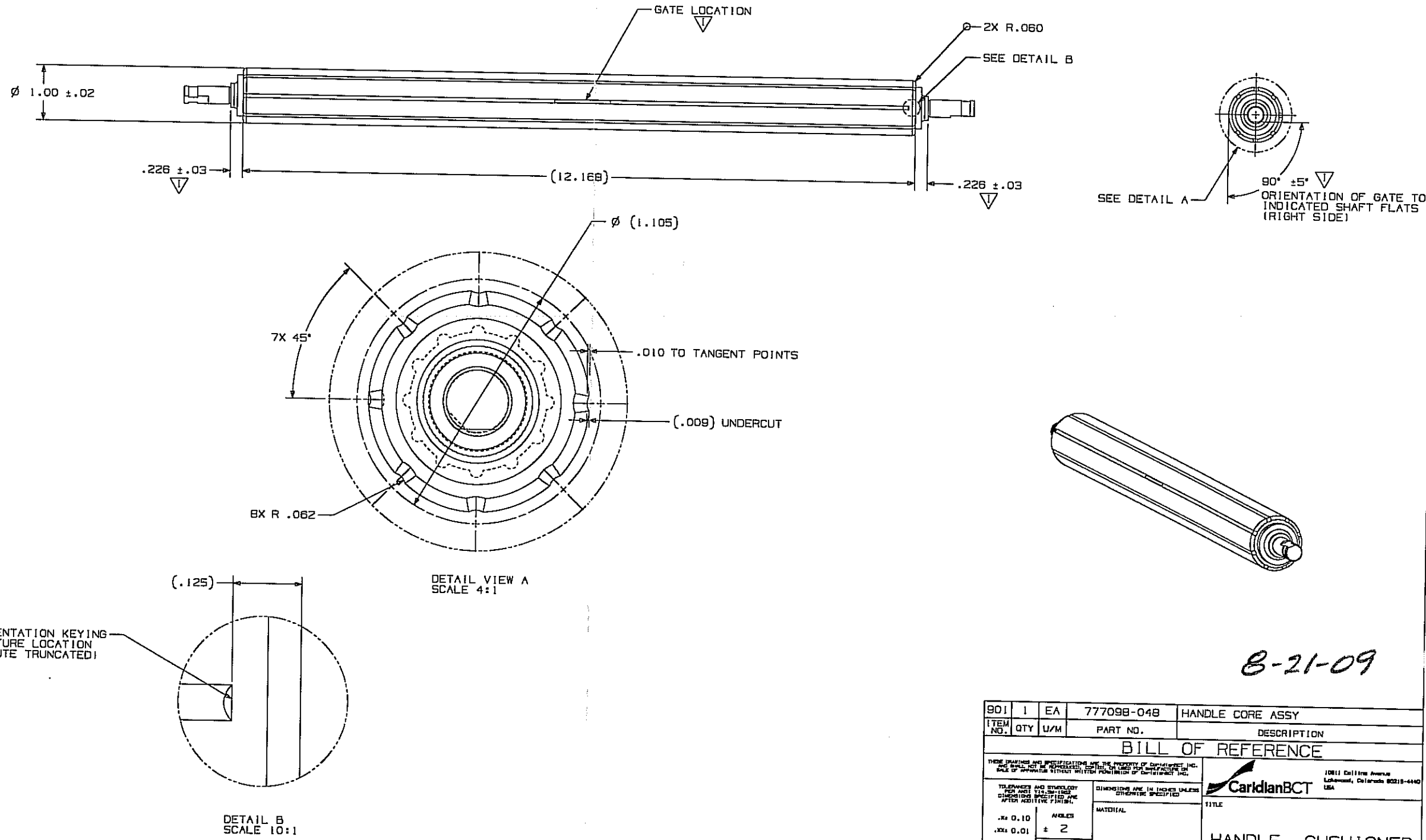


CaridianBCT GENERAL SPECIFICATIONS FOR MOLDED PLASTIC PARTS	
1. SURFACE APPEARANCE	
A. GENERAL APPEARANCE UNLESS OTHERWISE SPECIFIED	
<input type="checkbox"/> NO. 1: EXTRA HIGH LUSTER	
<input type="checkbox"/> NO. 2: HIGH LUSTER	
<input type="checkbox"/> NO. 3: FINE BRUSH	
<input type="checkbox"/> NO. 4: MEDIUM BRUSH	
<input type="checkbox"/> NO. 5: FINE MATTE	
<input type="checkbox"/> NO. 6: COARSE MATTE	
<input type="checkbox"/> NO. 7: NOT CRITICAL (MINIMUM WOULD SURFACE POLISH TO ASSURE PART RELEASE FROM MOLD)	
NOTE: FINISHES 1-6 ARE STANDARD SPI-SPE FINISHES	
B. SURFACE APPEARANCE SPECIFIED IS:	
<input type="checkbox"/> FOR PART FUNCTION	
<input type="checkbox"/> DECORATIVE	
2. DIMENSIONS & TOLERANCES UNLESS OTHERWISE SPECIFIED	
FILLETS SHOWN SHARP 0.000 R MIN TO 0.005 R MAX	
FILLETS SHOWN ROUND 0.005 R MIN TO 0.010 R MAX	
OUTSIDE CORNERS SHOWN SHARP 0.000 R MIN, 0.005 R MAX	
OUTSIDE CORNERS SHOWN ROUND 0.005 R MIN, 0.010 R MAX	
DRAFT FOR ROUND HOLES AND BOSSES 2.0 MAX INCLUDED ANGLE	
DRAFT FOR OTHER SURFACES 1.0 MAX PER SIDE	
NOTE: FLATNESS () SPECIFICATIONS ARE APPLIED WITH PERFECT FORM NOT REQUIRED AT MMC	
3. IDENTIFICATION MARKINGS	
A. CAVITY MARK	
<input type="checkbox"/> EACH CAVITY OF A MULTIPLE MOLD IS TO BE IDENTIFIED BY A CAVITY MARK	
<input type="checkbox"/> IF CAVITY IS REPLACED, THE REPLACEMENT MUST BEAR A MARK DIFFERENT FROM ANY OTHER INCLUDING THE ORIGINAL	
<input type="checkbox"/> LOCATION OF THE CAVITY MARK IS SPECIFIED IF CRITICAL	
B. MOLDERS MARK	
<input type="checkbox"/> LOCATION OF MOLDERS MARK IS SPECIFIED IF CRITICAL	
C. CARIDIANBCT PART NUMBER	
<input type="checkbox"/> IS NOT TO BE MOLDED ON PARTS	
<input type="checkbox"/> IS TO BE MOLDED ON PARTS, LOCATION AS SPECIFIED	
4. MOLDING DEFECTS INCLUDE:	
<input type="checkbox"/> BLACK SPECS, DISPERSED FOREIGN MATERIAL, OR ENTRAPPED AIR BUBBLES > .030" (1.78)	
<input type="checkbox"/> MORE THAN 3 SPECS PER PART > .010" (1.25)	
<input type="checkbox"/> OTHER	
5. EJECTOR PIN MARKS, UNLESS OTHERWISE SPECIFIED	
<input type="checkbox"/> PIN MARKS ACCEPTABLE TO RAISED, DEPRESSED	
<input type="checkbox"/> PIN MARK FLASH MUST BE REMOVED	
<input type="checkbox"/> SOLID PIN MARK FLASH ACCEPTABLE TO MAX	
<input type="checkbox"/> SPECIAL RECESSES: PIN MARK AND PIN MARK FLASH NOT TO EXCEED DEPTH OF RECESS	
6. NO PARTING LINE, GATE, FLASH OR EJECTOR PINS IN NOTED AREA	
NOTE: LOCATION OF GATES AND EJECTOR PINS TO BE APPROVED BY CARIDIANBCT PRODUCT ENGINEERING GROUP	
7. GATE, UNLESS OTHERWISE SPECIFIED	
<input type="checkbox"/> GATE MUST BE REMOVED FLUSH TO .010" (1.25) BELOW SURFACE OF PART	
