

MATERIAL: CHI MEI WONDERLOY XXX ABS - PC-510
COLOR: BLACK

TEXTURE AND FINISH:

BLUE SURFACES: TEXTURE TO MOLDTECH 11010 OR YICK SANG EQUIVALENT. COSMETIC FINISH SHALL BE IN ACCORDANCE WITH SOCIETY OF PLASTICS INDUSTRY (SPI) COSMETIC SPECIFICATION AQ-103, GRADE 2, CLASS B SURFACE.

GREEN SURFACES: NON VISIBLE SURFACES. LIGHT EDM FINISH OR EQUIVALENT, SPI AQ-103 GRADE 2 CLASS C.

NOTES, UNLESS OTHERWISE SPECIFIED:

1. **TOLERANCES:** ALL DIMENSIONS ARE IN MM [INCHES]. UNLESS OTHERWISE STATED, FEATURE SIZE AND POSITIONAL TOLERANCES ARE AS FOLLOWS:

FEATURE SIZE OR POSITION RANGE:	TOLERANCE:
0.00MM TO 25MM:	±0.10MM
FOR EACH ADDITIONAL 25MM:	±0.033MM

2. **CAD:** USE ELECTRONIC FILE FOR TOOLING AND MANUFACTURE.

3. **QUALITY INSPECTION:** IT SHALL BE THE MANUFACTURER'S RESPONSIBILITY TO VALIDATE THAT MOLDED PARTS MANUFACTURED TO THIS SPECIFICATION COMPLY WITH BOTH THE DIMENSIONED GEOMETRY DISPLAYED ON THIS SPECIFICATION DRAWING AND THE UNDIMENSIONED GEOMETRY DEFINED WITHIN THE ASSOCIATED 3D CAD DATA FILE (SEE NOTE 2).

1. DIMENSIONS IN OVALS ARE CONSIDERED TO BE CRITICAL TO FUNCTION "CONTROL DIMENSIONS" AND MUST BE INSPECTED BY THE MANUFACTURER ON AN ON-GOING / REGULAR PRODUCTION BASIS. IT SHALL BE THE MANUFACTURER'S RESPONSIBILITY TO BE PREPARED TO PROVIDE "DOCUMENTED EVIDENCE" OF INSPECTION AND DIMENSIONAL COMPLIANCE WHENEVER REQUESTED. INSPECTION RESULTS / REPORTS MUST BE TRACEABLE BACK TO SPECIFIC DATES OF MANUFACTURE.

2. FOR ALL UNDIMENSIONED GEOMETRY, IT SHALL ALSO BE THE MANUFACTURER'S RESPONSIBILITY TO OBTAIN THE NOMINAL FEATURE SIZE REQUIREMENTS FROM WITHIN THE ASSOCIATED 3D BODY CAD DATA FILE AND COMPLY WITH THE SPECIFIED "FEATURE SIZE TOLERANCE RANGES" INDICATED ON THIS SPECIFICATION DRAWING. ALL DIMENSIONS THAT ARE NOT IDENTIFIED AS "CONTROL DIMENSIONS" NEED NOT BE INSPECTED ON AN ON-GOING / REGULAR PRODUCTION BASIS, HOWEVER, THIS DOES NOT RELIEVE THE MANUFACTURER OF THEIR RESPONSIBILITY FOR COMPLIANCE TO ALL DIMENSIONS - CODED, TOLERANCE OR OTHERWISE DEFINED BY THE 3D DATA FILE.

4. **PARTING LINE, EJECTOR PINS, AND GATES:** GATES, EJECTOR PIN AND PARTING LINE LOCATION SHALL BE APPROVED. EJECTOR PIN AND INTERNAL GATE MARKS SHALL BE FLUSH WITHIN 0.005" OF ADJACENT SURFACE. EXTERNAL GATE MARKS SHALL BE TRIMMED FLUSH.

