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| Group 1 |
| Controlled Environment Monitors |
| Manufacturing Document ( June 19 ) |

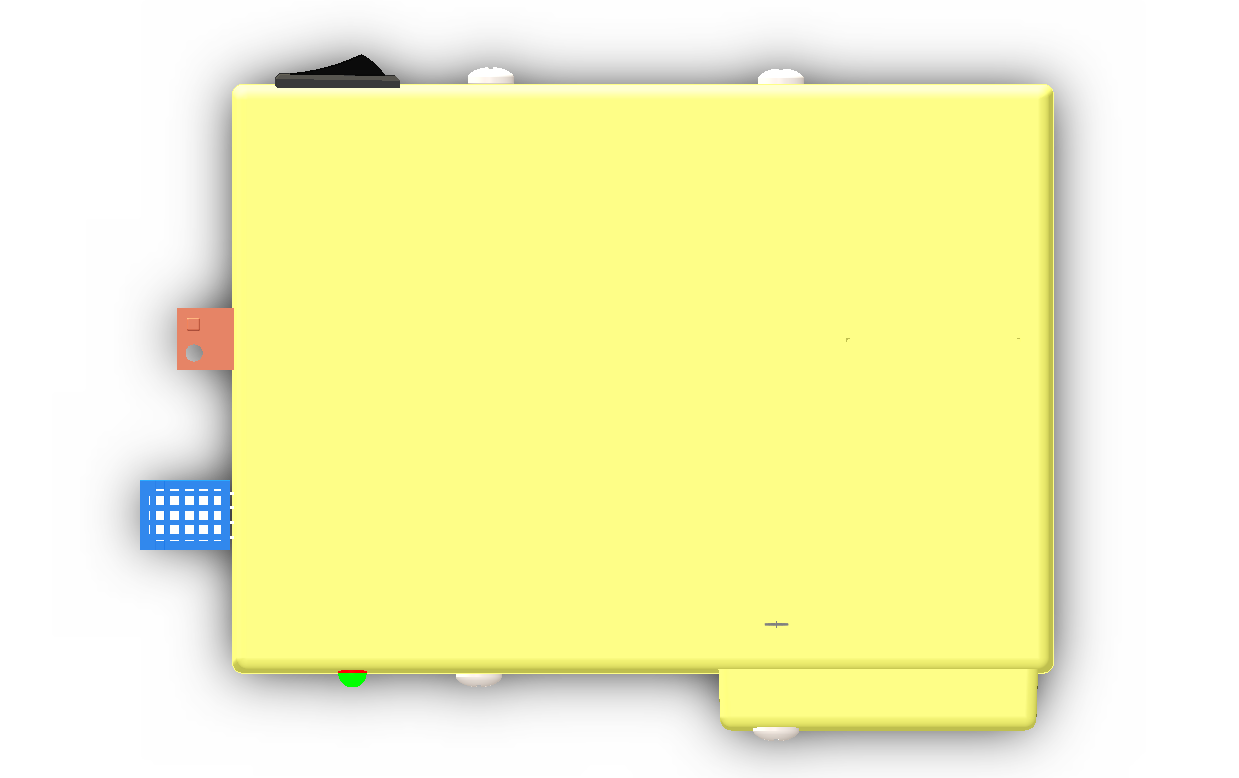
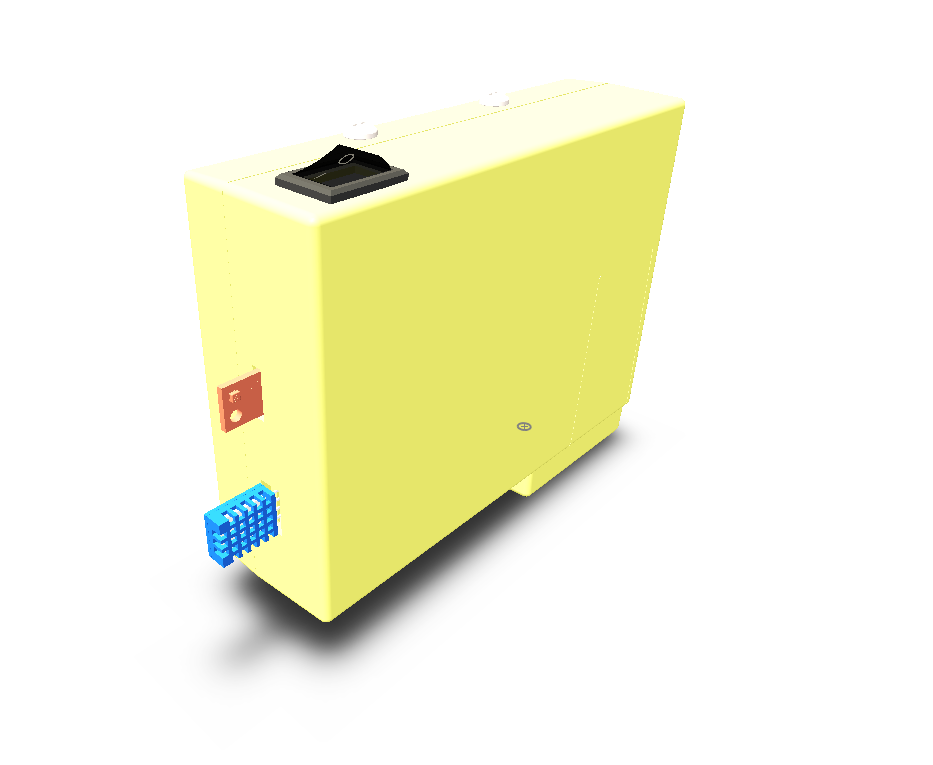
Contents