<input type="checkbox"/> TUNNEL OR SUB-GATE ACCEPTABLE	
<input type="checkbox"/> RECESSED GATES ACCEPTABLE IF BELOW SURFACE	
<input type="checkbox"/> GATE PERMITTED TO MAX HEIGHT	
8. FLASH, UNLESS OTHERWISE SPECIFIED	
<input type="checkbox"/> FLASH PERMITTED TO MAX	
<input type="checkbox"/> HOLES AND THROUGH OPENINGS, INCLUDING FLASH, MUST BE WITHIN SIZE TOLERANCE	
9. CLEANLINESS	
<input type="checkbox"/> PARTS TO BE FREE OF OIL, WAX, DUST	
<input type="checkbox"/> SPECIAL CLEANING REQUIRED PER NOTE ON DRAWING	
<input type="checkbox"/> NOT CRITICAL, AS MOLDED	
<input type="checkbox"/> USE OF MOLD RELEASE IS NOT DESIRABLE. MOLD RELEASE AGENT, IF NECESSARY, MUST BE APPROVED BY CARIDIANBCT	
10. PACKING & SHIPPING: SHIP ON PALLETS IF PRACTICAL	
<input type="checkbox"/> STANDARD CARTON WEIGHT, 110 KG (50 LBS) MAX	
<input type="checkbox"/> SPECIAL PACKING, AS SPECIFIED ON DRAWING	
<input type="checkbox"/> PACKED IN LAYERS WITH SEPARATORS	
<input type="checkbox"/> MAY BE PACKED IN BULK, 44 KG (20 LBS) MAX PER CARTON	
<input type="checkbox"/> DOUBLE PLASTIC BAGGED, FREE OF DEBRIS AND HOLES	
<input type="checkbox"/> SINGLE PLASTIC BAGGED, FREE OF DEBRIS AND HOLES	
11. GENERAL WALL THICKNESS TO BE 0.080 MIN UNLESS OTHERWISE SPECIFIED	
12. MATERIAL SPECIFICATIONS	
A. PERCENT REGRIND ALLOWED (MUST BE WITHIN SPECIFIED LOT)	
<input type="checkbox"/> 0	
<input type="checkbox"/> UNDER 10%	
<input type="checkbox"/> UNDER 25%	
<input type="checkbox"/> UNDER 50%	
<input type="checkbox"/> 100% REGRIND ALLOWED	
<input type="checkbox"/> OTHER % MAX	
B. RESIN LOT NUMBER TRACEABILITY	
<input type="checkbox"/> MUST BE MARKED ON THE PACKAGE WITH EACH SHIPMENT OF PARTS	
C. SHIFT AND MANUFACTURE DATE	
<input type="checkbox"/> TO BE SPECIFIED (MAY BE INCLUDED IN RESIN LOT DESIGNATION)	
D. FOR MEDICAL USE, TO BE TESTED AT CARIDIANBCT FOR MATERIAL TOXICITY ACCORDING TO THE FOLLOWING FUNCTION:	
<input type="checkbox"/> BLOOD CONTACT	
<input type="checkbox"/> POSSIBLE BLOOD CONTACT	
<input type="checkbox"/> FLUID CONTACT	
E. OTHER ADDITIVES ALLOWED	
<input type="checkbox"/> NOTED ON DRAWING	
13. MISMATCH: THE TOTAL MISMATCH PLUS THE ASSOCIATED FLASH AT THE PARTING LINES	
<input type="checkbox"/> .015" (1.38) MAX	
<input type="checkbox"/> .020" (1.51) MAX	
<input type="checkbox"/> OTHER 0.005 MAX	
14. SINKS: DEFECTS ARE:	
<input type="checkbox"/> WHERE LENGTH IS LESS THAN TWICE ITS DEPTH, OR EDGES ARE SHARP, OR DEPTH IS >.030" (1.78), OR DEPTH IS > 50% OF WALL THICKNESS	
<input type="checkbox"/> SPECIFIED ON DRAWING	
15. INDICATES KEY FEATURE/DIMENSION TO BE CHECKED AT INCOMING INSPECTION	

