



AVC ASIA VITAL COMPONENTS CO., LTD.

A117 GPU Thermal Module Assembly

Generic MTD

Rev 09: 05/29/2018

Update:2018/5/29

Rev. 02

MTD Revision History

Update in Blue

Update Date	Drawing Rev	MTD Rev	Update Description	DRI
03/05/18	730-00127-06	06		
03/21/18	730-00127-07	07	Fin zipper modified;FAI 11 nominal reduced 0.70,FAI 6reassigned;FAI 7-9 removed ;FAI 10 tolerance increased 0.1;FAI 15 removed ;FAI14 datums changed ;FAI 14,16 moved to clarify	
03/30/18	730-00127-08	08	Datums B and C moved to inner stand offs,outer inserts height reouced to flush;ad just ments to fin count and pitch affecting vc profile;	
04/04/18	730-00127-09	09	Updated fin radius reassigning FAI 4,fill tube length max increased from 6.5 to 8.5	

Note: Please always check and use the latest MCO revision for all spec.

Piece part summary

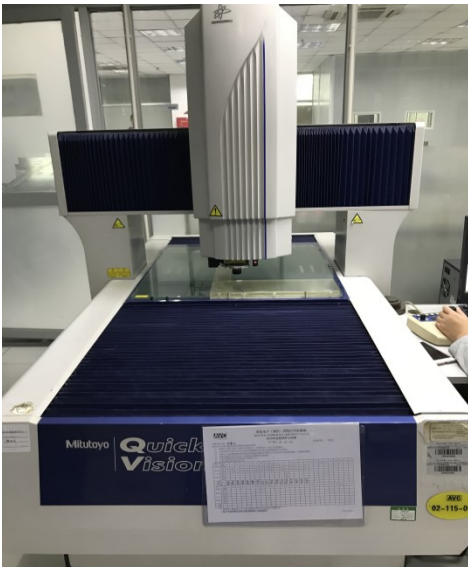
Update in Blue

SPC	FAI	Specification	Description	Part State	In-Process	FAI/Cpk
SPC dimension on the drawing	FAI dimension on the drawing	Nominal +/- Tolerance	Description of dimension being measured Ex. Side flatness	Free /Constrained ?	In-process measurement gage used	Measurement equipment for FAI/Cpk reporting
	FAI 1	8.0 mm Max	长度		-	OMM
	FAI 3	262.00+/- 0.50 mm	总长度		-	CMM
	FAI 4	R3.90+/- 0.10mm	圆角		-	OMM
	FAI 5	1.80+/- 0.10 mm	底高度		-	Height Gauge
	FAI 10	140.1 +/- 0.4mm	总宽度		-	CMM
	FAI 11	4x0.000+0.000/- 0.200mm	高度x 4		-	Height Gauge
SPC I	FAI 12	4x0 .000+/- 0.100mm	高度x 4		-	OMM
SPC E	FAI 13	70.50+/-0.30 mm	轮廓度		-	CMM
	FAI 14	1.0 mm Max	面轮廓度		-	CMM
	FAI 16	0.50 mm Max	面轮廓度		-	CMM
SPC F	FAI 17	4x0.35 mm Max	位置度		-	CMM
SPC G	FAI 18	4x0.35 mm Max	位置度		-	CMM
	FAI 20	1.00 mm Max	面轮廓度		-	CMM
SPC B	FAI 21	0.26 mm Max	平面度		-	CMM
SPC A	FAI 22	0.10 mm Max	平面度		-	CMM

Equipment Information



Brand:	HEXAGON
Type:	Global performance07.10.07
Range:	X=700 mm Y= 1000 mm Z= 1000 mm
Precision:	XYZ = (1.5 + 3L/1000)micron Z = (1.2 + 5L/1000)micron



Brand:	Mitutoyo
Type:	QV606
Range:	X=600 mm Y= 650 mm Z= 250 mm
Precision:	XYZ = (2.2 + 3L/1000)micron Z = (4 + 5L/1000)micron