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# Sensor Unit Manufacture

## Enclosure

Sensor Unit



## 

### Components

The Sensor Unit Enclosure consists of 4 components that are to be manufactured by injection molding. All units are to be molded using hard plastic

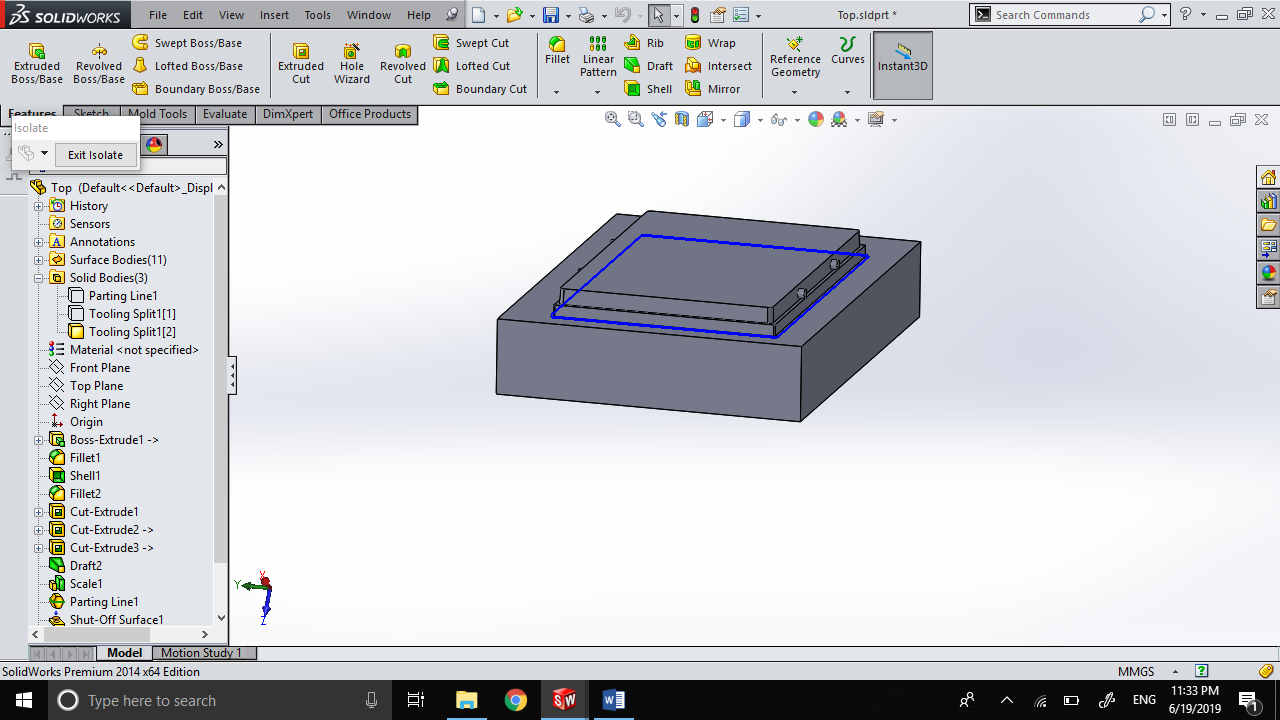
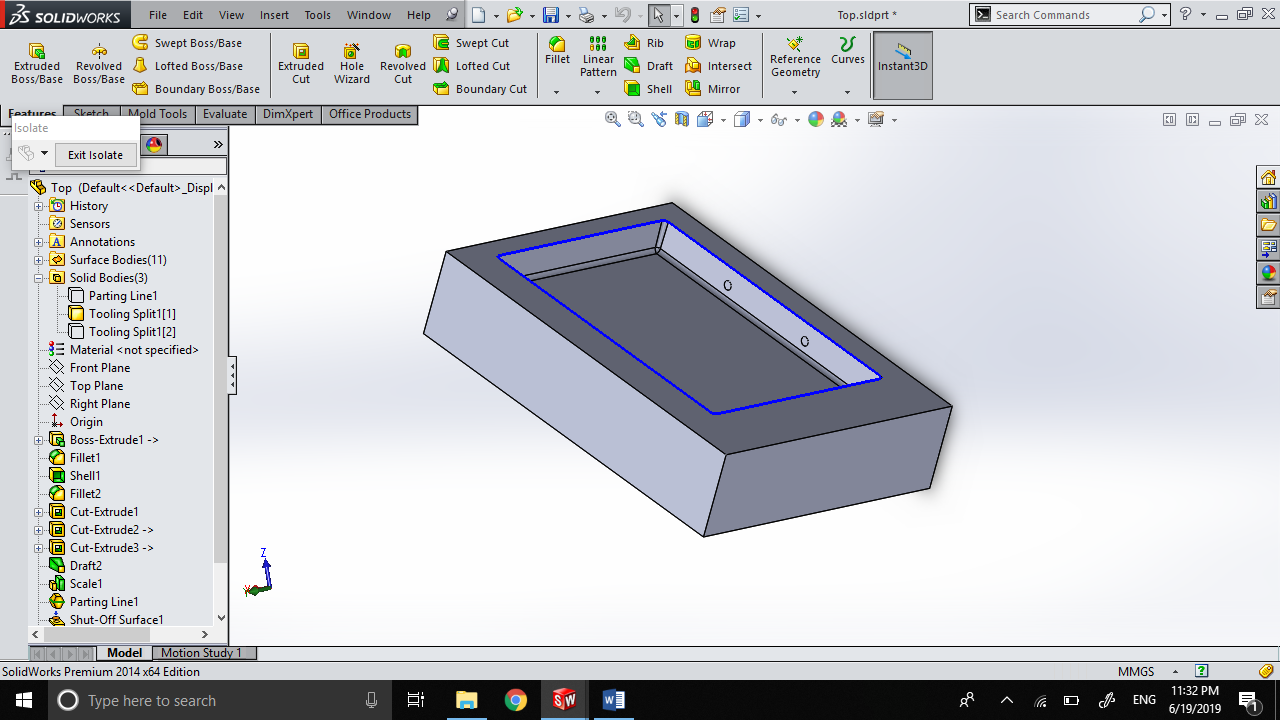
Components to be molded are:

