NOTES

1. MATERIAL: MULTIPLE_MATERIALS
   FINISH: RAL_9003

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

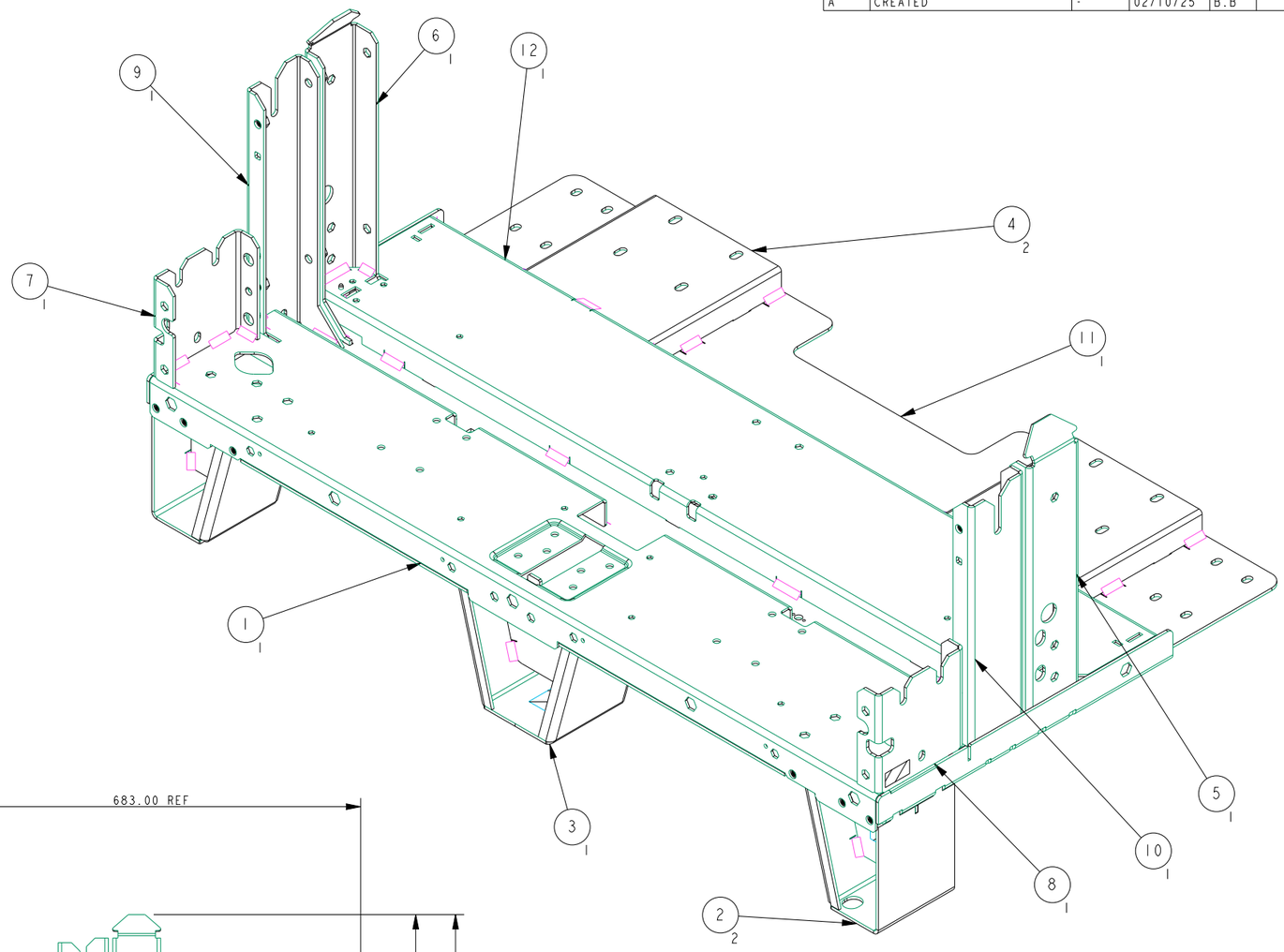
3. UNFINISHED (SHEET METAL / RAW) PARTS: ALL EDGES SHALL BE CONDITIONED FOR HANDLING WITH BURRS NO GREATER THAN 10% MATERIAL THICKNESS ACCORDING TO ISO 13715

