

SAMPLING AND RELEASE ACCORDING TO HQ-P-7.3 AND NMA SUPPLIER MANUAL	
SPECIAL CHARACTERISTIC	QUANTITY
SRC	0
SC	0
FC	0
CD	5

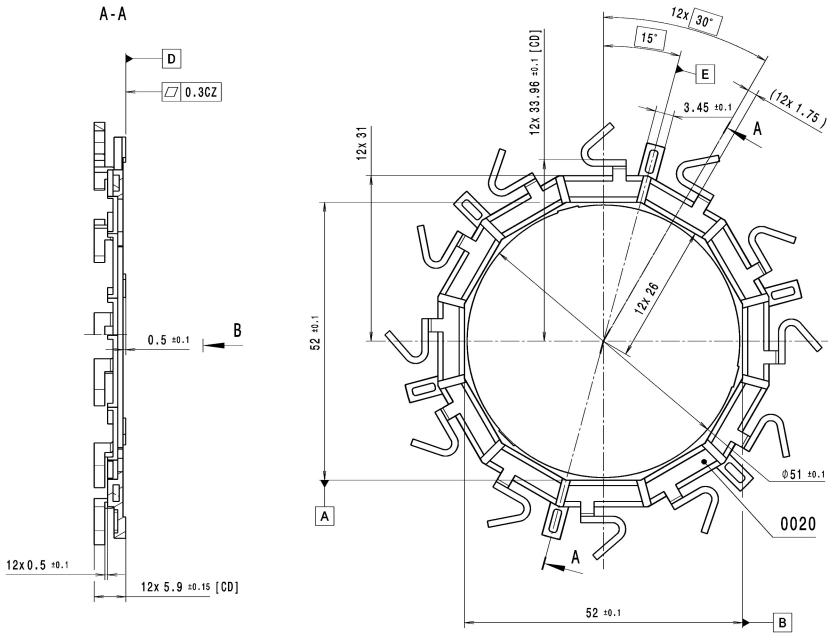
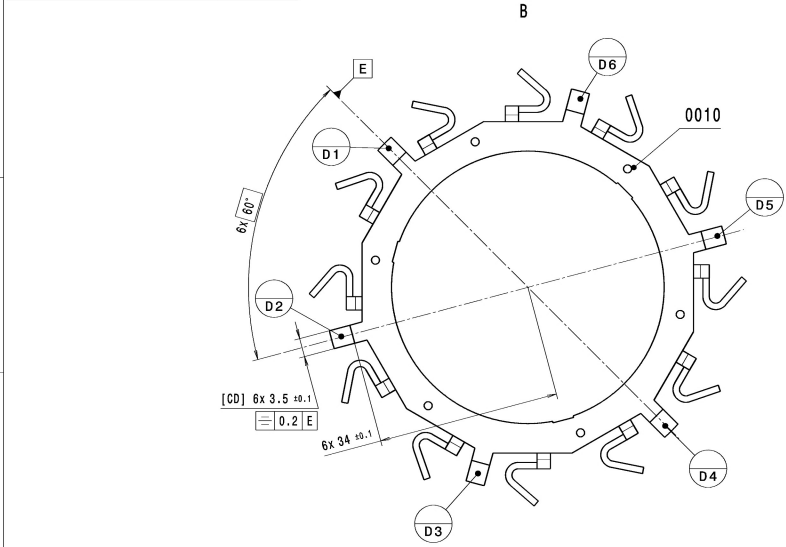


FIG.1 WRITTEN METHOD OF PRODUCTION DATE.
MANUFACTURING YEAR/WEEK



FIG.2 THE WRITTEN METHOD OF CAV. NO.
AND MATERIAL NO.

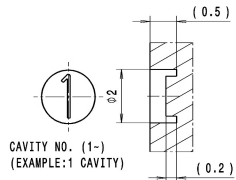
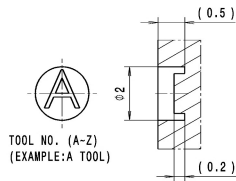
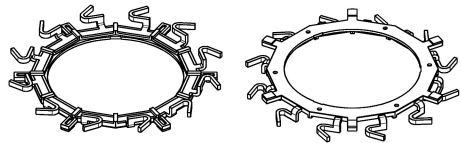


FIG.3 THE WRITTEN METHOD OF TOOL. NO.