1. Top Cover
2. Bottom Cover
3. Battery Cover
4. Battery Lock

### Top Cover

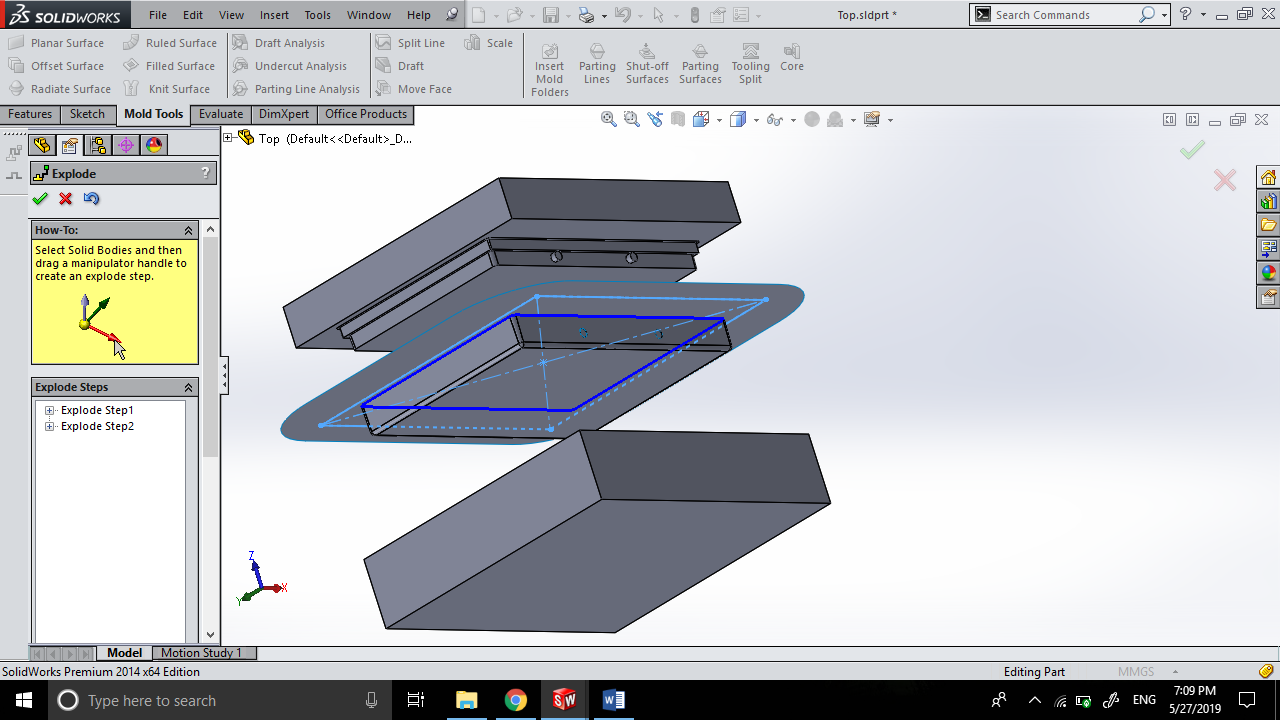
#### Draft Analysis

#### Mold Components



Core

