NOTES

1. MATERIAL: STEEL, STRUCTURAL, HOT-ROLLED, to EN 10149-2 Gr.S355MC 3.0mm THK
   FINISH: RAW

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

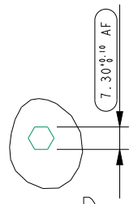
3. UNFINISHED (SHEET METAL / RAW) PARTS: ALL EDGES SHALL BE CONDITIONED FOR HANDLING WITH BURRS NO GREATER THAN 10% MATERIAL THICKNESS ACCORDING TO ISO 13715, AND MUST CONFORM TO UL 1439.

4. REFERENCE DRAWINGS: Na.

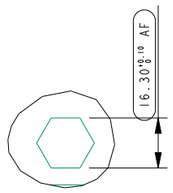
REV.	CHANGE	ECN	DATE	NAME	ZONE
A	CREATED	-	10/02/26	J.G.	-



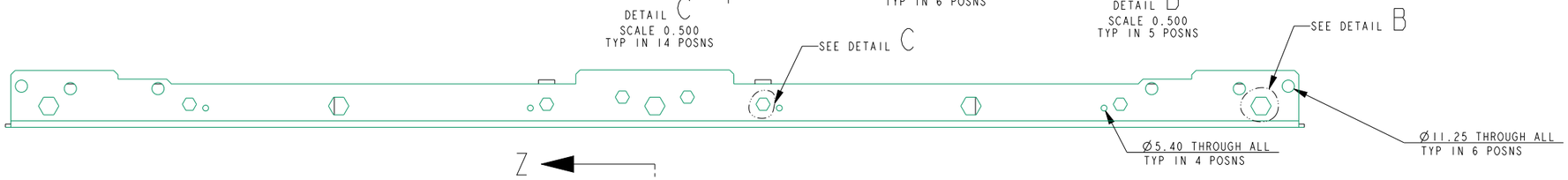
DETAIL C
SCALE 0.500
TYP IN 14 POSNS

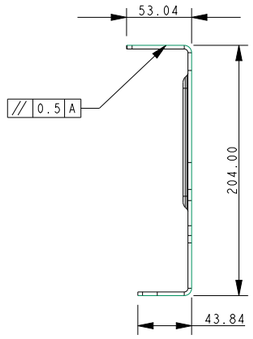


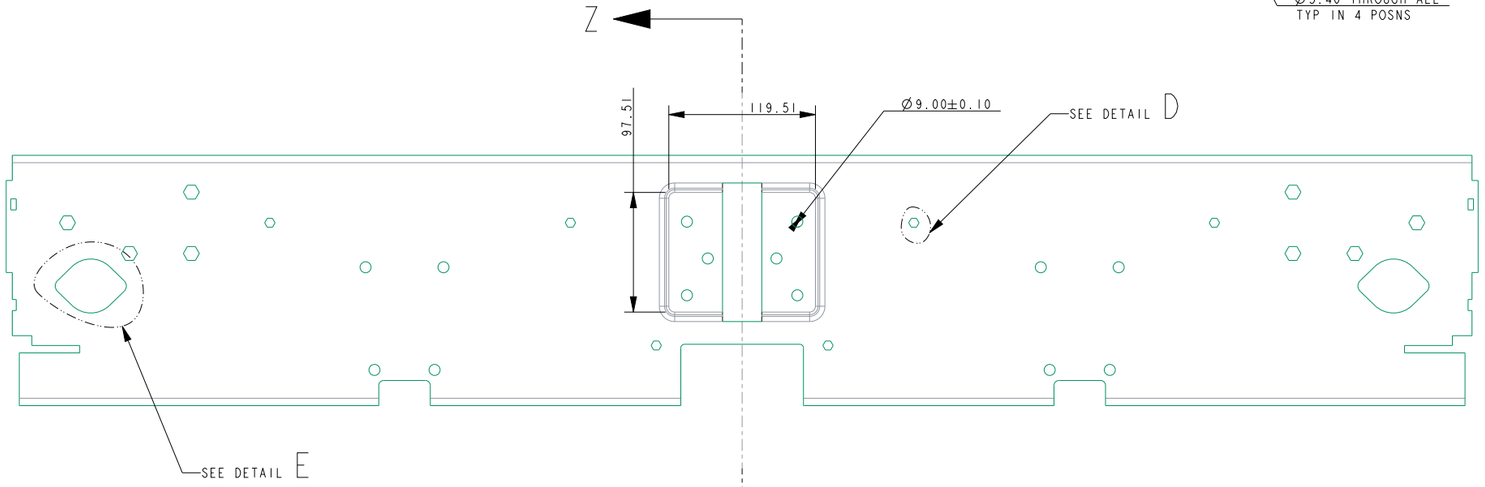
DETAIL D
SCALE 0.500
TYP IN 6 POSNS

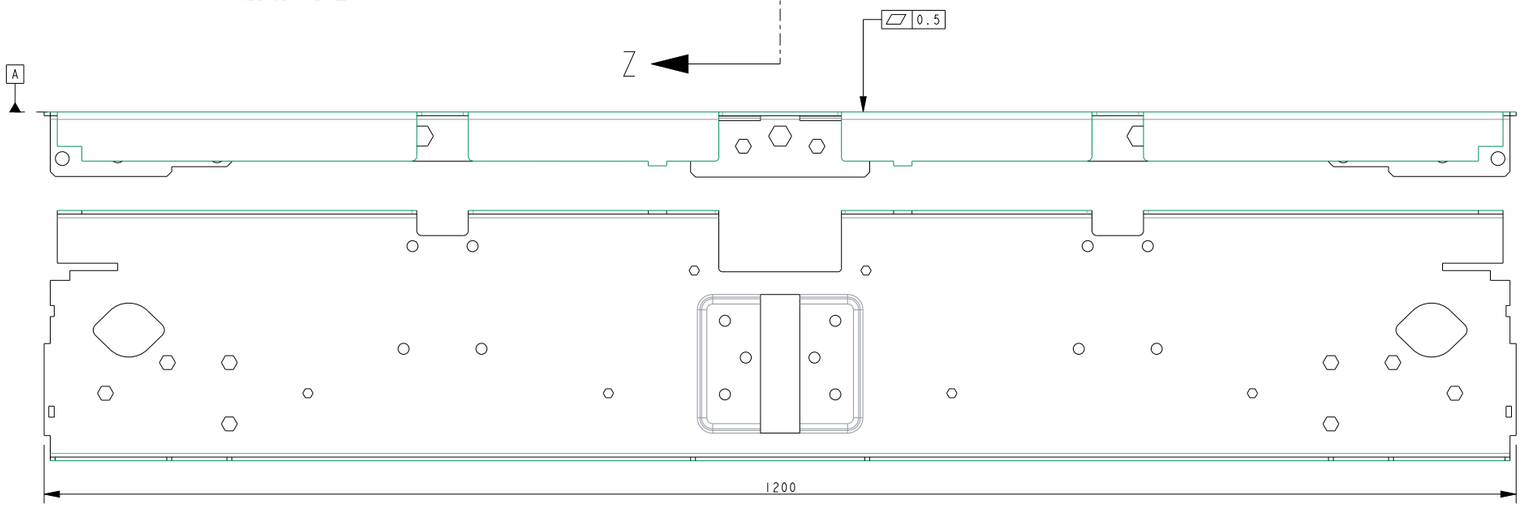


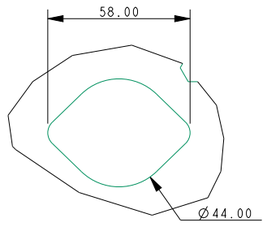
DETAIL B
SCALE 0.500
TYP IN 5 POSNS



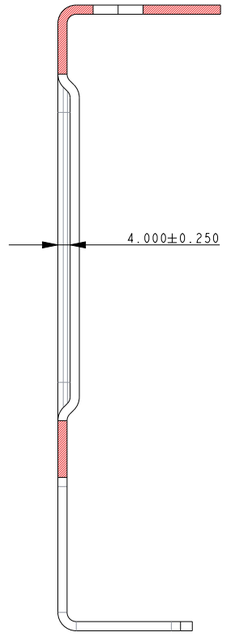








DETAIL E
SCALE 0.400
TYP IN 2 POSNS



SECTION Z - Z
SCALE 0.500

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

Meta

THIRD ANGLE PROJECTION.