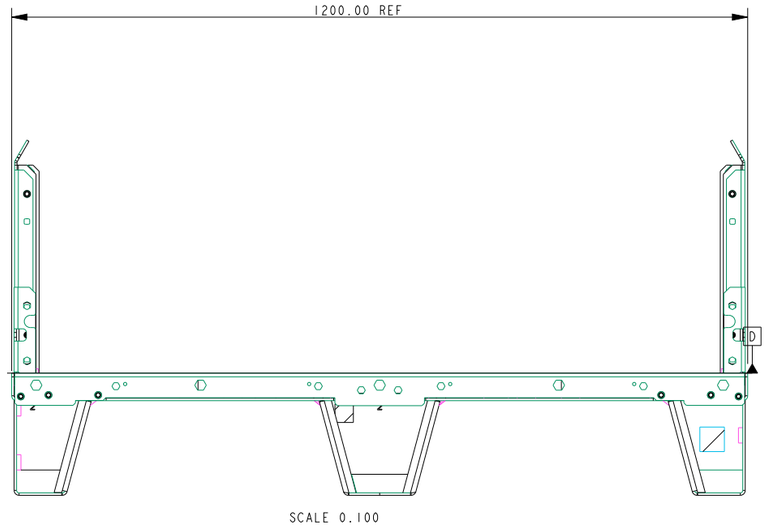
4. WELD SYMBOLS TO ISO 2553 UNLESS OTHERWISE STATED

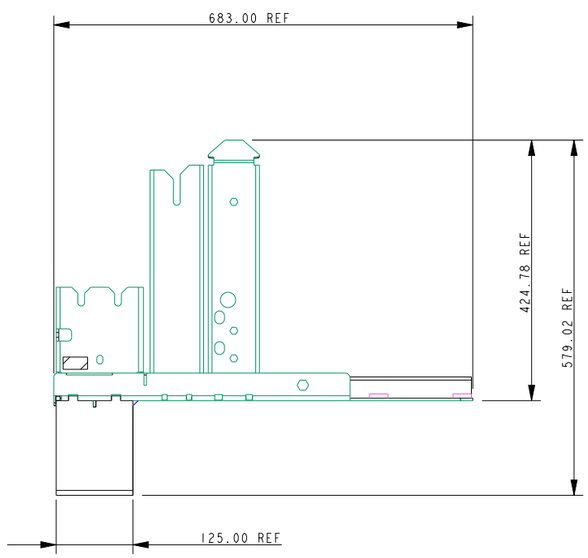
5. ALL WELD LENGTH TOLERANCES +5/-0mm UNLESS OTHERWISE STATED
   ALL WELD HEIGHTS TO ISO 5817 UNLESS OTHERWISE STATED
   WELD LENGTH MEASUREMENTS TO BE TAKEN FROM START/FINISH OF COMPLETE WELD

6. REFERENCE DRAWINGS: Na

REV.	CHANGE	ECN	DATE	NAME	ZONE
A	CREATED	-	02/10/25	B.B	







12	1	REAR PIN POS. U CHANNELPEM	402896	C37021_PEM
11	1	PROFILE REAR MAIN BASE SM	402874	C36776
10	1	BRACKET REAR VERTICAL BASE LH SUPPORT PEM	402885	C36845_PEM
9	1	BRACE REAR VERT BASE RH PEM	402883	C36845_RH_PEM
8	1	BRACE REAR CANOPY LH SM	402888	C36996
7	1	BRACE REAR CANOPY LH SM	402887	C36996_RH
6	1	BRACE INNER VERT INTERNAL RH WLD	402877	C36808_RH_PEM
5	1	BRACE INNER VERT INTERNAL LH WLD	402879	C36808_LH_PEM
4	2	BASE MID FIXING BRKT 2 TAGSBRACKET	402890	C36982
3	1	REAR MIDDLE FOOT 154MM HIGH LABEL 2 WLD	402904	C37069_WLD
2	2	CORNER FOOT 154MM HIGH LABELLED 2 WLD	402907	C37072_WLD
1	1	BASE, HACK 2 REAR STIFFENER SUPPORT	402894	C36442_WLD
ITEM	QTY	DESCRIPTION	PART No.	DRWG No.