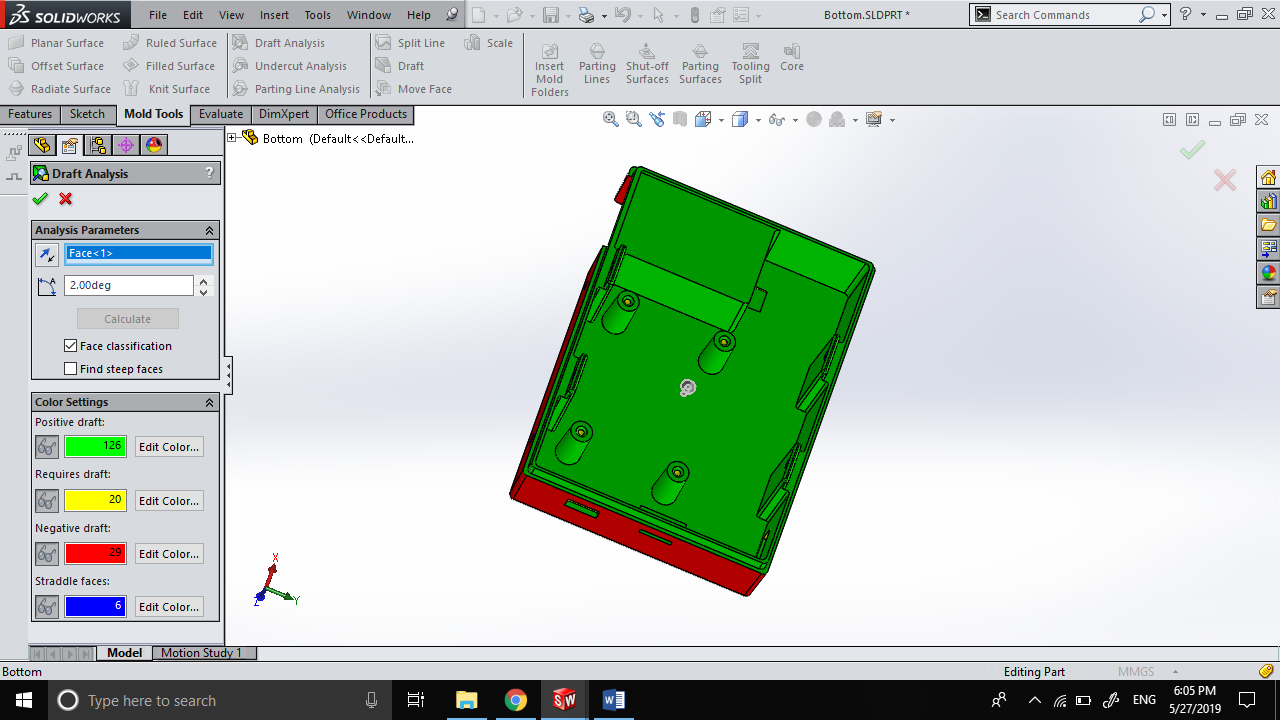
Cavity



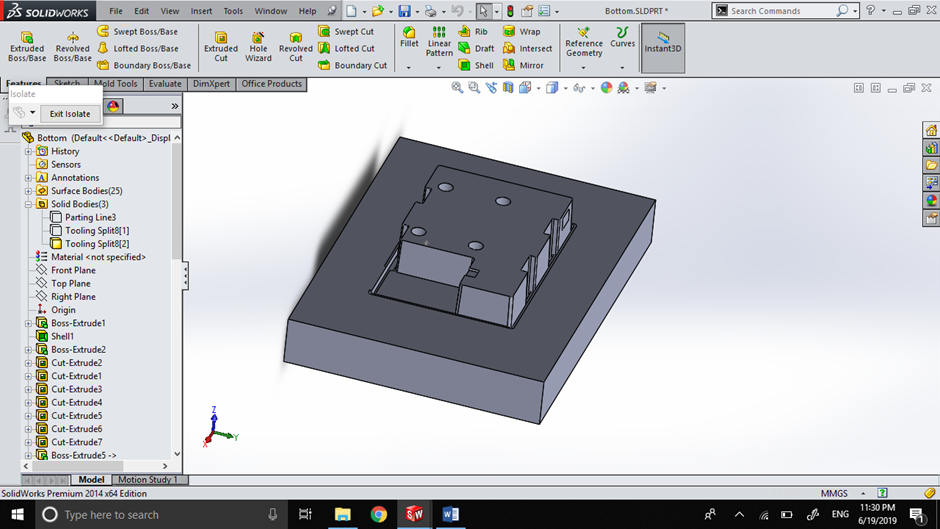
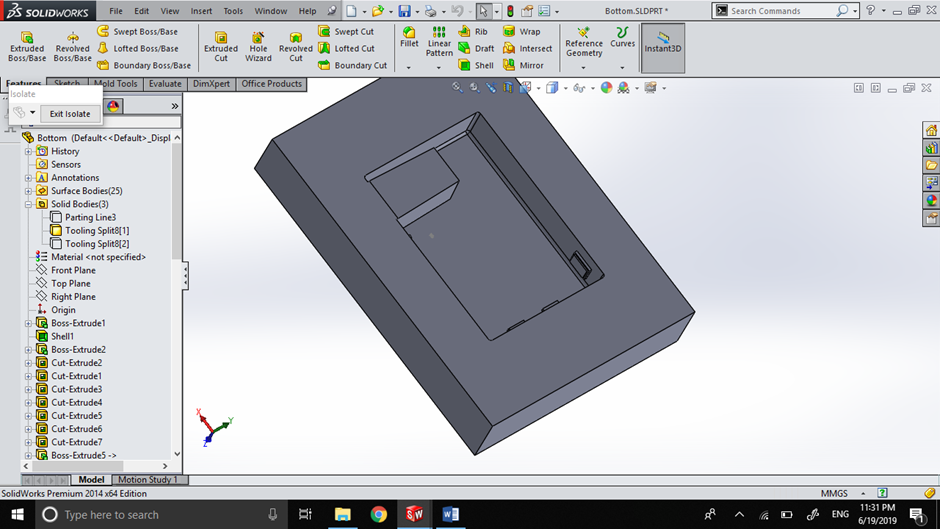
Exploded View of Mold

