NOTES

1. MATERIAL: STEEL, MILD, COLD-ROLLED, to EN 10130:2006 Gr.DC01 2.0 THK.
   FINISH: RAL_9005

2. TOLERANCES ADDED TO DRAWING DIMENSIONS TAKE PRECEDENCE OVER OTHER TOLERANCES. DIMENSIONS MARKED CRITICAL OR PROCESS WILL BE MEASURED DURING CpK.

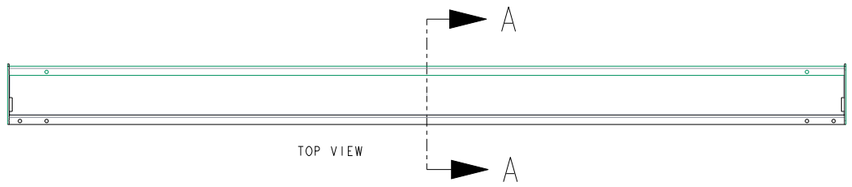
3. - UNFINISHED (SHEET METAL / RAW) PARTS: ALL EDGES SHALL BE CONDITIONED FOR HANDLING WITH BURRS NO GREATER THAN 10% MATERIAL THICKNESS ACCORDING TO ISO 13715, AND MUST CONFORM TO UL 1439.
   - FINISHED COMPONENTS (PAINTED, PLATED, RAW) PARTS: ALL EDGES SHALL BE CONDITIONED FOR HANDLING WITH BURRS NO GREATER THAN 10% MATERIAL THICKNESS, ACCORDING TO ISO 13715, AND MUST CONFORM TO UL 1439.

5. WELD SYMBOLS TO ISO 2553 UNLESS OTHERWISE STATED

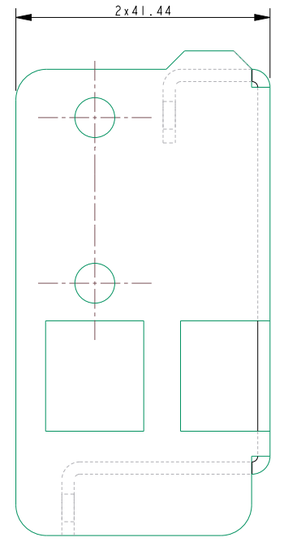
6. ALL WELD LENGTH TOLERANCES +5/-0mm UNLESS OTHERWISE STATED
   ALL WELD HEIGHTS TO ISO 5817 UNLESS OTHERWISE STATED
   WELD LENGTH MEASUREMENTS TO BE TAKEN FROM START/FINISH OF COMPLETE WELD

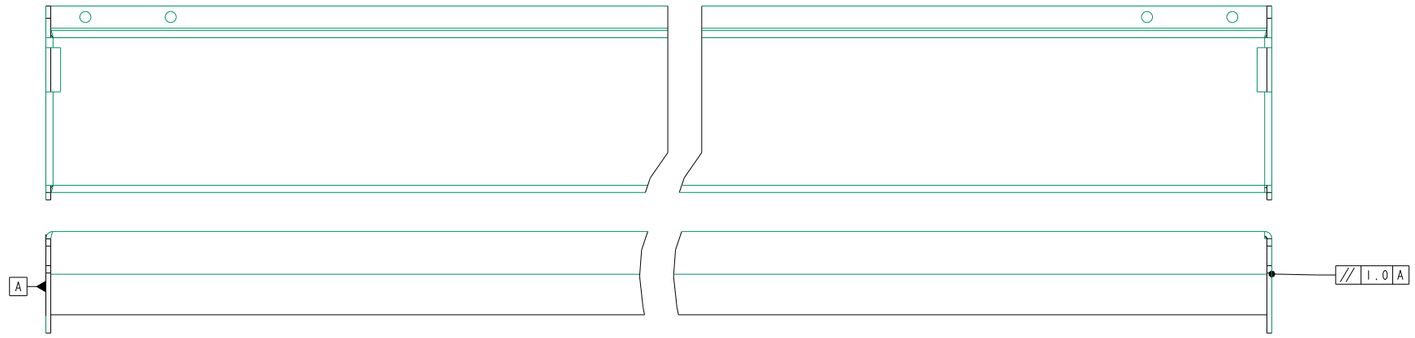
7. REFERENCE DRAWINGS: Na.

