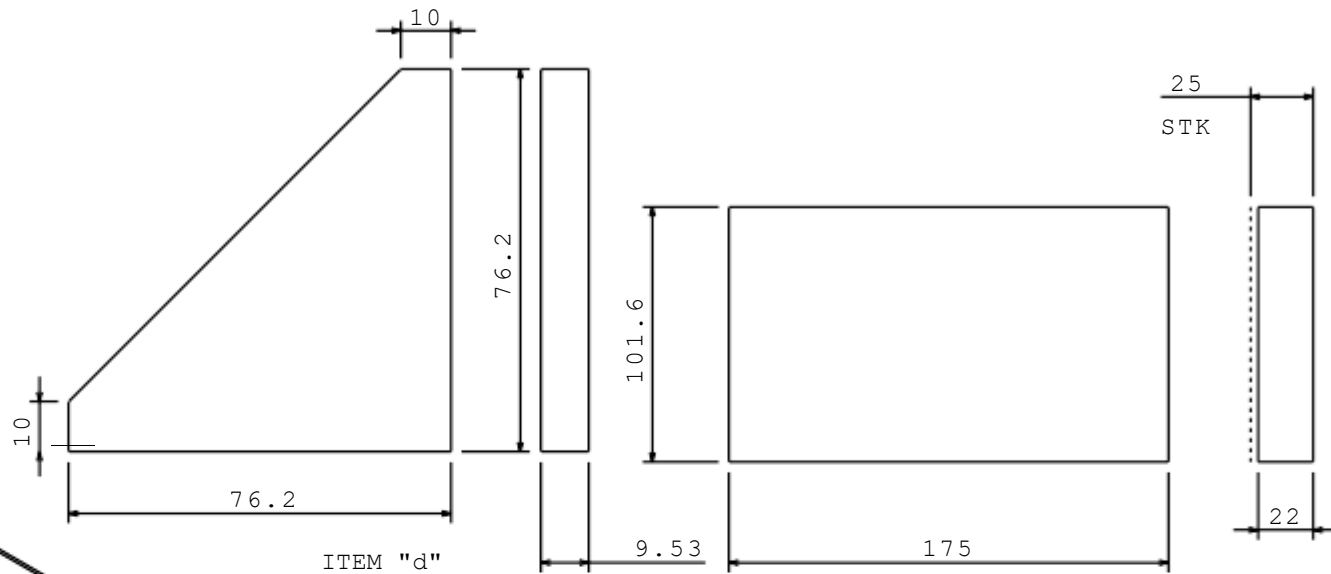
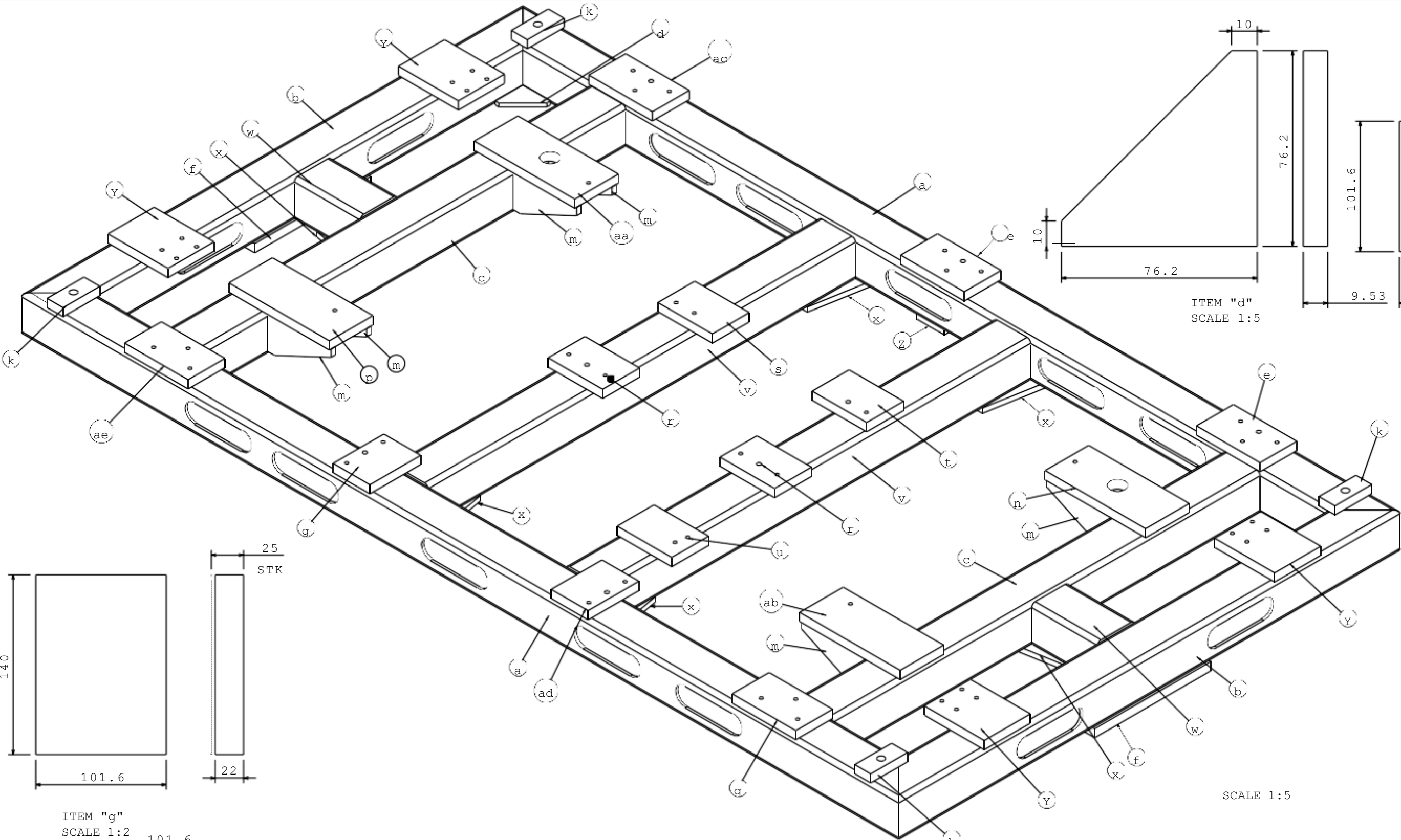
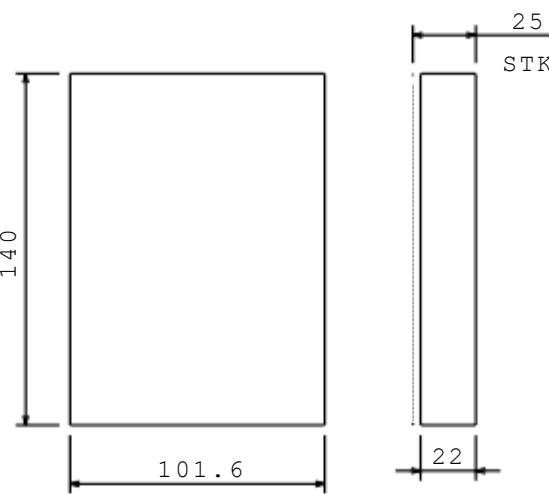