### Bottom Cover

#### Draft Analysis

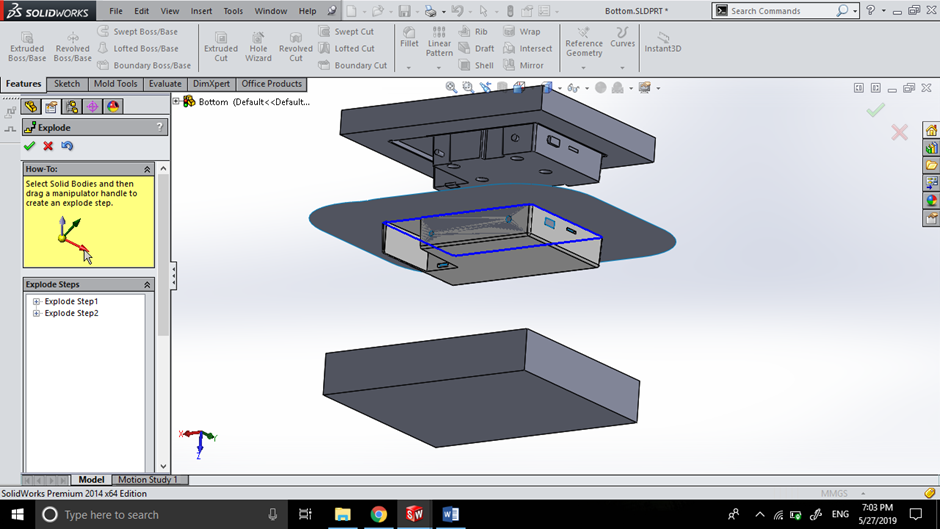


#### Mold Components



Core

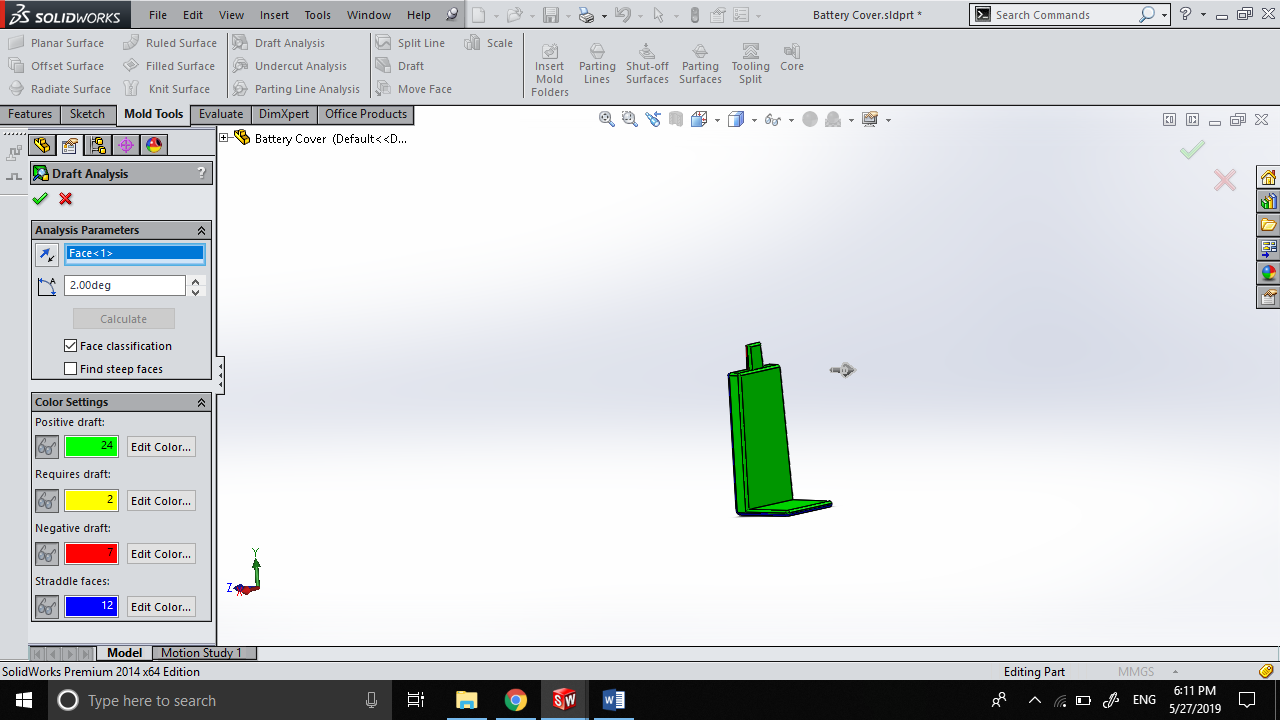
