REV.	CHANGE	ECN	DATE	NAME	ZONE
B	DESIGN FREEZE		11/FEB/26	DPW	

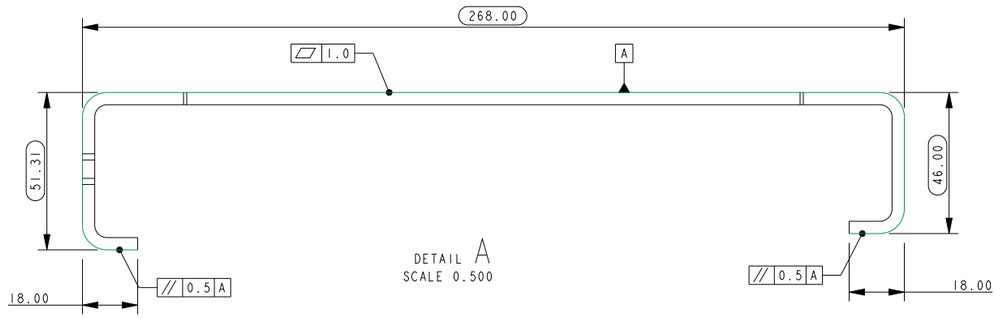
NOTES

1. MATERIAL: STEEL, STRUCTURAL, HOT-ROLLED, to EN 10149-2 Gr.S275JR 4.0mm THK
   FINISH: RAW

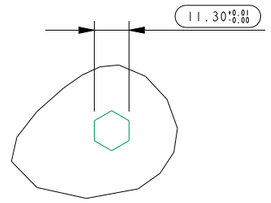
2. TOLERANCES ADDED TO DRAWING DIMENSIONS TAKE PRECEDENCE OVER OTHER TOLERANCES. DIMENSIONS MARKED CRITICAL OR PROCESS WILL BE MEASURED DURING CpK.

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.

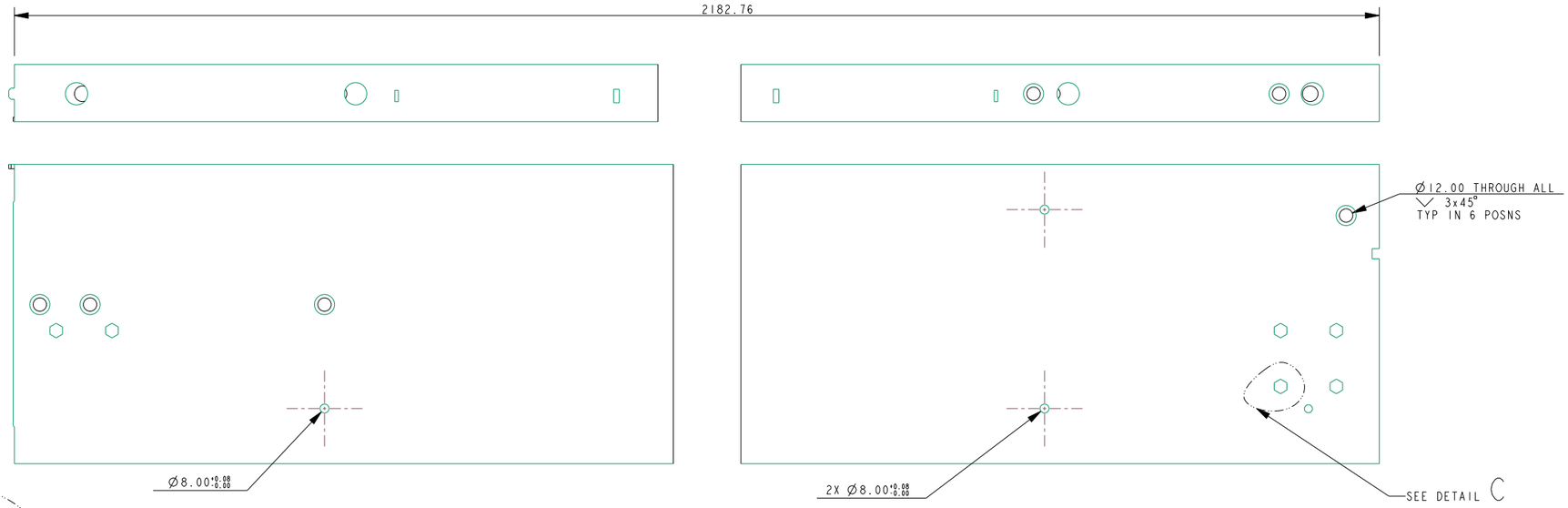
4. REFERENCE DRAWINGS: REFER TO SHEET2 FOR SUBSEQUENT PEM STUD PROCESS.

