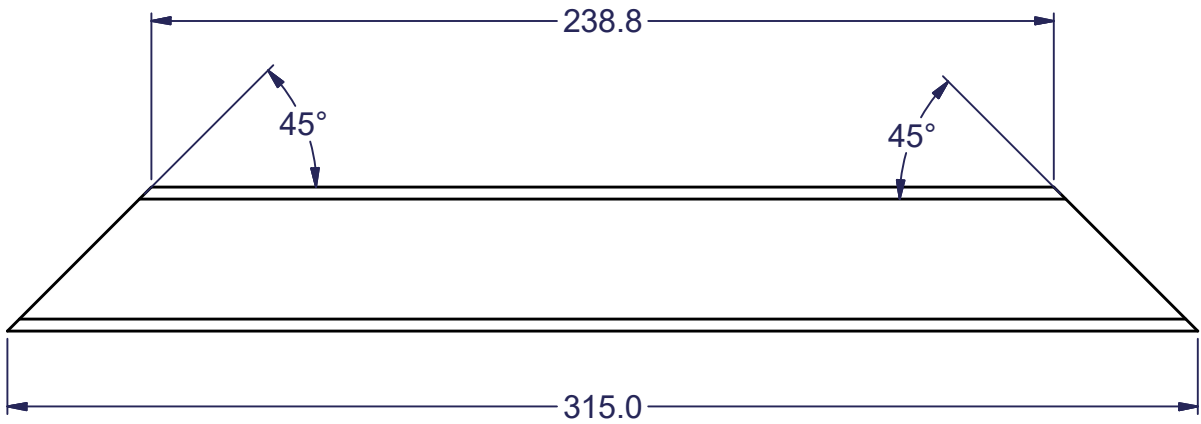
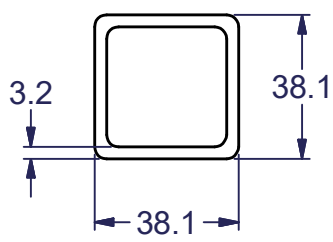
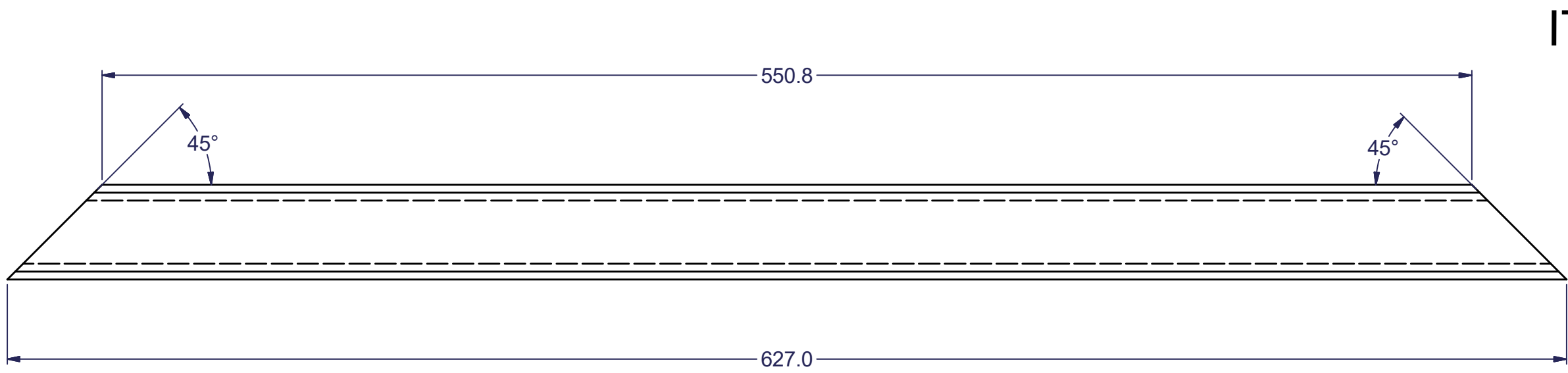