Stock List			
ITEM	QTY	MATERIAL	DESCRIPTION
a	2	PTR	1/4" X 4" X 4" X 2413mm LG.
b	2	PTR	1/4"X 4" X 4"X 1379 mm LG.
c	2	PTR	1/4"X 4" X 4"X 1176mm LG.
d	4	HRS	3/8" X 3" X 76.2 mm LG.
e	2	HRS	1"X 4" X 175 mm LG.
f	2	HRS	1"X 4" X 320 mm LG.
g	1	HRS	1" X 4" X 140 mm LG.
k	4	HRS	1" X 4" X 44 mm LG.
m	8	Steel	1/2" X 93mm X 175 mm LG.
n	1	Steel	1" X 120mm X 276.6 mm LG.
p	1	Steel	1" X 120mm X 276.6 mm LG.
q	1	HRS	1" X 4" X 175 mm LG.
r	2	HRS	1" X 4" X 150 mm LG.
s	1	HRS	1" X 4" X 150 MM LG.
t	1	HRS	1" X 4" X 150 MM LG.
u	1	HRS	1" X 4" X 150 MM LG.
v	2	PTR	1/4"X 4" X 4" X 1176mm LG.
w	2	PTR	1/4"X 4" X 4" X 181.4mm LG.
x	3	Steel	1/2" x 150mm X 200MM LG.
y	4	HRS	1" X 5" X 165.1mm LG.
z	2	HRS	1" X 3" X 76.2mm LG.
aa	1	Steel	1" X 120mm X 276.6mm LG.
ab	1	Steel	1" X 120mm X 276.6mm LG.
ac	1	HRS	1" X 4" X 175mm LG.
ad	1	HRS	1" X 4" X 140mm LG.
ae	1	HRS	1" X 4" X 175mm LG.