BILL OF MATERIALS FOR BASETRAY REAR SECTION WLD PART NO. 402873

	AS REQUIRED	PAINT, RAL 9005, TEXT (CARBON BLACK)	406087	406087
	AS REQUIRED	PAINT RAL9005 2 PART DIP MIX	478517	478517_
	1	BASETRAY REAR SECTION WLD	402873	C36443_WLD
ITEM	QTY	DESCRIPTION	PART No.	DRWG No.

BILL OF MATERIALS FOR BASETRAY REAR SECTION PNT PART NO. 402872

Meta

THIRD ANGLE PROJECTION.

ALL DIM'S ARE IN MM.

MASS APPROX. 56.4 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 0.15 @ A3

MATERIAL [.1] THK'

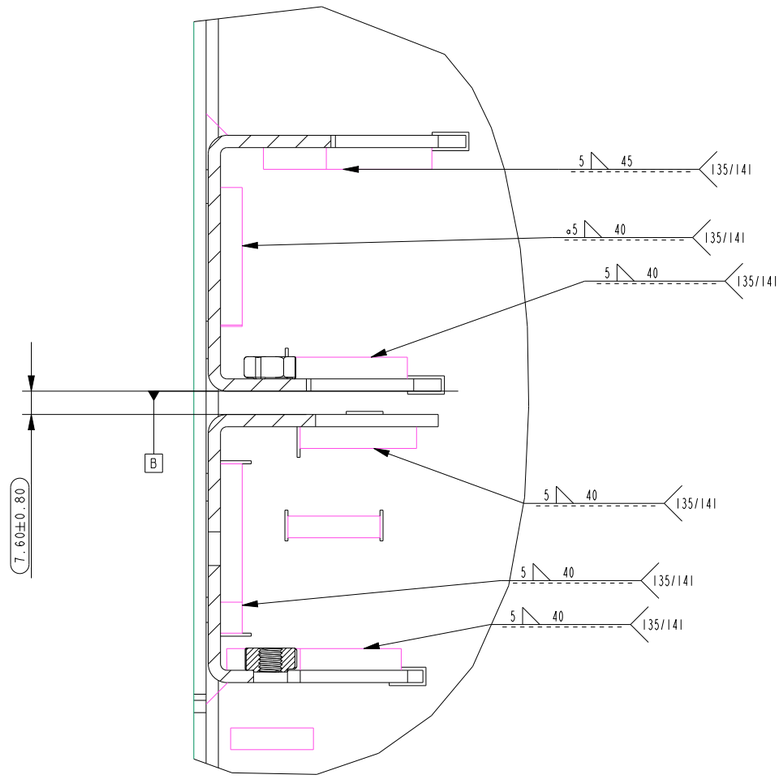
DESCRIPTION AQUATRON META

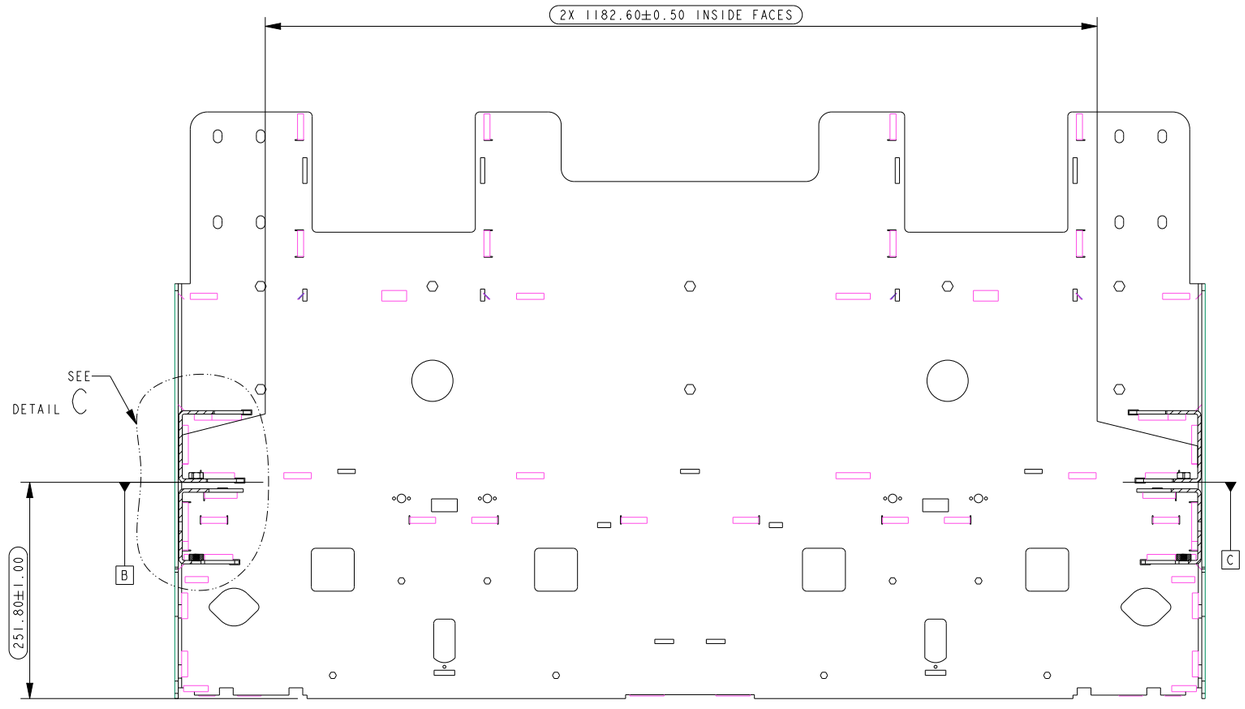
BASETRAY REAR SECTION WLD

DWG No C36443_WLD

A

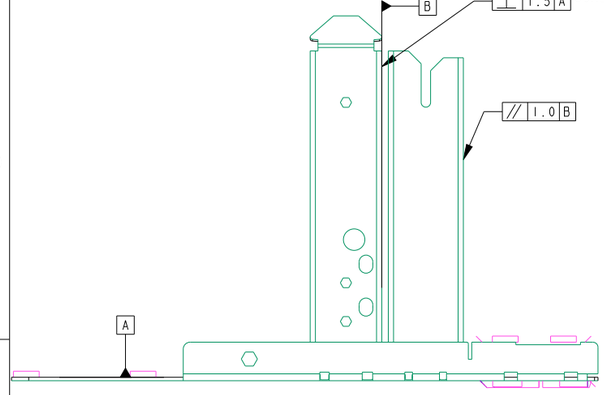
STAGE 1 WELDING
WELDING REPEATED BOTH SIDES