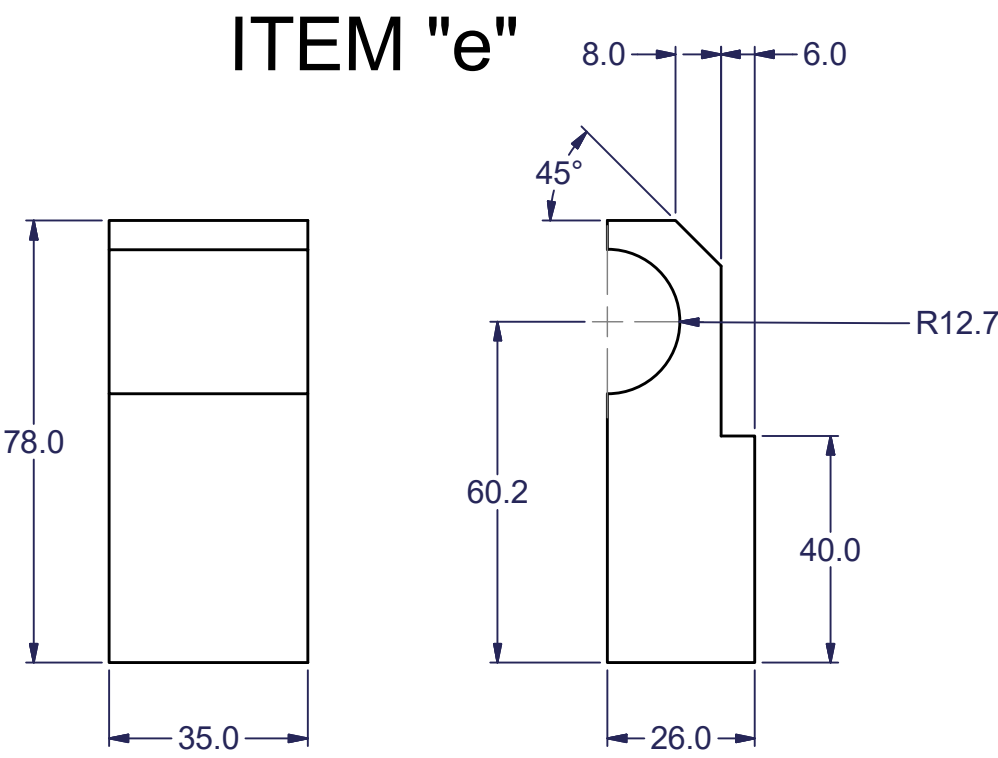
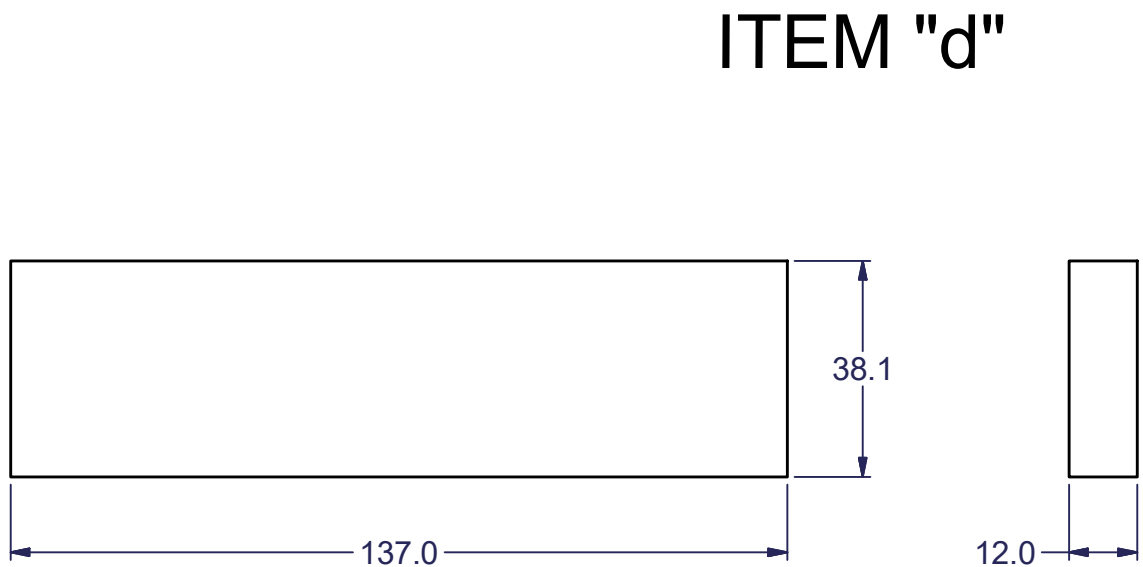
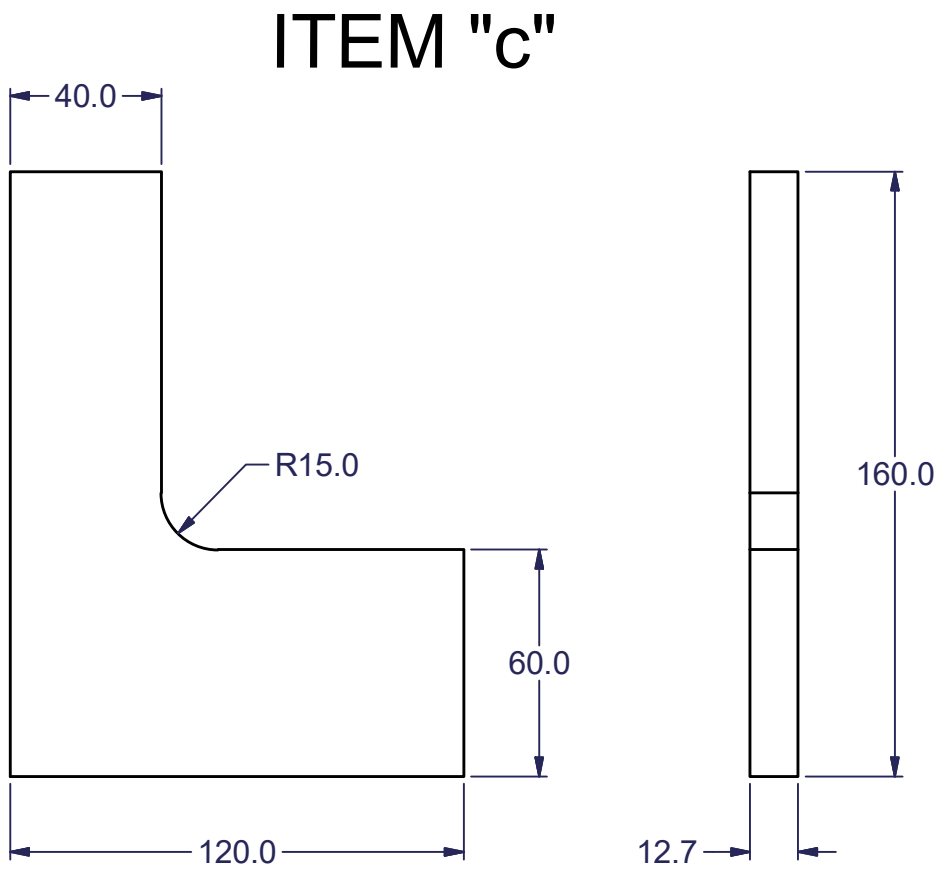