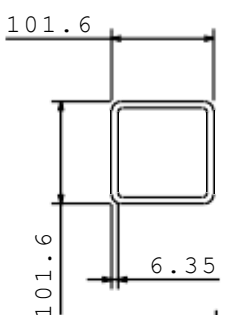


ITEM "d"
SCALE 1:5

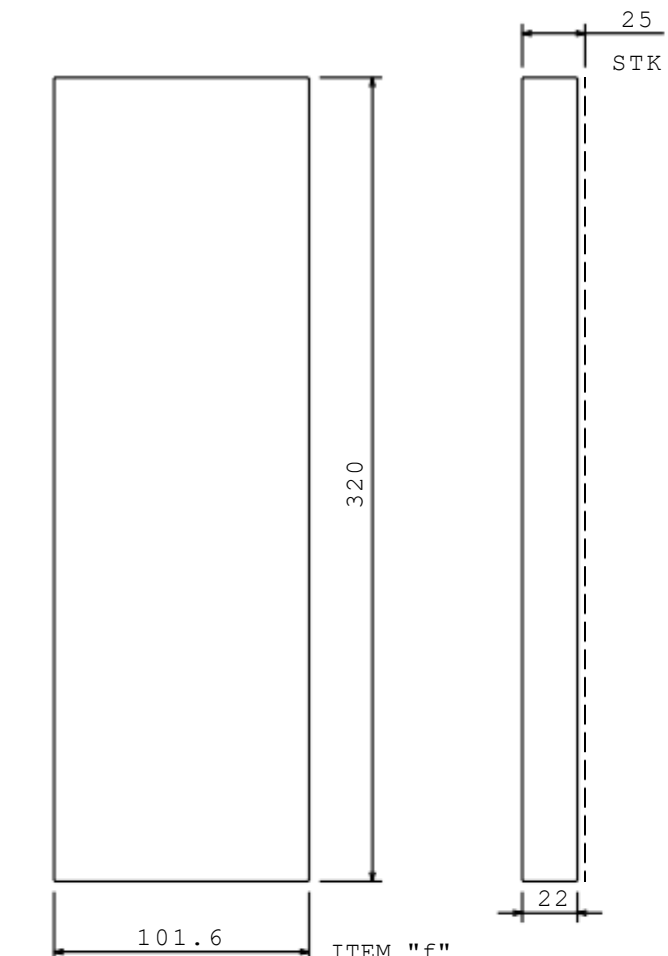
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SCALE 1:2