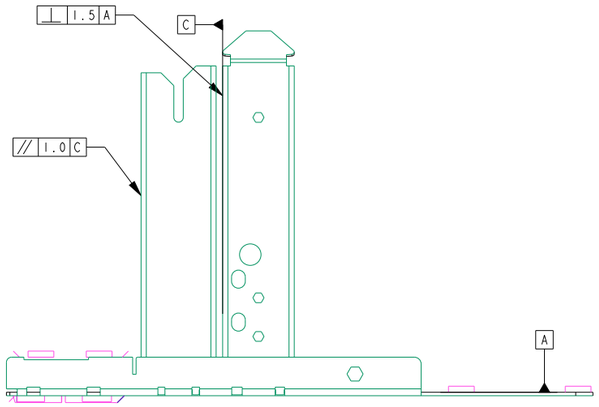


SECTION D - D

DETAIL C
SCALE 0.500





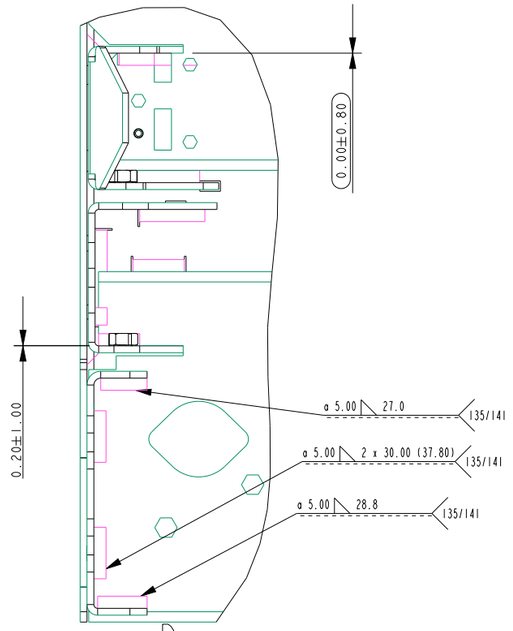


Meta

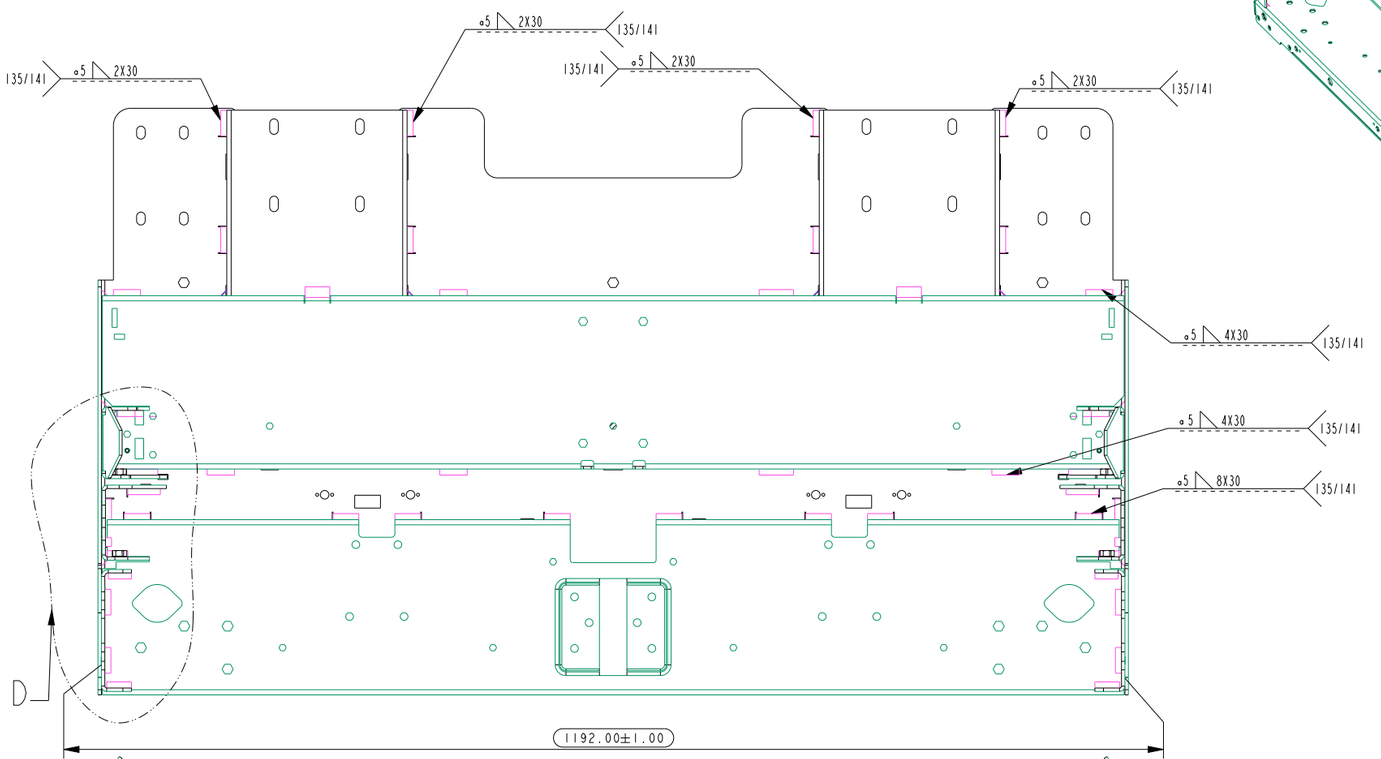
THIRD ANGLE PROJECTION.	MASS APPROX.	56.4 Kg
ALL DIM'S ARE IN MM.	FOR UNSPECIFIED DIMENSIONS REFER TO 3D CAD. UNDIMENSIONED FEATURES TO BE INTERPRETED FROM 3D CAD FILE AND TOLERANCES FROM TOL. TABLE ANGLES : ±1.0°	
	CRITICAL DIMENSION	