ALL DIM'S ARE IN MM.

MASS APPROX. 7.3 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 0.20 @ A3

MATERIAL STEEL_S355MC_HR_BSEN10149-2 3.0 THK

DESCRIPTION AQUATRON META

CHANNEL REAR BBAR U SM

DWG No C36442

A

1 OF 2

NOTES

1. MATERIAL: MULTIPLE
   FINISH: RAW

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

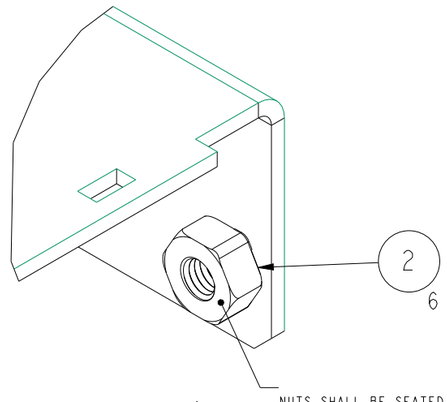
3. UNFINISHED (SHEET METAL / RAW) PARTS: ALL EDGES SHALL BE CONDITIONED FOR HANDLING WITH BURRS NO GREATER THAN 10% MATERIAL THICKNESS ACCORDING TO ISO 13715

5. WELD SYMBOLS TO ISO 2553 UNLESS OTHERWISE STATED

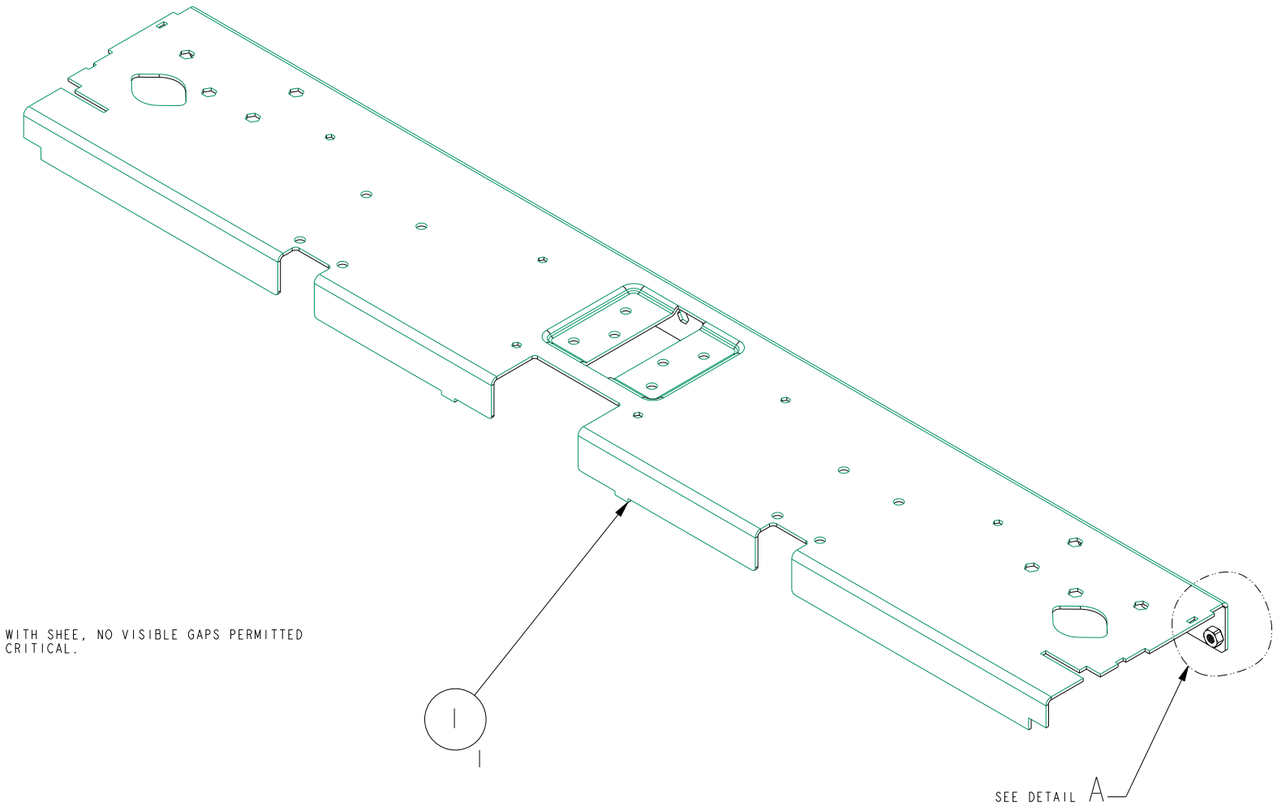
6. ALL WELD LENGTH TOLERANCES +5/-0mm UNLESS OTHERWISE STATED
   ALL WELD HEIGHTS TO ISO 5817 UNLESS OTHERWISE STATED
   WELD LENGTH MEASUREMENTS TO BE TAKEN FROM START/FINISH OF COMPLETE WELD