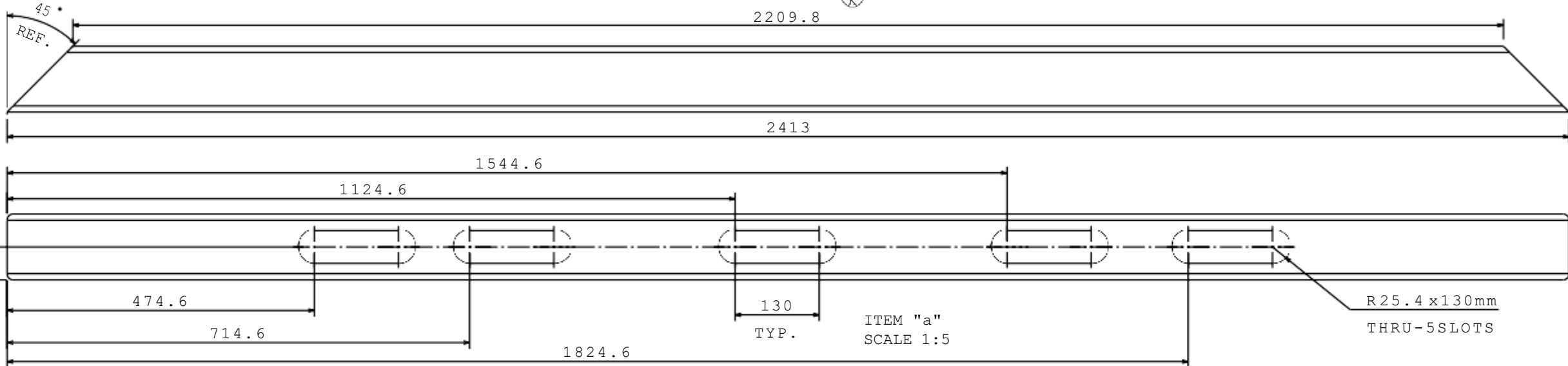
ITEM "g"
SCALE 1:2



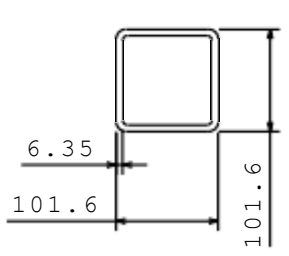
ITEM "f"
SCALE 1:2



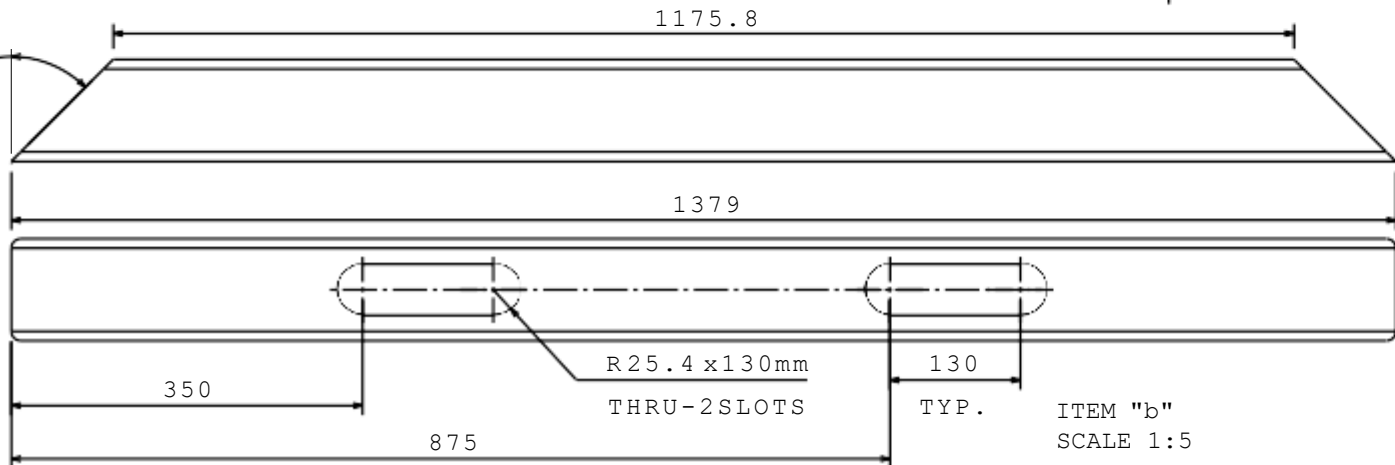
ITEM "c"
SCALE 1:5



ITEM "a"
SCALE 1:5



ITEM "b"
SCALE 1:5



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 :0.1
1 PLACE FABRICATION :1.5
2 PLACE :0.08 BETWEEN MACHINED SURFACES
0.03 BETWEEN SINGLE CORNER AND A REEL SURFACE
0.03 BETWEEN CORNERS IN THE SAME PLANE
0.10 BETWEEN CORNERS IN DIFFERENT PLANE
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 FINISERS TO HAVE .125 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 *** GROOVES TO BE 90 DEGREE AS SHOWN.

AND VENT HOLES IN ALL WELDMENTS WHERE TRAPPED AIR IS A POSSIBILITY, I.E. TUNING 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.:	01
WEIGHT (KG):	325.65

