

Stock List			
ITEM	QTY	MATERIAL	DESCRIPTION
a	1	HRS	1/2" x 115.0mm x 397.0mm L.G.
b	1	HRS	1/2" x 397.0mm x 423.0mm L.G.
c	2	HRS	1/4" x 57.6mm x 125.0mm L.G.
d	1	HRS	3/8" x 57.6mm x 267.0mm L.G.
e	1	HRS	3/8" x 57.6mm x 267.0mm L.G.
f	1	HRS	3/4" x 56.5mm x 136.0mm L.G.
g	1	HRS	1/2" x 54.0mm x 57.6mm L.G.
151	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 ROUND SURFACES TO BE 0.4 MICRONS.

METRIC - EXCEPT AS NOTED TOLERANCES SHALL BE:
1 PLACE MACHINEING: 0.3
2 PLACE FABRICATION: 1.5

2 PLACE

0.03 TO GREEN SLOTTED DOWEL AND A HEEEL 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
RADIUS R50TING.

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

CRITICAL FEATURES ARE MARKED WITH ***

WELDMENTS

ALL WELD FLETS TO BE 1/4 INCH
ALL "V" GROOVES TO BE 40 DEGREE AS SHOWN.

ADD VENT HOLES IN ALL WELDMENTS WHERE TRAPPED
AIR IS A POSSIBILITY (I.E. TURNING CAPRIED AT BOTH ENDS,
BOXED FORMS ETC. SPOTFACE 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 AROUND OUTER PERIMETER.

WELDMENT CONSTRUCTION MUST BE STRESS RELIEVED
BY NORMALIZED. WELDMENT CONSTRUCTION MUST BE MILLING
AND DRAG GRINDING TO REMOVE ALL WELD BEADS.

MICRO WIRE D 0.5mm. WIRE DIAMETER. BREAK SHARP EDGES.

UNIT No.:	01
WEIGHT (KG):	N/A



ONLY FOR MANUFACTURING	
PROCESS	STATUS
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 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 LIQUID (CERTIFICATE MUST BE PROVIDED)

⑤ THE EXCEPTION FOR CORROSION-SENSITIVE IN ITEM (5) IS THE CASES OF JOINTS SUBJECT TO DYNAMIC LOADS, STRUCTURES EXPOSED TO THE WEATHER OR AGGRESSIVE

<p>PLATE WITH DOUBLE OVERLAP BUTT JOINT WELD</p>	<p>PLATE WITH BUTT PLATE LAP WELD</p>	<p>WELD JOINT AT 45° IN SQUARE</p>
<p>WELDING PLATE TO PLATE OR PLATE WITH SQUARE BUTT</p>	<p>PLATE WITH PLATE LAP WELD</p>	<p>PLATE WITH OVERLAP LAP WELD</p>
<p>PLATE TO PLATE JOINT AT 90°</p>	<p>PLATE WITH ANGLE LAP WELD</p>	<p>BUTT JOINT WITH GUSSET</p>
<p>WELDING PLATE WITH ROUND BUTT JOINT</p>	<p>PLATE JOINT WITH GUSSET</p>	<p>ALTERNATE DESIGN FOR ROUND BUTT JOINT</p>

DESIGN SOURCE	BUILD SOURCE	CUSTOMER
 MAGNA	 MAGNA	FMX

DESIGNER F.ESCOBAR	DETAILER F.ESCOBAR	 3RD ANGLE PROJECTION
PROJECT MGR. A.RANGEL	DESIGN SUP. E.TORREES	CHECKER E.TOORES

SYSTEM NAME	BEV3_RRC
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DESCRIPTION
CRADLE

SCALE NONE	SHEET 1 OF 2	RELEASE DATE 9/27/2021
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G.No.	SHOWN
	BEV3 BRC ST170 M0151 BSWCMW

DRAWING	DEVELOPMENT OF THE MOTOR CONCEPT
	OPPOSITE