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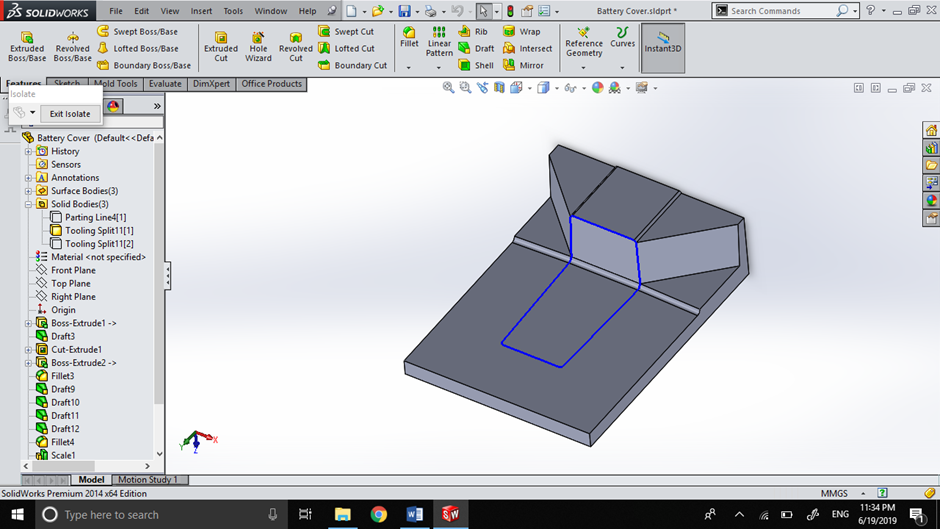
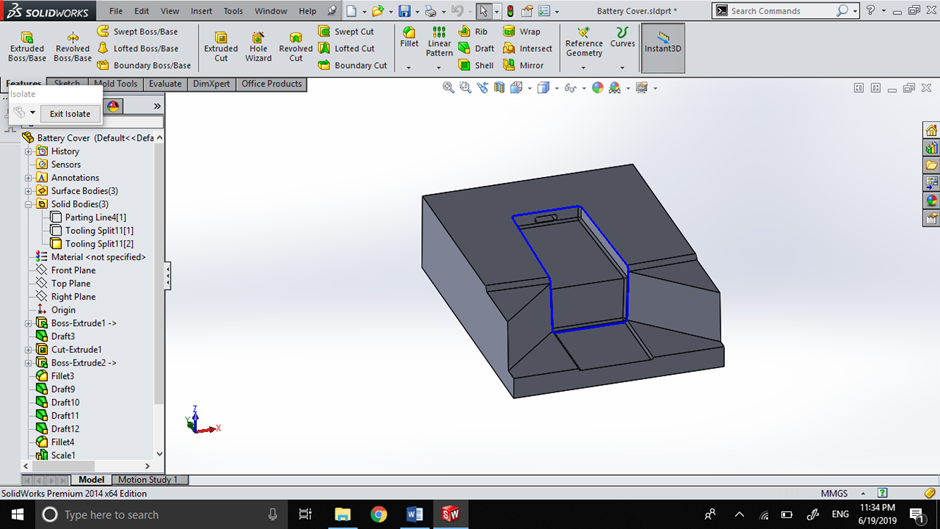
Exploded View of Mold