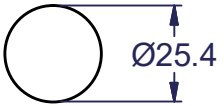
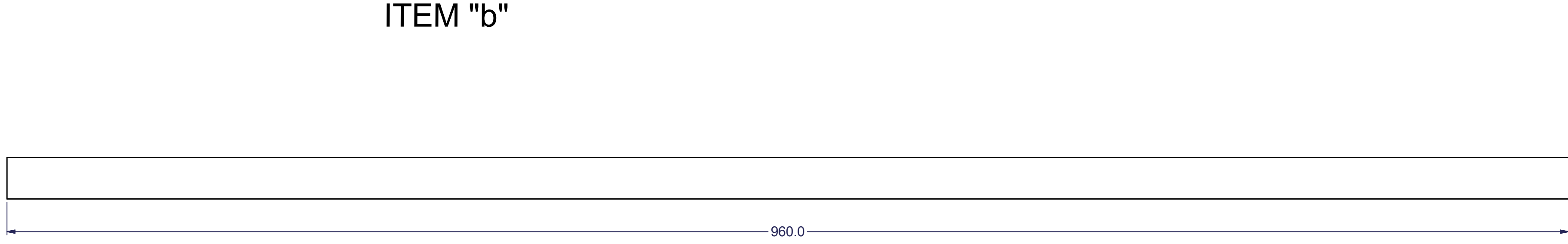
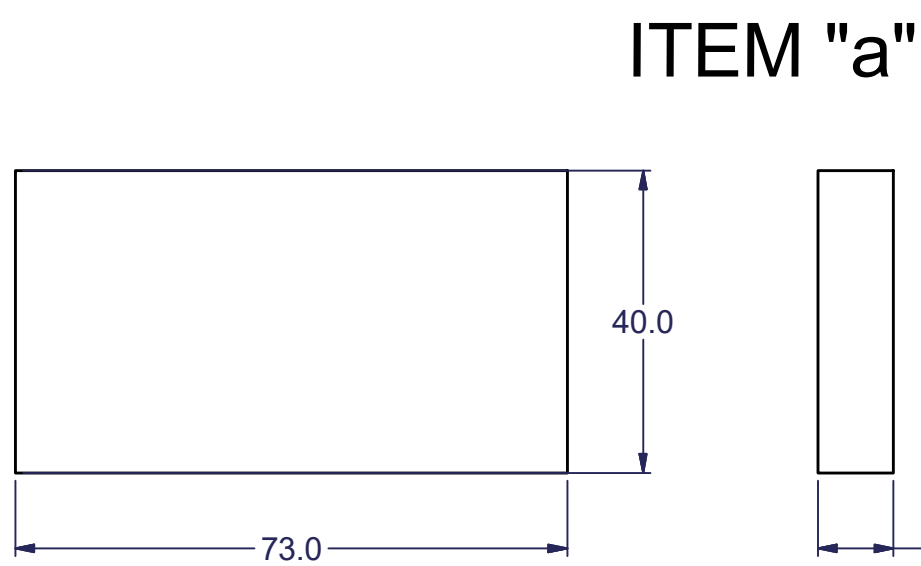
**"ONLY FOR WELDMENTS"**