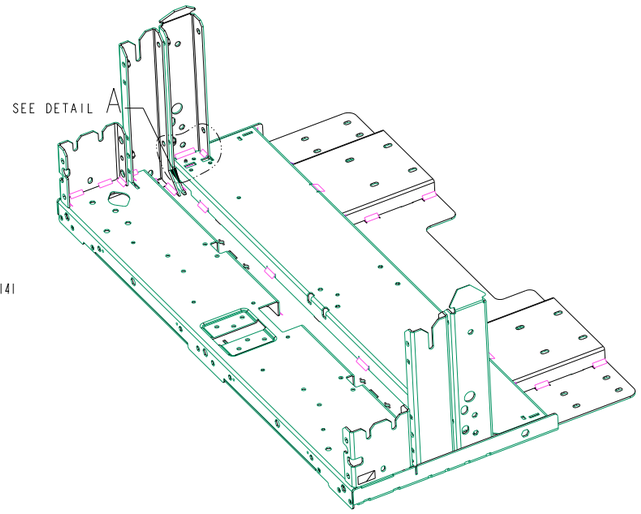
SCALE 0.14 @ A3	
MATERIAL	[.1] THK'
DESCRIPTION	AQUATRON / META
BASETRAY REAR SECTION WLD	
DWG No C36443_WLD	A
	2 OF 4