PERSPECTIVE VIEW
1:1



DATUM
ORIGIN O: INTERSECTION POINT BETWEEN DATUM A AND DATUM B
X-AXIS: AXIS PERPENDICULAR TO X-AXIS PASS THROUGH ORIGIN.
Y-AXIS: AXIS PASSING THROUGH DATUM E AND ORIGIN AND ROTATED 15° TO CCW DIRECTION

LIMIT DIMENSIONS FOR NOMINAL SIZE RANGES IN mm	...8	>8...30	>30...120	>120...400	>400...1000
TOLERANCES FOR NOMINAL SIZE RANGES IN mm	0.1	0.2	0.3	0.5	0.8
LIMIT DIM. FOR NOMINAL SIZE RANGES IN DEGREE/ MINUTE (SHORTER ANGLE SIDE)	...10	>10...50	>50...100	>100	>100
TOLERANCES FOR NOMINAL SIZE RANGES	1	1°	30'	20'	10'
SURFACE FINISH ACC. TO SNF 00.051	NORM FOR SURFACE FINISH				

SURFACE TEXTURE ACC. TO DIN EN ISO 1302	EDGES ACC. TO ISO 13715
GEOMETRICAL PRODUCT SPECIFICATIONS (GPS) SIZE ISO 14405 (E)	GEOM. TOLERANCING ACC. TO DIN EN ISO 1101
STOCK MATERIAL	
CUSTOMER REFERENCE NO.	
MATERIAL REFERENCE NO.	SEE NOTE 2
NORM FOR MATERIAL SPECIFICATION ACC. TO SNF 10.2XX	ISO 1043

MATERIAL NO. 504-642-99-99	OLD SPAIN MATERIAL NO.	REFERENCE NO.
ALL DIMENSIONS IN mm	TITLE ZUS STROMSCHIENE BUSBAR ASSY	ARTICLE NO. 7425
RELEASE-LEVEL RELEASED	DT DOCUMENT NO. 10000031839	VERSION 01
DATE 25.10.2019	NAME DABROWSKI	SHEET 1
CHECKED 19.12.2019	DESIGN DABROWSKI	OF 1
RELEASED 20.10.2019	INCH/CM UNSPECIFIED	FORMAT A1
SUB. FOR		
NIDECC MOTOR & ACTUATORS GERMANY / POLAND / SPAIN		
COMPUTER DRAWING PLOTTED AT		

TABLE 1. GENERAL TOLERANCE

DIMENSION		DIMENSION IN A TOOLING	DIMENSION IN MULTIPLE TOOLING
OVER	LESS THAN		
-	6	±0.17	±0.22
6	22	±0.20	±0.30
22	40	±0.28	±0.38
40	70	±0.40	±0.50
70	120	±0.60	±0.70