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

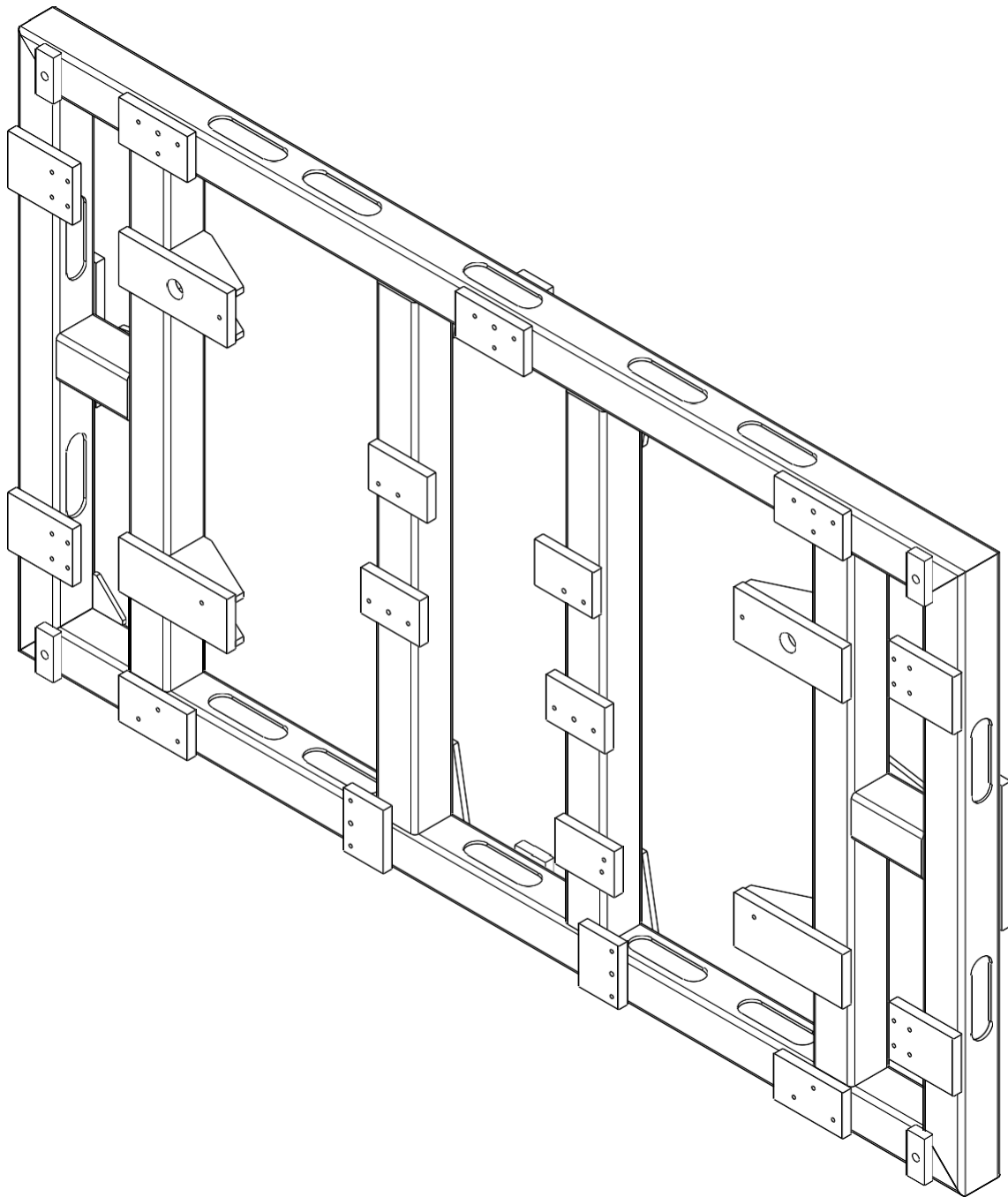
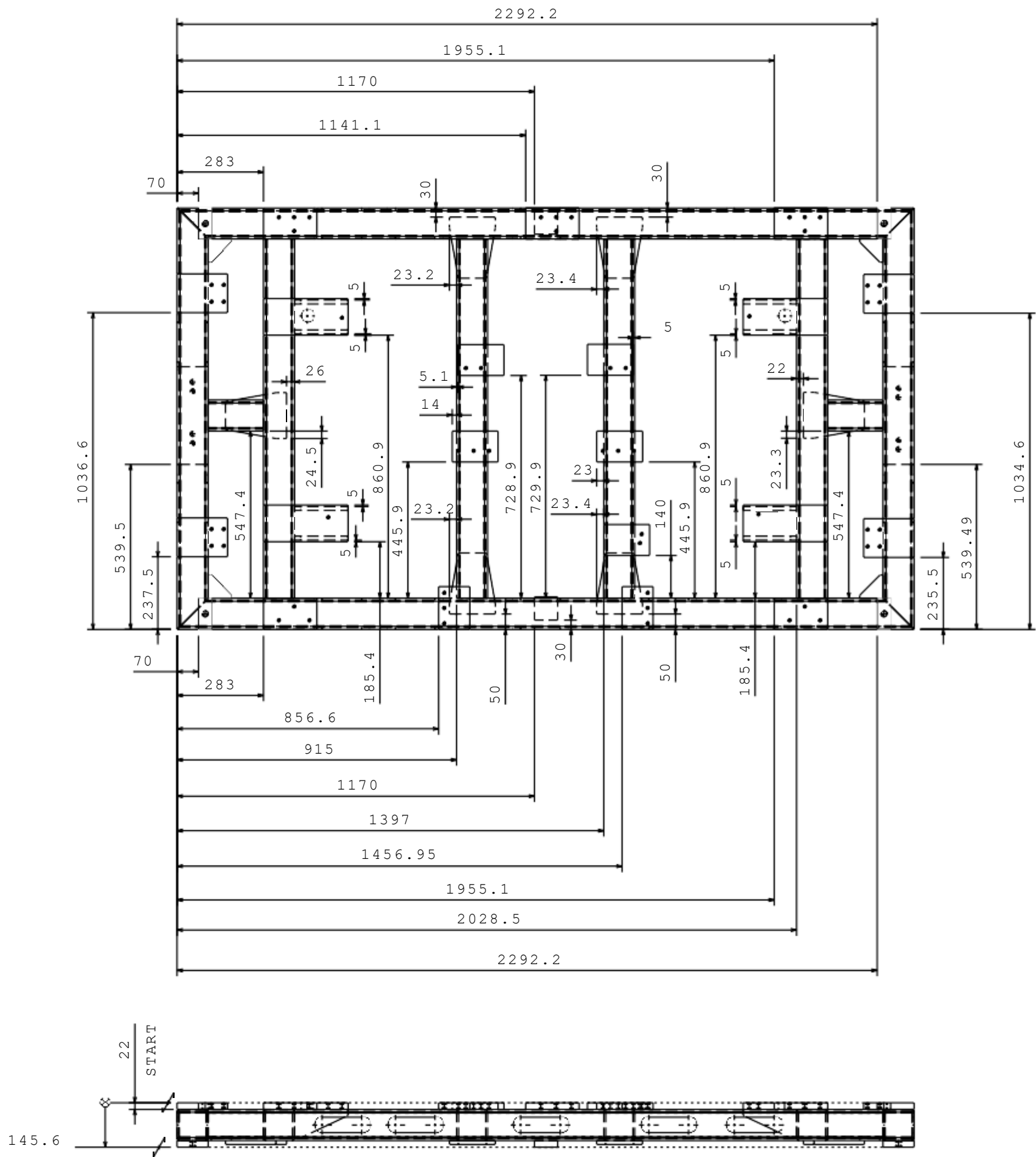
DESIGN SOURCE	BUILD SOURCE	CUSTOMER
		FMX

