

Firefly Ice Blue

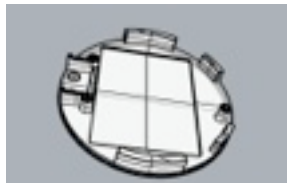
Overview

The Firefly Ice Blue design has 4 elements:

- plastic “back” in black PC
- plastic “shell” in green, pink, blue, and black PC
- plastic “spacer” in black PC
- plastic “top” in clear PC



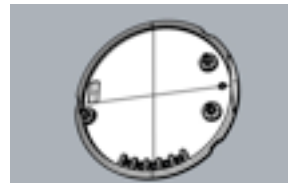
All visible surfaces have a high gloss finish (SPI-A2 or better).



“back”



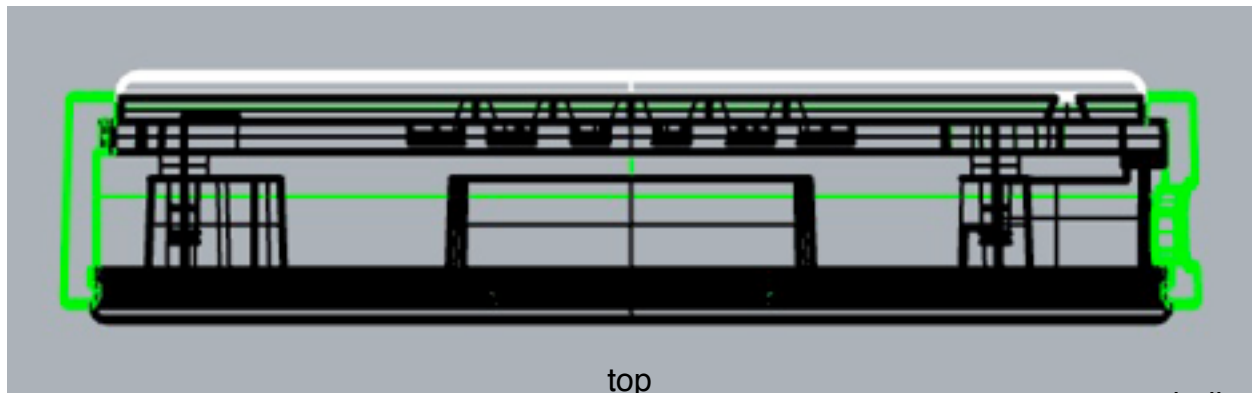
“shell”



“spacer”



“top”



top
cross section

shell

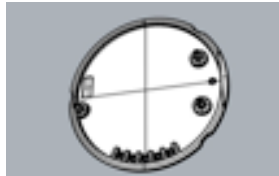
Shell Colors

The shell will be made in 4 colors: green, pink, blue, and black:



Co-Molding

The “top” and “spacer” will be co-molded into a single part, referred to as the “face”. The intent is to form a black part with a high quality clear overcoat to form a visually attractive “face”. The “spacer” has 6 holes where LEDs shine through the “face”.



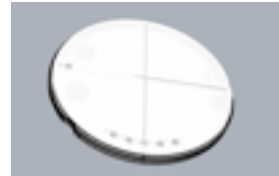
“spacer”

+



“top”

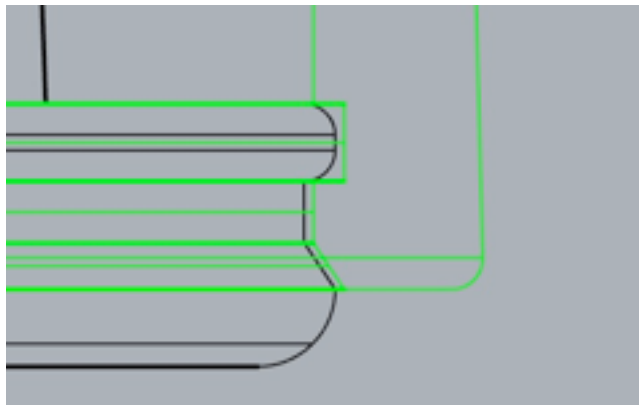
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“face”

Press-Fit

The “back” piece is press-fit into the “shell” and should snap reliably into place. The press-fit is intended to hold the assembly together when if the device is dropped on the side, back, or face onto a hard surface from 4 feet.



USB Connector

The “shell” has a Micro USB connector opening. A Micro USB cable plugs and unplugs through this opening.

Assembly

The final assembly process has three steps:

1. Press “face” into “shell” paying attention to the alignment features. Bond the two parts together by applying a very small amount of low viscosity solvent to the inside mating edge.



back

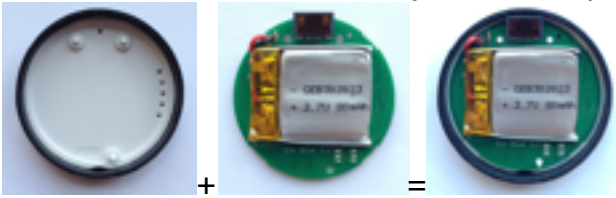
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2. Press the electronic assembly onto the “spacer” pins.



3. Press the “back” onto the “spacer” pins. Press until the “back” snaps into place.