Equipment Information

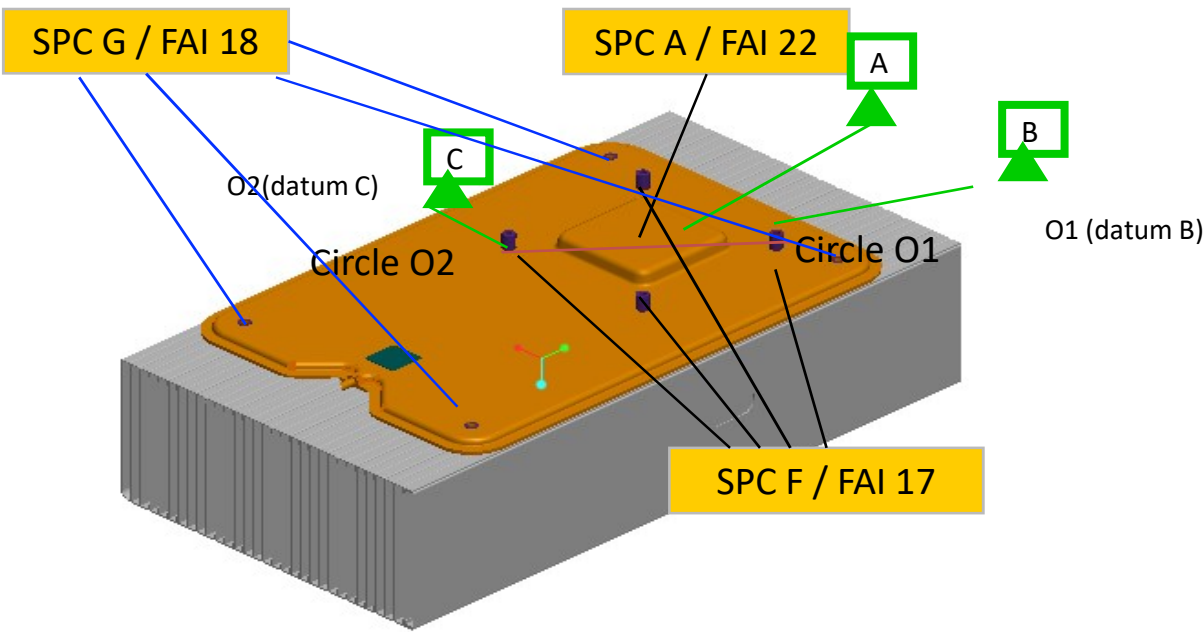


Brand:	Mitutoyo
Type:	543-461B
Range:	0~50mm
Accuracy:	0.001mm

Measurement Method

SPC A	FAI 22	0.1 mm Max	CMM
SPC F	FAI 17	0.35 mm Max	CMM
SPC G	FAI 18	0.35 mm Max	CMM