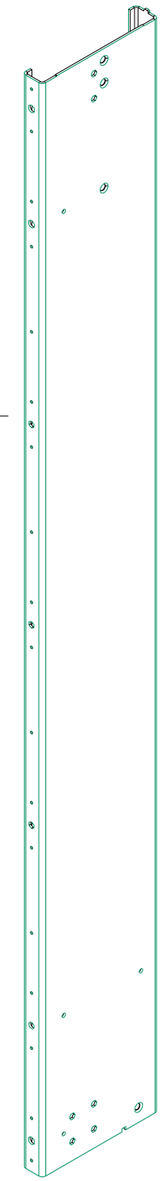


DETAIL A
SCALE 0.500



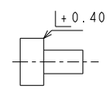
DETAIL C
SCALE 0.500
TYP IN 9 POSNS





SCALE 0.100

FEATURES WITHOUT TOLERANCES SHALL USE THE FOLLOWING TABLE:		SOFT TOOL TOLERANCE TABLE +4MM SPECIFIC				
FEATURE TYPE TABLE		DIM. VALUE (X)				
#	TYPE	0 < X < 6	6 < X < 30	30 < X <120	120 < X < 900	900 < X
1	Feature to feature (same operation)	0.18	0.18	0.23	0.23	0.30
2	Feature to feature (different operation)	0.35	0.40	0.40	0.45	0.45
3	Blank cutouts	0.10	0.13	0.18	0.30	0.38
4	Bend to cutout	0.72	0.72	0.72	0.72	0.72
5	Bend to bend or cuts w/bend between (same op)	0.72	0.72	0.72	0.72	0.72
6	Bend to bend (different operation)	0.90	0.90	0.90	0.90	0.90



Meta

THIRD ANGLE PROJECTION.

ALL DIM'S ARE IN MM.

MASS APPROX. 25.4 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 0.20 @ A3

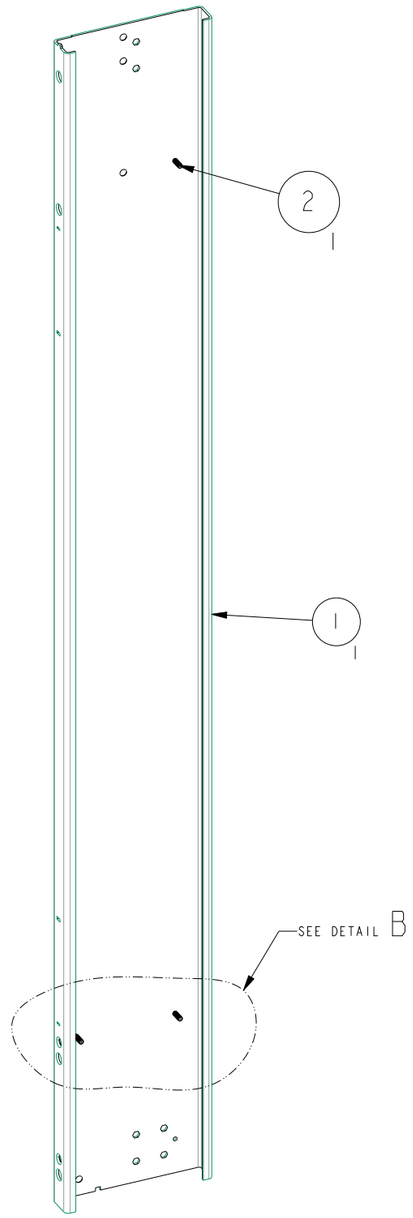
MATERIAL STEEL_S275JR_HR_EN10025-2 4.0 THK

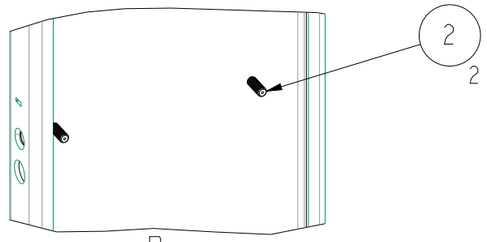
DESCRIPTION AQUATRON | META

PROFILE LH REAR OUTER VERT SM

DWG No C37026

B





DETAIL B
SCALE 0.200

ITEM	QTY	DESCRIPTION	PART No.	DRWG No.
1	1	PROFILE LH REAR OUTER VERT SM	402839	C37026
2	3	STUD, PEM M8 X 25 STUD (FH-M8-25Z1)	432457	FH_M8_25_Z1_PEM_STUD

BILL OF MATERIALS FOR C37026_PEM PROFILE LH REAR OUTER VERT PEM PART NO. 402838

SCALE	0.10 @ A3
MATERIAL	
DESCRIPTION	AQUATRON META
PROFILE LH REAR OUTER VERT PEM	
DWG No	C37026_PEM
ISS.	B
Cont'd	

DRAWING SHEET 2 OF 2