NOTES:

- DIMENSIONS NOT SPECIFIED ON THE DRAWING ARE CONTAINED IN THE DATABASE FOR THIS PART NUMBER AND REVISION.
- INDICATES KEY DIMENSION/FEATURES TO BE CHECKED AT INCOMING I.C.
- TOOLING CHANGES AFTER APPROVED FIRST ARTICLE INSPECTION REQUIRE APPROVAL FROM COBE BCT.
- MATERIAL:
SANTOPRENE THERMOPLASTIC ELASTOMER GRADE 201-73 (73 SHORE A),
COLOR FOCUS LIGHT TEAL, COLOR CONCENTRATE NO. 00084564 SPR
SUGGESTED SOURCE FOR COLOR CONCENTRATE CLARIANT CORP.

REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	INITIAL RELEASE, REPLACES 777098-075	CH	1/13/00	BCT008923
B	ADDED DETAIL B AND ASSOC. FEATURE	CH	05/20/00	BCT007877
C	MATERIAL WAS 201-64 (64 SHORE A)	CH	09/20/00	BCT007788
D	REVISED ORIENTATION OF KEYING FEATURE TO FLAT ON SHAFT 180° TO MATCH PARTS AS BUILT; .226 ±.03 WAS ±.02	CH	08/29/00	BCT008072



901	1	EA	777098-048	HANDLE CORE ASSY
ITEM NO.	QTY	U/M	PART NO.	DESCRIPTION
BILL OF REFERENCE				
THESE DRAWINGS AND SPECIFICATIONS ARE THE PROPERTY OF CARIDIANBCT, INC. AND SHALL NOT BE REPRODUCED, COPIED, OR USED FOR ANY PURPOSES OTHER THAN THAT OF APPROVAL WITHOUT WRITTEN PERMISSION OF CARIDIANBCT, INC.				
TOLERANCES AND DIMENSIONS: DIMENSIONS SPECIFIED ARE AFTER FINISHING.		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.		
.X± 0.10 .XX± 0.01 .XXX± 0.005 .XXXX± 0.002		ANGLES ± 2 SURF. FINISH		
SIZE D1:1		DATE 12/08/00		
SCALE 1:1		DRAWN C HAKE		
TITLE HANDLE, CUSHIONED		PART NO. 777098-036		
DATE 12/08/00		REV 1		

8-21-09 408