ANGULAR DIMENSION		
OVER	LESS THAN	TOLERANCE
ALL DIMENSION		

TABLE 2. EDGE AND CORNER DIMENSION

EDGE / CORNER	
INSIDE	OUTSIDE
±0.3	±0.3

TABLE 3. ERROR BETWEEN PRODUCT AND 3D MODEL

DIMENSION RANGE	DIMENSION TOLERANCE
-40	±0.20
40~	±0.30

TABLE 4. SYMBOLS AND ABBREVIATED TERMS OF RESIN

CONTENTS OF MARKING	>PBT-GF30<
HEIGHT OF CHARACTER	*2mm min.
SHAPE	CONVEX SHAPE (HEIGHT *0.2mm min.)
FONT	UNSPEC FIED

- NOTE:
- PARTS/MATERIALS TO COMPLY WITH THE LATEST VERSION OF ENVIRONMENTAL SPECIFICATION (2SAST11X047). (RESIDUES ON PARTS/MATERIALS IN PRODUCTION PROCESS TO ALSO COMPLY WITH IT).
 - MATERIAL: CHANG CHUM PLASTIC PBT3030-104 COLOR: B (BLACK) (POS. 0010) HAS TO COMPLY WITH MATERIAL SPECIFICATION (2SAST131001B)
 - HEIGHT OF GATE TO BE 0.2 [mm]. MAX. POSITION TO BE AGREED WITH NIDECC.
 - USE 100[%] VIRGIN MATERIAL.
 - FREE FROM CRACKS, BREAKS, CHIPS, BURRS, THAT MAY DROP OFF AND VOIDS ON THE SURFACE.
 - FREE FROM HARMFUL SHRINK MARKS AND SHORT-MOLDING.
 - MEASUREMENT METHODS TO BE DECIDED AFTER DISCUSSION.
 - INCUSE CAVITY NO. AND TOOL NO. AS IDENTIFICATION MARK. REFER TO FIG.2 AND FIG.3 HOW TO DESCRIBE. IDENTIFICATION MARKS TO BE UNDER THE SURFACE.
 - THE POSITION OF IDENTIFICATION MARK TO BE DECIDED AFTER DISCUSSION.
 - PRODUCTION YEAR/MONTH/WEEK TO BE INCUSED. REFER TO FIG.1 HOW TO DESCRIBE.
 - PRODUCTION MARKING TO BE UNDER THE SURFACE. PRODUCTION MARKS CAN BE VISUALLY CONFIRMED.
 - [CD] 10. CONTAMINATION SPECIFICATION TO BE COMPLY WITH LATEST VERSION OF " STANDARD CONTAMINATION SPECIFICATION 2SAST159002". MAXIMUM WEIGHT OF ALL PARTICLES (5-500 [µm]) LESS THAN 0.3 [mg]. MAXIMUM NUMBER OF CONDUCTIVE PARTICLES (150-500 [µm]) 4[pcs].
 - MEASUREMENT METHODS TO BE DECIDED AFTER DISCUSSION.
 - DEFINITION OF HOLE FOR BUSBAR POSITIONING PIN IN INJECTION PROCESS HAS TO BE PROPOSED FROM SUPPLIER AND HAS TO BE APPROVED BY NIDECC.
 - REFER TO GENERAL TOLERANCE OF TABLE 1 FOR NO INDICATED DIMENSIONS.
 - REFER TO CORNER DIMENSION OF TABLE 2 UNLESS OTHERWISE SHOWN INDIVIDUALLY.
 - >PBT-GF30< OF RESIN TO BE INCUSED. REFER TO TABLE 4 ABOUT HOW TO DESCRIBE.
 - THE POSITION OF IDENTIFICATION MARK TO BE DECIDED AFTER DISCUSSION.
 - THE SUPPLIER IS OBLIGATED TO TAKE THE MISSING DIMENSIONS FROM THE 3D MODEL AFTER NIDECC AGREEMENT.
 - [CD] CRITICAL DIMENSION IS FOR IMPORTANT INQUIRY WHICH DOES NOT HAVE SPECIAL CHARACTERISTICS INDICATION, E.G. RELATED TO MOTOR PERFORMANCE, PRODUCTIVITY AND CUSTOMER INTERFACE. PPK>1.33 AT PPAP AND CPK >1.00 IN MASS PRODUCTION ARE REQUESTED. DATA HAS TO BE PROVIDED ACCORDING TO NIDECC REQUEST.
 - [CD] 18. COMPONENT TO BE CHECKED BY GAUGE ACC. TO CONTROL PLAN.

WEIGHT: 14.5 [g] [REFERENCE]

0020	504-665-99-99	1.0	ANSCHLUSS	TERMINAL	10000031835	CDR N.A.
0010	504-664-99-99	1.0	EINSPRITZTEIL	MOULDING	10000031836	
ITEM	MATERIAL NUMBER	QUANT.	TITLE	DOCUMENT NO.		