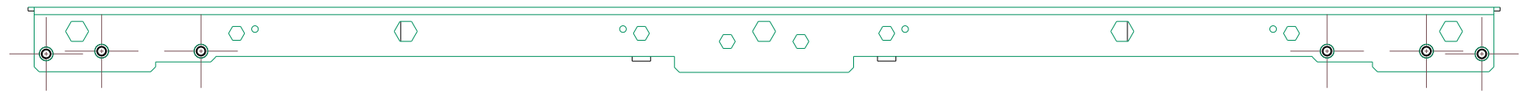
7. NUTS SHALL BE SEATED FLUSH WITH SHEET, NO VISIBLE GAPS PERMITTED
   ROTATIONAL ORIENTATION NOT CRITICAL.

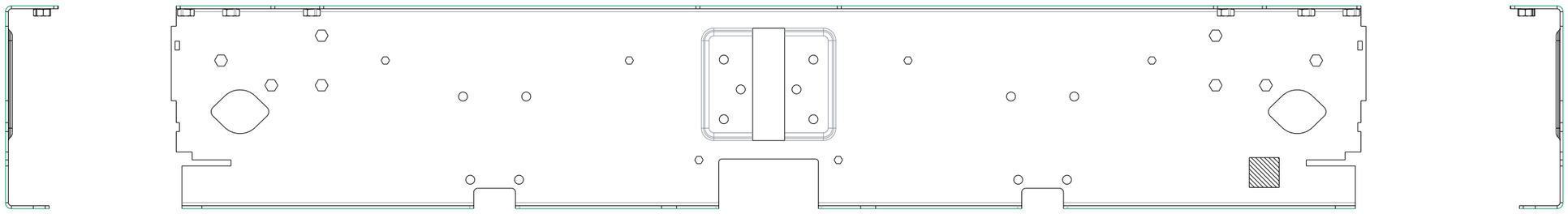
8. REFERENCE DRAWINGS: Na



DETAIL A
SCALE 1.0
REPEAT IN 6x LOCATIONS







ITEM	QTY	DESCRIPTION	PART No.	DRWG No.
2	6	NUT- WELD M8 inc. WELD PROJ.	417758	C13988
1	1	CHANNEL REAR BBAR U SM	402895	C36442

BILL OF MATERIALS FOR BASE, HACK 2 REAR STIFFENER SUPPORT PART NO. 402894

SCALE	0.20 @ A3
MATERIAL	
DESCRIPTION	AQUATRON / META
	BASE, HACK 2 REAR STIFFENER SUPPORT
DWG No	C36442_WLD Cont'd
ISS.	A
	DRAWING SHEET 2 OF 2