DESIGNER ONWARD	DETAILER ONWARD	3RD ANGLE PROJECTION
PROJECT MGR. A.RANGEL	DESIGN SUP. E.TORRES	CHECKER E.TORRES

SYSTEM NAME	202022-BEV3-FMX-CRADLE
DESCRIPTION	BEV3-CRADLE

ONLY FOR MANUFACTURING	
PROCESS	STATUS
CUT	
WELDING	
THIEVE	
MACHINING	
PAINT	

SCALE	SHEET	RELEASE DATE
1:5	1 OF 4	18/03/2021
NO. SHOWN	BEV3_RRC_ST050_G0176_BFWCM	
DRAWING	OPPOSITE	



SCALE 1:8

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 REEL 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 CHAM SURFACES.

ALL EDGES OF PART CONTACT SURFACES ON LOCATING BLOCKS AND FINGERS TO HAVE .125 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 "P" GROOVES TO BE 90 DEGREE AS SHOWN.

ADD VENT HOLES IN ALL WELDMENTS WHERE TRAPPED AIR IS A POSSIBILITY, I.E. TUBING CAPPED AT BOTH ENDS, BOXED FORMS ETC. SHOOTFACE 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 CHILLING AFTER WELDING AND STRESS RELIEVED. APPLY MICRO WIRE WELD 0.45mm. WIRE DIAMETER. BREAK SHARP EDGES.