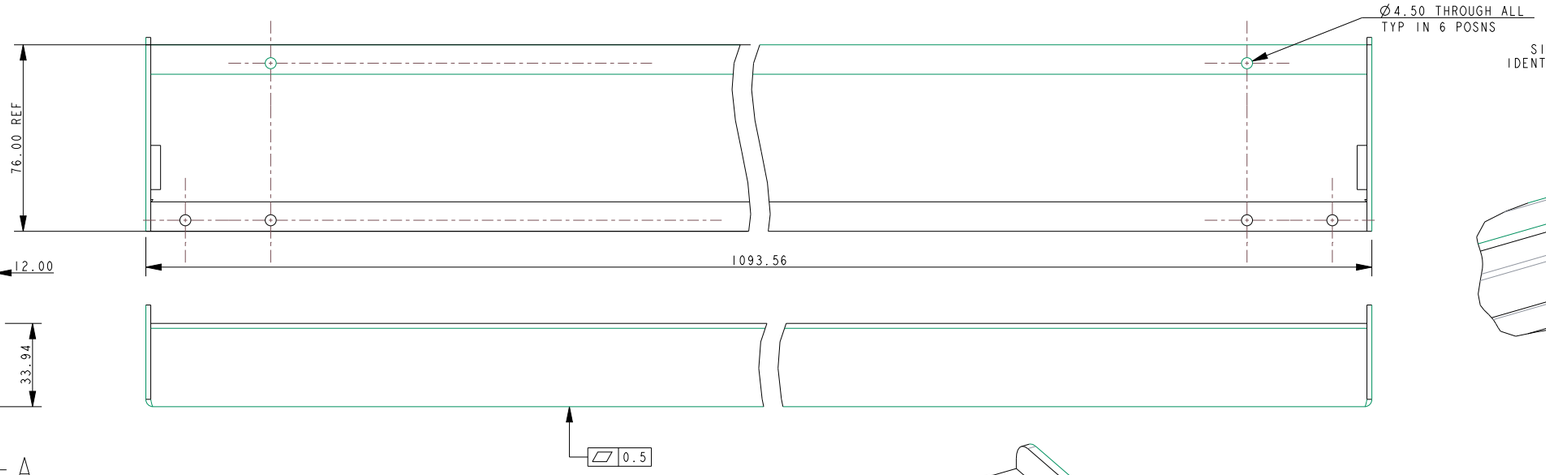
REV.	CHANGE	ECN	DATE	NAME	ZONE
A	INITIAL	-	24/03/25	M.T	-
B	E.V.T. UPDATED	-	19/SEPT/25	P.C.	
C	REFORMAT	-	12/02/26	J.G.	-