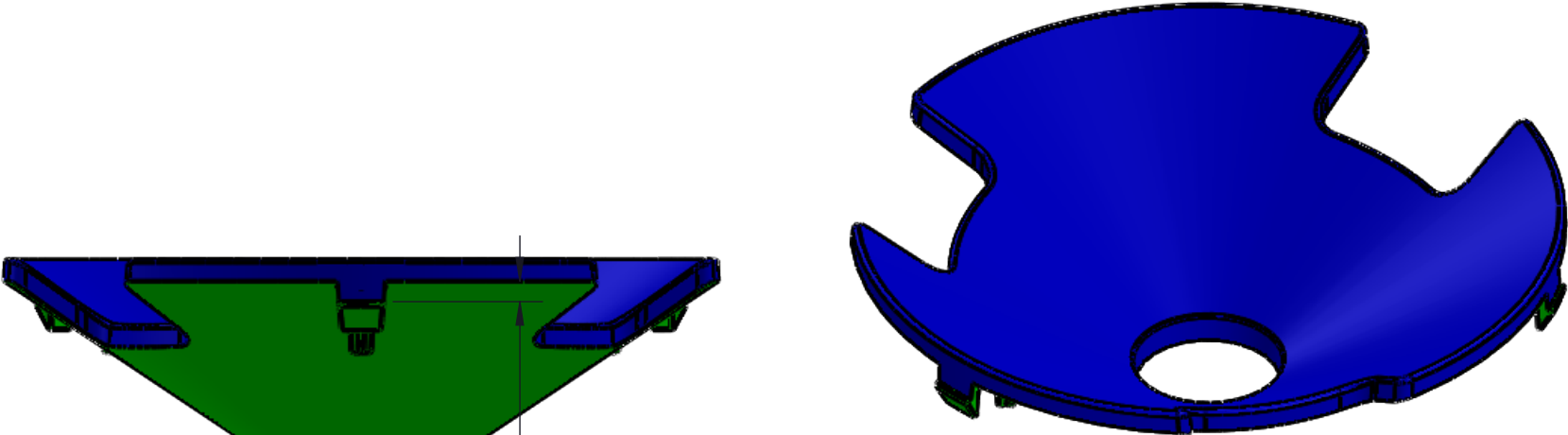
5. **PART CLEANLINESS:** PARTS SHALL BE CLEAN AND FREE OF DIRT, GREASE, OILS AND ANY TYPE OF MOLD MAINTENANCE FLUIDS, FOREIGN PARTICLES AND DISCOLORATIONS. CLEAR PARTS SHALL NOT HAVE ANY VOIDS OR BUBBLES. MOLD RELEASE SHALL NOT BE USED.

6. **PACKAGING:** SUPPLIER SHALL BE RESPONSIBLE FOR ADEQUATE PROTECTION AGAINST SHIPPING AND HANDLING DAMAGE. .