UNIT No.:	01
WEIGHT (KG):	325.65

COTO: 202022

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

DESIGN SOURCE	BUILD SOURCE	CUSTOMER
		FMX

DESIGNER ONWARD A. RANGEL	DETAILER ONWARD E. TORRES	3RD ANGLE PROJECTION
PROJECT MGR.	DESIGN SUP.	CHECKER
	E. TORRES	E. TORRES

SYSTEM NAME
202022-BEV3-FMX-CRADLE

DESCRIPTION
BEV3-CRADLE

SCALE 1:5	SHEET 3 OF 4	RELEASE DATE 17/03/2021
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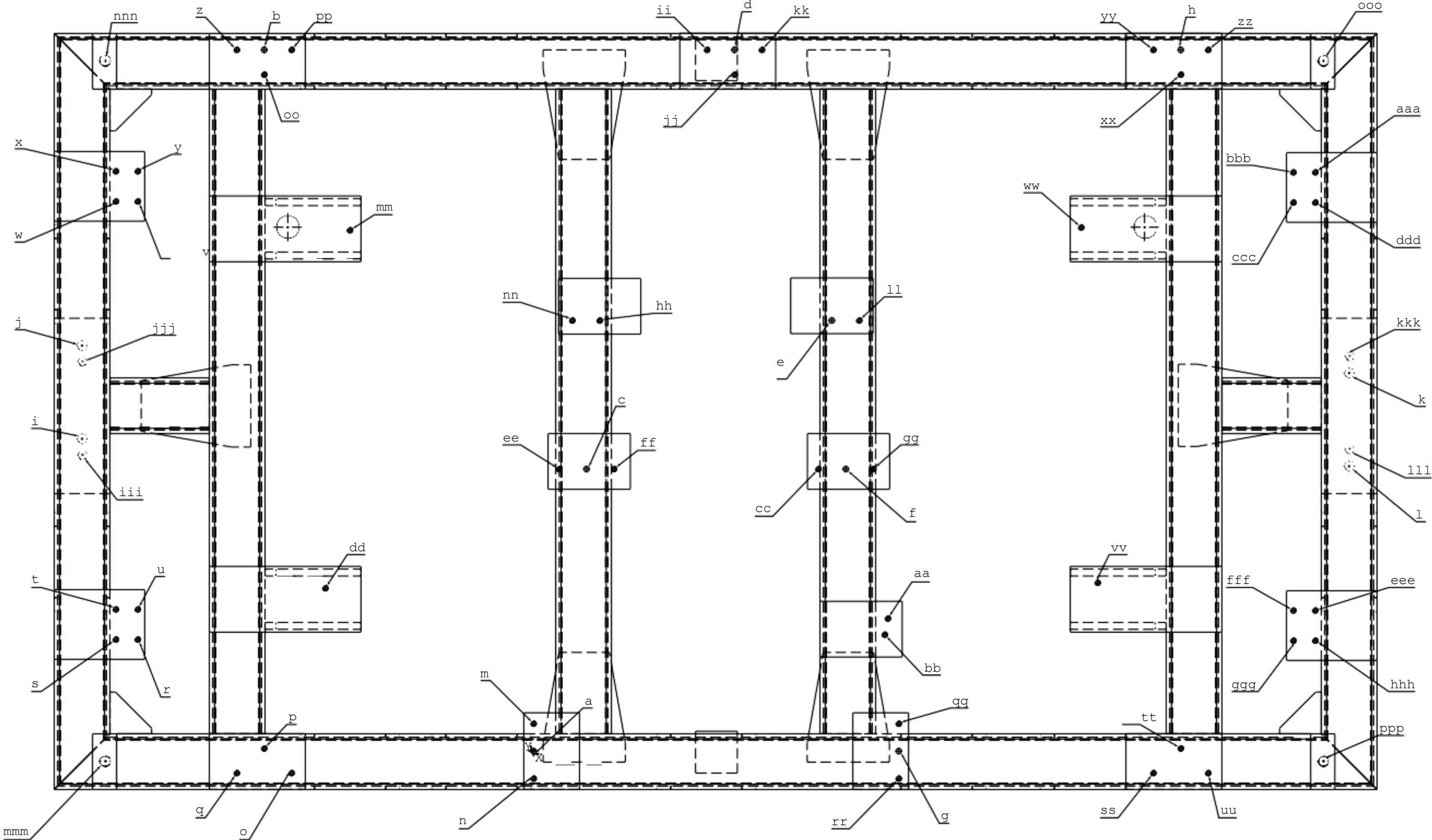
DRAWING No SHOWN	BEV3_RRC_ST050_G0176_BFWCM
DRAWING No OPPOSITE	-