STAGE 2 WELDING
MAIN SECTIONS AND
REAR VERTICAL BRACES

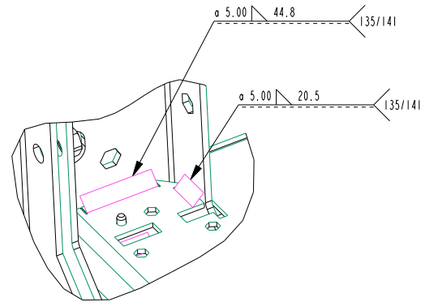


DETAIL D
SCALE 0.280

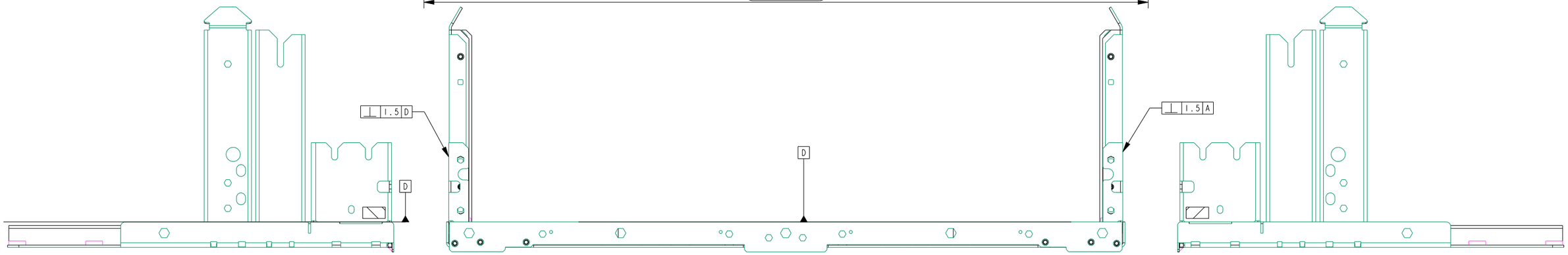