1. THE WELDING APPLICATION IN MUST COMPLY WITH THE SPECIFICATION IN THE BOTTOM CHART
2. MUST INCLUDE VENTILATION HOLES IN ALL WEEDS WHERE AIR IS TRAPPED.
3. IS REQUIRED STRESS RELIEVED PROCESS IN THE WELDING AREA AFTER THE WELDING PROCESS AND
4. REQUIRES TO VISUAL REVIEW AND WITH PENETRATING LIQUID (CERTIFICATE MUST BE PROVIDED)
5. THE EXCEPTION FOR CONDITIONS DEFINED IN ITEM 5G) IS THE CASES OF JOINTS SUBJECT TO DYNAMIC LOADS, STRIKES EXPOSED TO THE WEATHER OR AGGRESSIVE ENVIRONMENTS OR TEMPERATURES LOWER THAN 0° C.

THE LONGITUDINAL JOINTS OF TWO PICES CAN BE CARRIED OUT BY DISCONTINUED WELDING PER INDICATION OF THE BOTTOM CHART

The diagram illustrates eight different welding joint types for butt plates:

- PLATE WITH DOUBLE OVERLAP BUTT JOINTS (75% weld coverage indicated)
- PLATE WITH BUTT PLATE (75% weld coverage indicated)
- WELD COAT SET BY SQUARE
- PLATE WITH OVERLAP BUTT JOINTS (75% weld coverage indicated)
- PLATE TO PLATE JOIN BY JOINT
- PLATE WITH HORIZONTAL BAY OR PLATE TO PLATE
- PLATE TO PLATE JOINT GUSSET
- ALTERNATE JOINT LOCATION



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  
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ALL O 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):		0.23 kg

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

DESIGN SOURCE	BUILD SOURCE	CUSTOMER
		FORMEX

DESIGNER K. MAR	DETAILER K. MAR	
--------------------	--------------------	--

PROJECT MGR. A. RANGEL	DESIGN SUP. E. TORRES	CHECKER E. TORRES
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SYSTEM NAME
RRC

DESCRIPTION
BEV3

SCALE NONE	SHEET 2 OF 2	RELEASE DATE 3/1/2018
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DRAWING No. BEV3_RRC_ST019_Y-U01-0151-BSWCFW-a
SHOWN
OPPOSITE