### Battery Cover

#### Draft Analysis

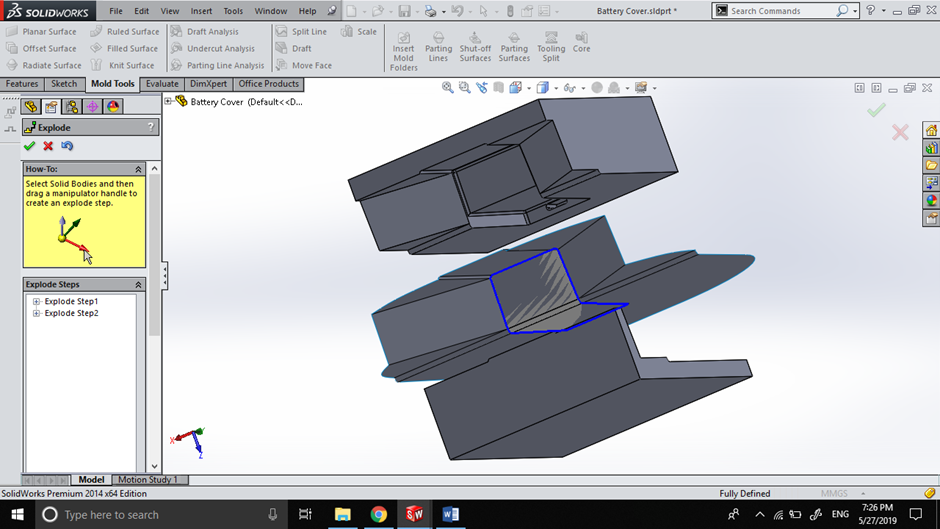


#### Mold Components



Core

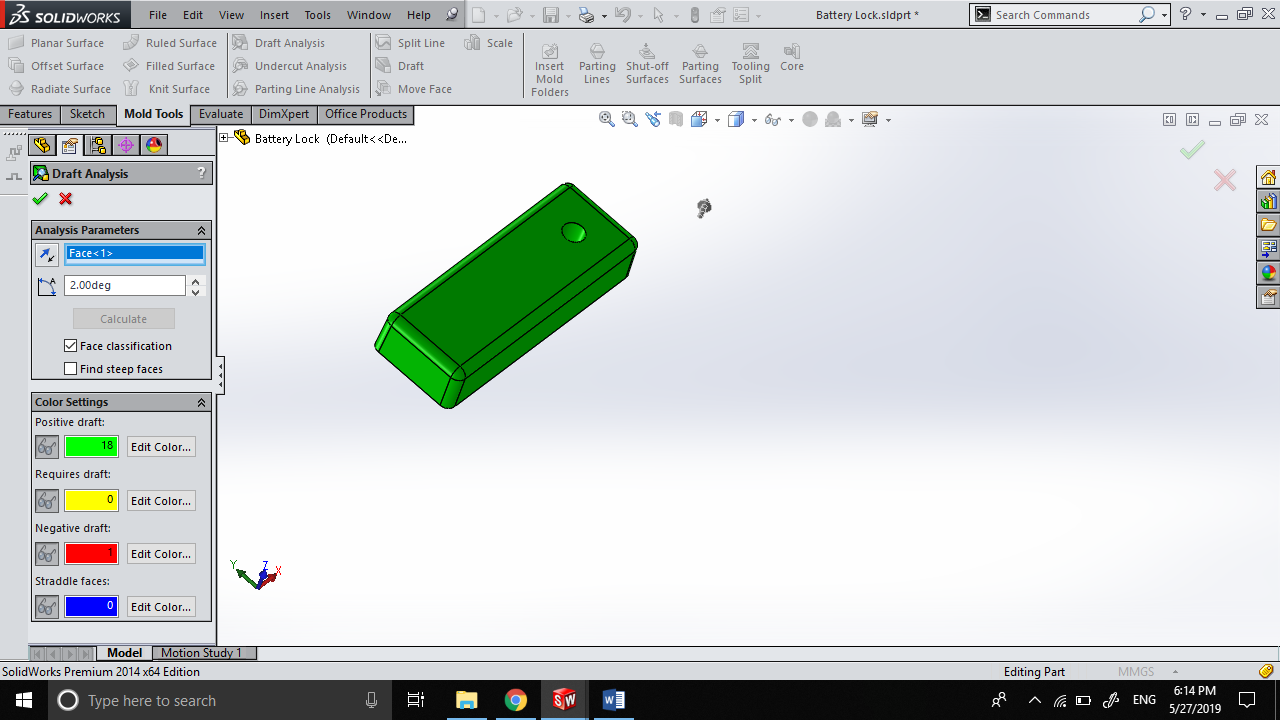
Cavity



Exploded View of Mold

### Battery Lock

#### Draft Analysis



Display Unit Enclosure