SCALE 0.080

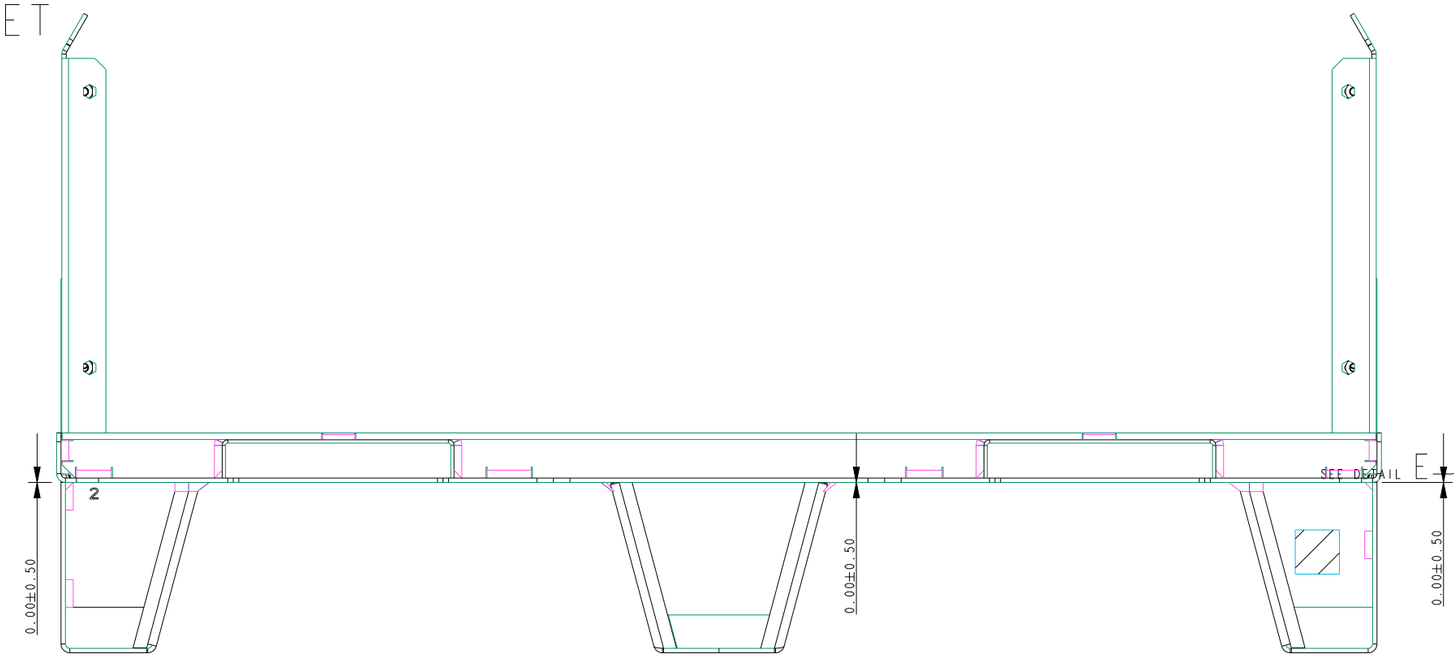


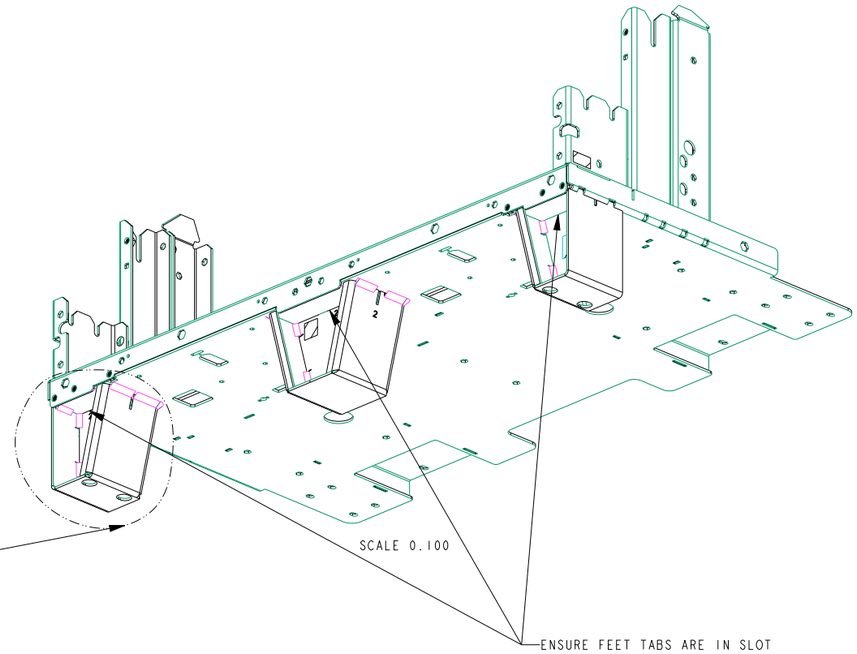
DETAIL A
SCALE 0.300
(BOTH SIDES)

