

DETAIL B  
SCALE 2:1


MAX 0.010 RADIUS  
ALLOWABLE AT  
SHARP CORNERS  
20 PLACES

NOTE: FACES MARKED 'A' ARE  
VISIBLE TO CUSTOMER,  
CONSIDERATIONS REGARDING  
GATE AND EJECTOR PIN  
LOCATION SHOULD BE MADE

| LETTER | FINISH  | DESCRIPTION        |
|--------|---------|--------------------|
| A      | SPI D-1 | DULL FINISH        |
| B      | SPI A-3 | HIGH POLISH FINISH |

## NOTES

1. IF DIMENSION IS NOT SPECIFIED, ASSUME TOLERANCE:  $\pm 0.015"$
2. 3D FILE DIMENSIONS SUPERSEDE DIMENSIONS IN THIS DOCUMENT.
3. TOLERANCE FOR NOTED DIMENSIONS ARE AS FOLLOWS:  
X.XX =  $\pm 0.010"$   
X.XXX =  $\pm 0.005"$
4. TOLERANCE FOR ALL ANGLES:  $\pm 0.5$  DEGREES
5. TOLERANCE FOR ALL RADII:  $\pm 0.005$  OR 10%, WHICHEVER IS SMALLER.
6. SURFACE IS CLEAN AND FREE OF BURRS AND ROUGH EDGES.
7. REFER TO SOLID MODEL FOR DRAFT ANGLE ON SURFACES UNLESS OTHERWISE NOTED.
8. REFER TO SOLID MODEL FOR CORNER AND FILLET RADII UNLESS OTHERWISE NOTED.
9. UNLESS OTHERWISE NOTED, ALL SURFACES TO BE MINIMUM OF SPI C3 FINISH. ALL TOOL AND CUTTER MARKS TO BE REMOVED.
10. GATE, PARTING LINE, EJECTOR PIN LOCATIONS, AND OTHER FEATURES FOR TOOLING CONSIDERATIONS SHALL BE APPROVED BY ECOVENT BEFORE TOOL CONSTRUCTION.
11. PARTING LINE FLASH, GATES, RUNNER, AND RISER STUBS 0.005" MAXIMUM.
12. EJECTOR PIN MARKS SHALL BE FLUSH TO .003 UNDERFLUSH WITH SURFACE.
13. VISIBLE SINK MARKS TO BE .0005" DEEP MAX ON ALL COSMETIC SURFACES.
14. [◆] CALLOUTS ARE APPLIED TO TOLERANCES THAT MAY REQUIRE SPECIAL QUALITY CONTROL PROCESSES. QUALITY CONTROL INSTRUCTIONS ARE OUTSIDE THE SCOPE OF THIS DRAWING AND ARE DEFINED BY EXTERNAL DOCUMENTATION TO BE AGREED TO WITH THE MANUFACTURER.
15. NO REGRIND ACCEPTABLE.
16. INTERIOR OF PART TO SHOW PART NUMBER, TOOL AND CAVITY NUMBER, TOOL REVISION (ON EJECTOR PIN), AND MATERIAL SYMBOL.
17. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS AND TOLERANCES ARE APPLICABLE AT 20 DEGREES CELSIUS (68 DEGREES FAHRENHEIT) IN ACCORDANCE WITH ANSI/ASME B89.6.2.
18. ALL HOMOGENEOUS MATERIALS AND PROCESSES IN THIS DRAWING SHALL BE COMPLIANT TO THE EU RoHS DIRECTIVE 2011/65/EC.

|  |                              |                                   |          |    |   |  |  |  |        |     |                                   |   |   |            |   |   |         |
|--|------------------------------|-----------------------------------|----------|----|---|--|--|--|--------|-----|-----------------------------------|---|---|------------|---|---|---------|
| REV  | DESCRIPTION                  | ECO                               | DATE     | BY | <b>DO NOT SCALE DRAWING. WORK TO DIMENSION</b><br>IF PLATING IS SPECIFIED, ALL DIMENSIONS TO BE MET AFTER PLATING<br>DIMENSIONS ARE TO 0.15" UNLESS OTHERWISE SPECIFIED<br>1. PERMISSIBLE TOLERANCES<br>2. ALL RIGHT ANGLES=90°<br>3. DIMENSIONS GIVEN IN INCHES<br>CHAMFER ANGLES=45°<br>CONCENTRICITY=0.010 T.I.R.  |  |  |  |        |     |                                   |   |   |            |   |   |         |
| A  | INITIAL TOOL RELEASE         |                                   |          |    | NOTICE: CHANGES TO MATERIAL, DESIGN, CONFIGURATION OR PROCESS MAY NOT BE MADE WITHOUT NOTIFICATION TO ECOVENT, ALL MATERIALS AND PROCESSES MUST BE COMPLIANT WITH ENVIRONMENTAL LAWS AND REGULATIONS AS REFERENCED IN XXXXX<br><table><tr><td>DESIGN</td><td>CTQ</td><td>CLASSIFICATION OF CHARACTERISTICS</td></tr><tr><td>★</td><td>★</td><td>(CRITICAL)</td></tr><tr><td>◆</td><td>◆</td><td>(MAJOR)</td></tr></table> |  |  |  | DESIGN | CTQ | CLASSIFICATION OF CHARACTERISTICS | ★ | ★ | (CRITICAL) | ◆ | ◆ | (MAJOR) |
| DESIGN   | CTQ                          | CLASSIFICATION OF CHARACTERISTICS |          |    |   |  |  |  |        |     |                                   |   |   |            |   |   |         |
| ★  | ★                            | (CRITICAL)                        |          |    |   |  |  |  |        |     |                                   |   |   |            |   |   |         |
| ◆  | ◆                            | (MAJOR)                           |          |    |   |  |  |  |        |     |                                   |   |   |            |   |   |         |
| B  | ADD ULTRASONIC WELD FEATURES | ECO-000057                        | 12/08/15 | TF |   |  |  |  |        |     |                                   |   |   |            |   |   |         |
| C  | ADD SUPPORTS FOR TOP POWER   | ECO-000057                        | 12/17/15 | TF |   |  |  |  |        |     |                                   |   |   |            |   |   |         |
| D  | KEY FEATURE                  | 000078                            | 02/24/16 | TF |   |  |  |  |        |     |                                   |   |   |            |   |   |         |
| MATERIAL: L80518UV LTL COLOR COMPOUNDERS FRPA100X WHITE (WHITE ABS/PC)-UV RESISTANT OR ECOVENT APPROVED EQUIVALENT |                              |                                   |          |    | REVIEW: _____ DATE: _____   |  |  |  |        |     |                                   |   |   |            |   |   |         |
| FINISH _____   |                              | DESCRIPTION _____                 |          |    | TITLE: POWECORE FRONT PLATE A2<br>PART NO. 602-00001<br>SCALE: 1:1<br>SHEET 1 OF 1<br>   |  |  |  |        |     |                                   |   |   |            |   |   |         |
| SEE TABLE  |                              |                                   |          |    | THIS DOCUMENT IS THE PROPERTY OF ECOVENT. NEITHER THIS DOCUMENT NOR ANY INFORMATION CONTAINED HEREIN MAY BE USED, REPRODUCED OR DISCLOSED TO THIRD PARTIES WITHOUT THE WRITTEN PERMISSION OF ECOVENT.   |  |  |  |        |     |                                   |   |   |            |   |   |         |