ONLY FOR MANUFACTURING	
PROCESS	STATUS
CUT	
WELDING	
STRESS	
MACHINING	
PAINT	

ALL VIEWS SCALE 1:10

Hole Table			
hole	XDIM	YDIM	DESCRIPTION
a	0	0	FOR Ø10.00 - DWL H7 - THRU
b	-491.5	1279	
c	96.5	514.5	
d	366.5	1279	
e	544	785.5	
f	569.5	514.5	
g	666	0	
h	1180.5	1279	
i	-823.8	569.55	FOR Ø16.00 - DWL- THRU FAR SIDE
j	-823.8	739.55	
k	1487.6	689.54	
l	1487.6	519.54	

Hole Table			
HOLE	XDIM	YDIM	DESCRIPTION
m	0	50	M10x1.75 -TAP- THRU
n	0	-50	
o	-441.5	-40	
p	-491.5	5	
q	-541.5	-40	
r	-722.1	203.55	
s	-762.1	203.55	
t	-762.1	258.55	
u	-722.1	258.55	
v	-722.1	1002.65	
w	-762.1	1002.65	
x	-762.1	1057.65	
y	-722.1	1057.65	
z	-541.5	1279	
aa	646.18	242	M12x1.75 -TAP- THRU
bb	640.46	212.55	
cc	519.5	514.5	
dd	-380	297.05	
ee	46.5	514.5	
ff	146.5	514.5	M10x1.75- TAP-THRU
gg	619.5	785.5	
hh	120.5	785.5	
ii	316.5	1279	
jj	366.5	1234	
kk	416.5	1279	
ll	594	785.5	
mm	-335	950.05	
nn	70.5	514.5	
oo	-491.5	1232	
pp	-441.5	1279	
qq	666	50	
rr	666	-50	
ss	1130.5	-40	
tt	1180.5	5	
uu	1230.5	-40	
vv	1028.9	307.05	
ww	998.9	955.05	
xx	1180.5	1234	
yy	1130.5	1279	
zz	1230.5	1279	
aaa	1425.9	1055.65	M10x1.75- TAP-THRU FAR SIDE
bbb	1385.9	1055.65	
ccc	1385.9	1000.65	
ddd	1425.9	1000.65	
eee	1425.9	256.55	
fff	1385.9	256.55	M20x1.75- TAP-THRU
ggg	1385.9	201.55	
hhh	1425.9	201.55	
iii	-823.8	539.55	
jjj	-823.8	709.55	
kkk	1487.6	719.54	
lll	1487.6	549.54	
mmm	-782.6	-19.15	
nnn	-782.6	1258.25	
ooo	1439.6	1258.25	
ppp	1439.6	-19.15	



ALL VIEWS SCALE 1:5

ONLY FOR MANUFACTURING	
PROCESS	STATUS
CUT	
WELDING	
STRESS	
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 3M FINISH DIMENSIONS TO BE 3.2 MICRONS
2 PLACE 3M FINISH DIMENSIONS TO BE 1.6 MICRONS
3 PLACE 3M 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 .015
1 PLACE FABRICATION .15
2 PLACE .008 BETWEEN MACHINED SURFACES
.003 BETWEEN SINGLE DOWEL AND A REEL SURFACE
.002 BETWEEN DOWELS IN STIFFENING PLATES

ALL EDGES OF PART CONTACT SURFACES ON LOCATING
BLOCKS AND FINGERS TO HAVE .125 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 *** GROOVES TO BE 90 DEGREE 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.:	01
WEIGHT (KG):	325.65

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

DESIGN SOURCE	BUILD SOURCE	CUSTOMER
		FMX
DESIGNER ONWARD	DETAILER ONWARD	3RD ANGLE PROJECTION
PROJECT MGR. A.RANGEL	DESIGN SUP. E.TORRES	CHECKER E.TORRES

SYSTEM NAME 202022-BEV3-FMX-CRADLE		
DESCRIPTION BEV3-CRADLE		
SCALE 1:5	SHEET 4 OF 4	RELEASE DATE 17/03/2021
DRAWING No. SHOWN	BEV3_RRC_ST050_G0176_BFWCM	
DRAWING OPPOSITE	-	