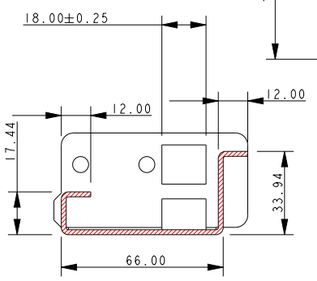


SCALE 0.125



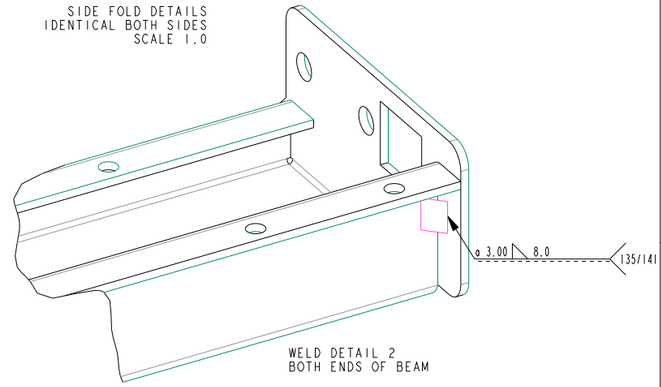




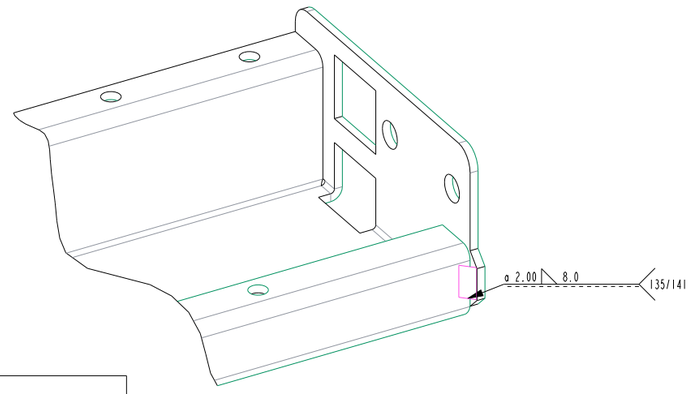


SECTION A - A

SIDE FOLD DETAILS
IDENTICAL BOTH SIDES
SCALE 1.0



WELD DETAIL 2
BOTH ENDS OF BEAM

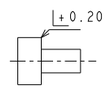


WELD DETAIL 1
BOTH ENDS OF BEAM

ITEM	QTY	DESCRIPTION	PART No.	FINISH
3	0.02	PAINT, RAL 9005, TEXT (CARBON BLACK)	406087	TEXTURED
2	0.01	PAINT RAL9005 2 PART DIP MIX	478517	E-COAT
1	1	BRACE 1200W MEMBER 10U WLD	402861	RAW

BILL OF MATERIALS for BRACE 1200W MEMBER 10U PNT PART NO. 402860
FINISH NOTES
PAINT IN ACCORDANCE WITH R1INT-00078 FOR E-COAT AND R1INT-00077
FOR POWDER COAT. REFER TO PAINT BOM TABLE ABOVE.

FEATURES WITHOUT TOLERANCES SHALL USE THE FOLLOWING TABLE:		SOFT TOOL TOLERANCE TABLE					
FEATURE TYPE TABLE		DIM. VALUE (X)					
#	TYPE	0 < X < 25	25 < X < 125	125 < X < 250	250 < X < 375	375 < X < 500	500 < X
1	Feature to feature (same operation)	0.13	0.13	0.18	0.18	0.25	0.38
2	Feature to feature (different operation)	0.25	0.30	0.30	0.38	0.38	0.51
3	Blank cutouts	0.10	0.13	0.18	0.30	0.38	0.51
4	Bend to cutout	0.30	0.30	0.30	0.38	0.38	0.51
5	Bend to bend or cuts w/bend between (same op)	0.30	0.38	0.38	0.51	0.51	0.64
6	Bend to bend (different operation)	0.38	0.38	0.38	0.38	0.51	0.64



ALL DIM'S ARE IN MM.

THIRD ANGLE PROJECTION.

MASS APPROX. 2.3 Kg

FOR UNSPECIFIED DIMENSIONS REFER TO 3D CAD, UNDIMENSIONED FEATURES TO BE INTERPRETED FROM 3D CAD FILE AND TOLERANCES FROM TOL. TABLE
ANGLES : ±1.0°

CRITICAL DIMENSION

SCALE 0.40 @ A3

MATERIAL MILD_STEEL_DC01 2.0 THK'

DESCRIPTION AQUATRON META

BRACE MEMBER 10U 1.2M SM

DWG No C35170

C

1 OF 1