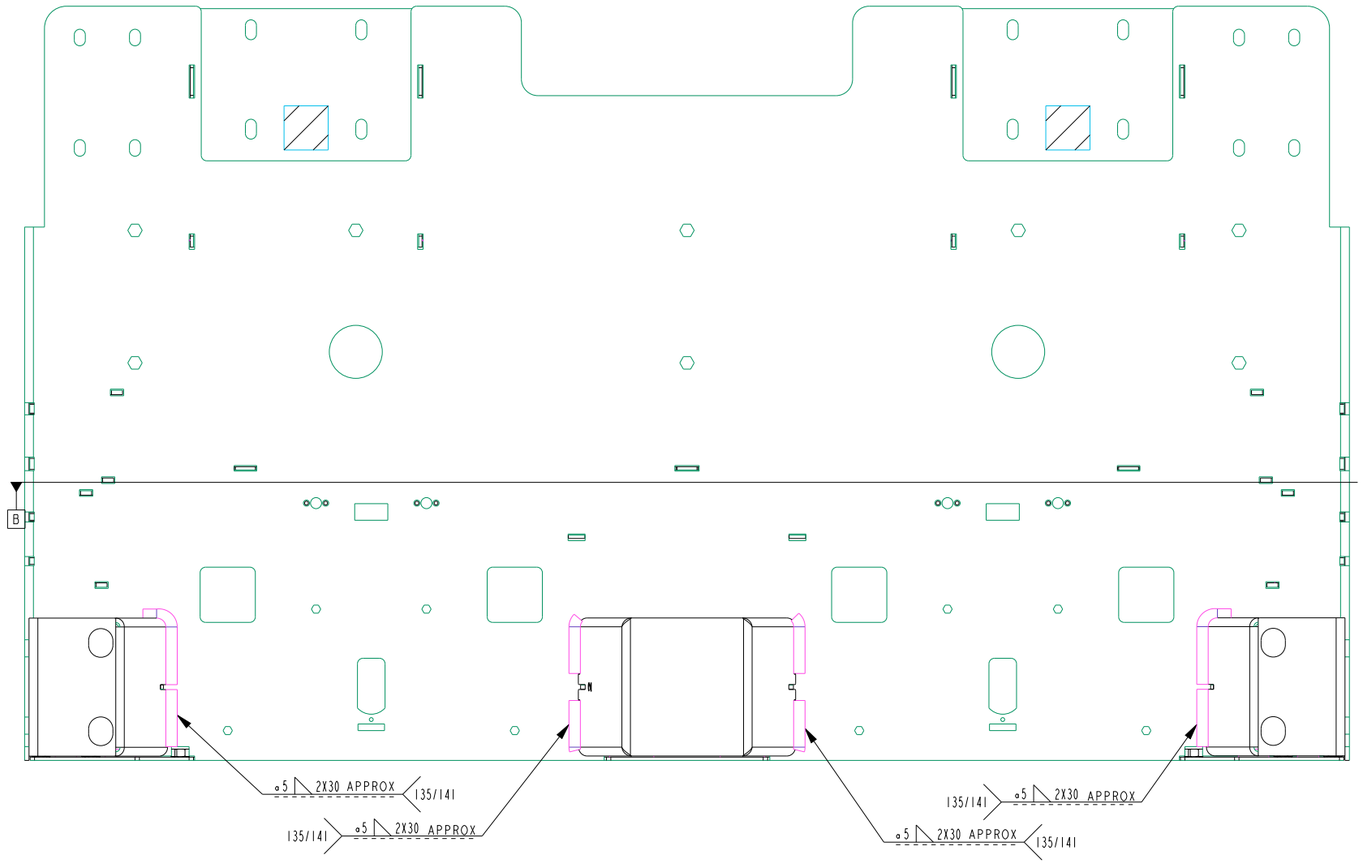


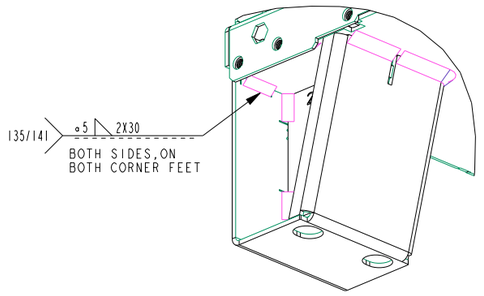
SCALE	0.14 @ A3
MATERIAL	
DESCRIPTION	AQUATRON META
BASETRAY REAR SECTION WLD	
DWG No	ISS.
C36443_WLD Cont'd	A
DRAWING SHEET 3 OF 4	

STAGE 3 WELDING
FEET









DETAIL E
SCALE 0.200

SCALE 0.18 @ A3	
MATERIAL	
DESCRIPTION AQUATRON	META
BASETRAY REAR SECTION WLD	
DWG No C36443_WLD	ISS. A
Cont'd	
DRAWING SHEET 4 OF 4	