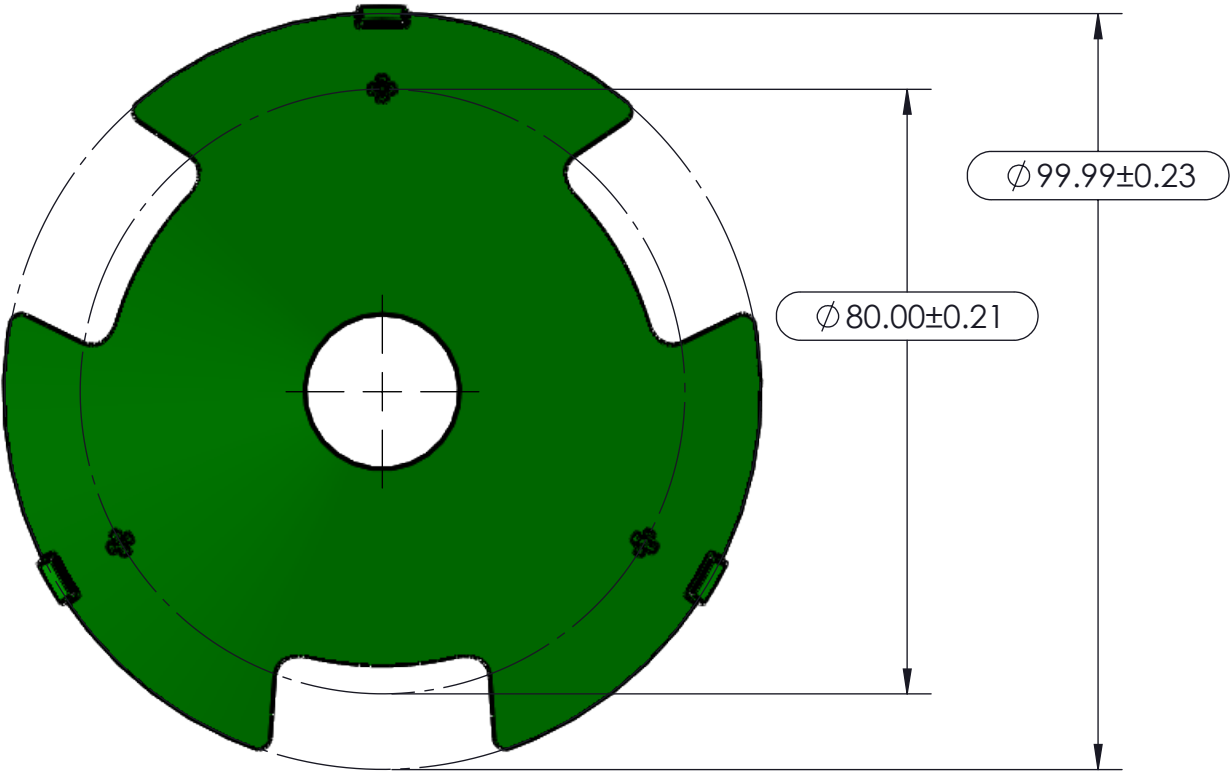
7. **PART IDENTIFICATION MARKING:** PART NUMBER, ISO MATERIAL CODE AND RESIN IDENTIFICATION CODE TO BE LOCATED WHERE APPROXIMATELY SHOWN. LETTERING SHALL BE APPROXIMATELY 3 MM TALL AND SHALL NOT EXCEED 0.1MM IN HEIGHT ABOVE ADJACENT SURFACE.

8. **CONTROLLED DRAWING:** NO CHANGES SHALL BE MADE TO THIS DRAWING WITHOUT WRITTEN APPROVAL.

9. **RoHS COMPLIANCE:** THIS PART SHALL COMPLY WITH THE EU2002/95/EC(RoHS) AND EU 9.2002/96/EC (WEEE) DIRECTIVES



2.85±0.08



Ø 99.99±0.23

Ø 80.00±0.21

PROJECT MOAB

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TOLERANCES:

REFER TO NOTES FOR TOLERANCE INFORMATION.

SIZE:

B



TITLE:

CLOSEOUT CONE

ENGINEER:

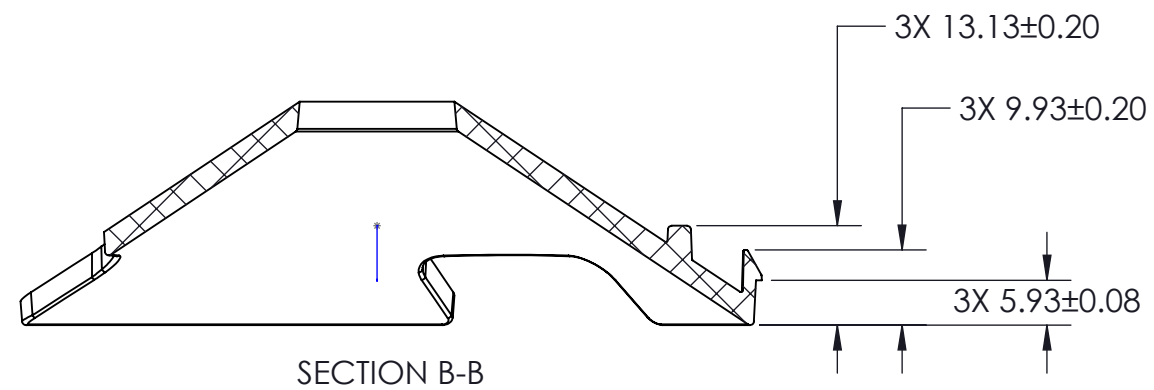
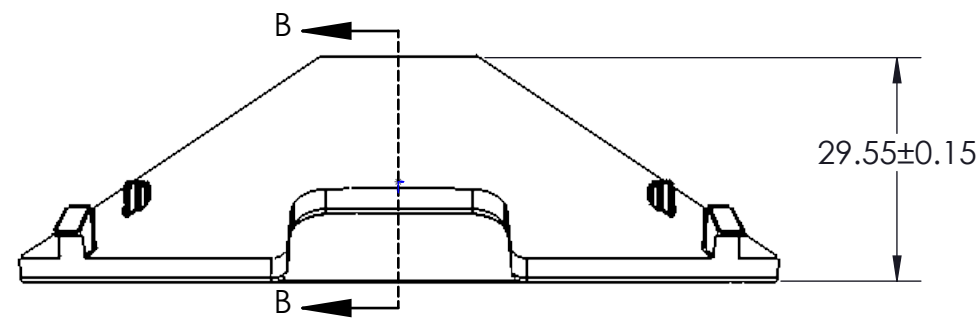
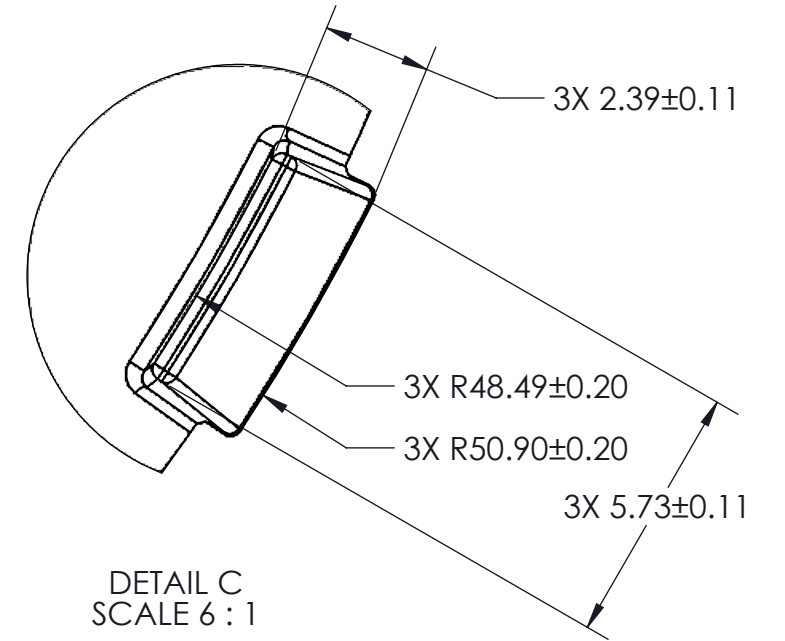
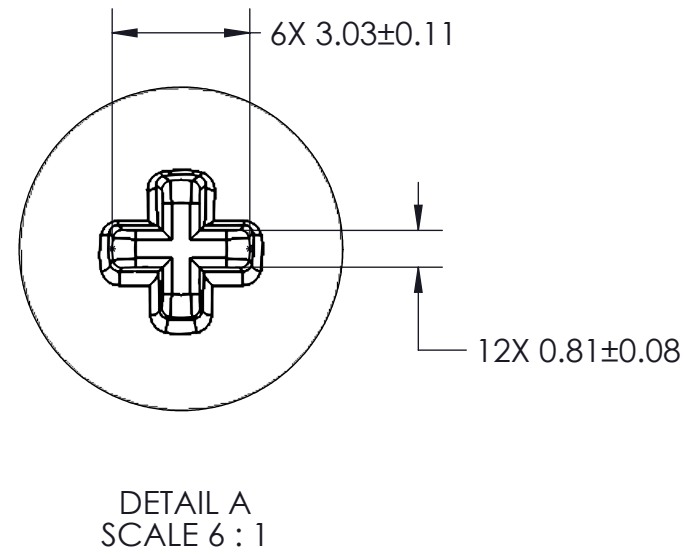
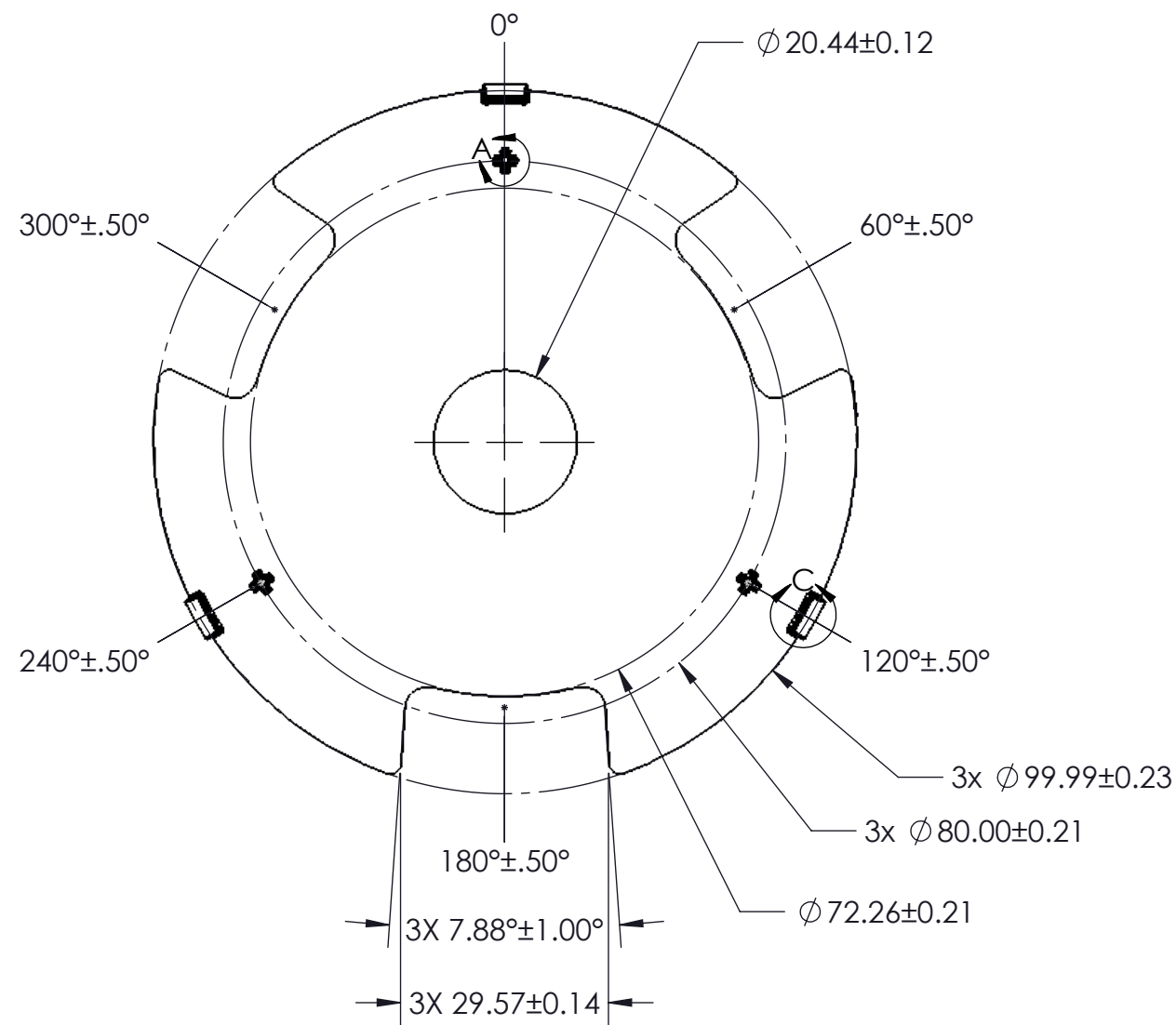
DRAWN BY:

DATE CREATED: 05/19/2020

PART NUMBER:

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DISCLAIMER

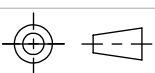
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