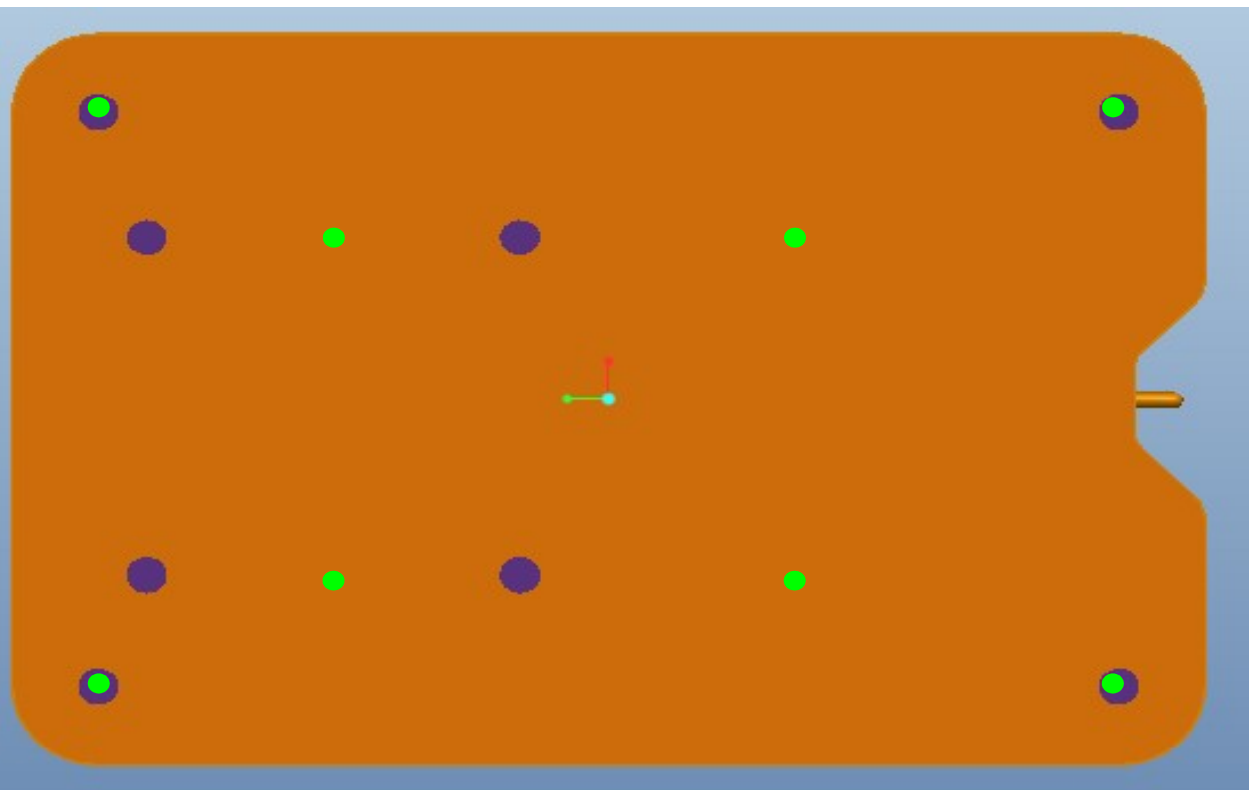
- 1.以上尺寸测试设备均为三次元.
- 2.在凸台面上4个圆角与中心取5个点构成基准面A.
- 3.在螺柱内取8点构造圆1并设为基准原点B
- 4. 在另一螺柱内取8点构造圆2，圆1与圆2构造直线1且圆2偏置64mm并设为基准轴.
- 5. 在凸台面上4表圆角与中心取5点构造平面即可计算其平面度(SPC A)
- 6.在螺柱内取8点构造圆并输入对应的理论值，通过基准即可计算其位置度（SPC F）余下三个螺柱皆按此方法
- 7.在螺纹孔内取8点构造圆并输入对应的理论值，通过基准即可计算其位置度（SPC G）余下三个螺纹孔皆按此方法



Measurement Method

SPC B	FAI 21	0.26mm Max	CMM
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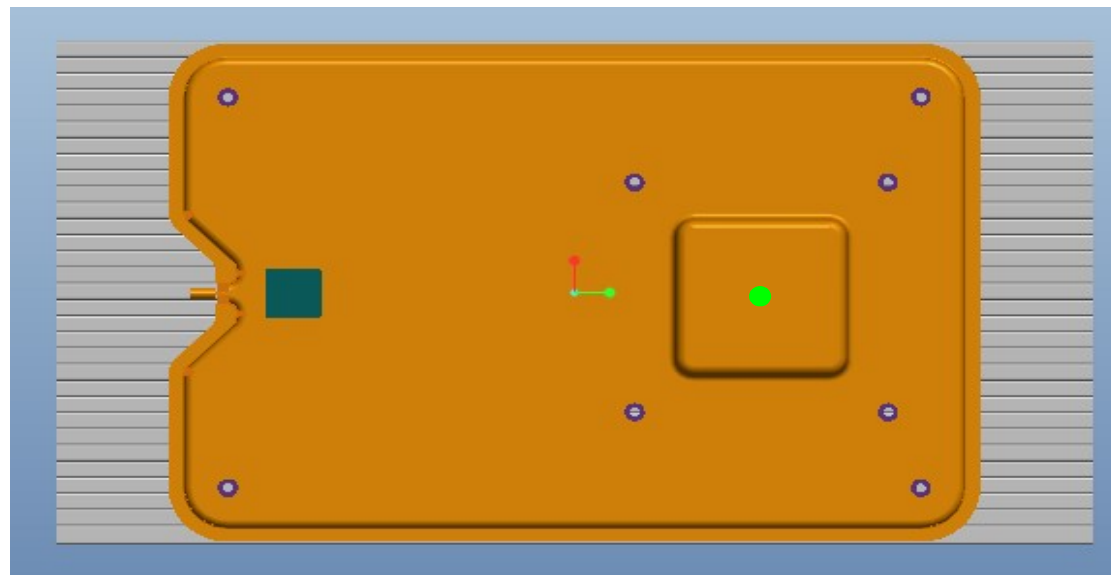
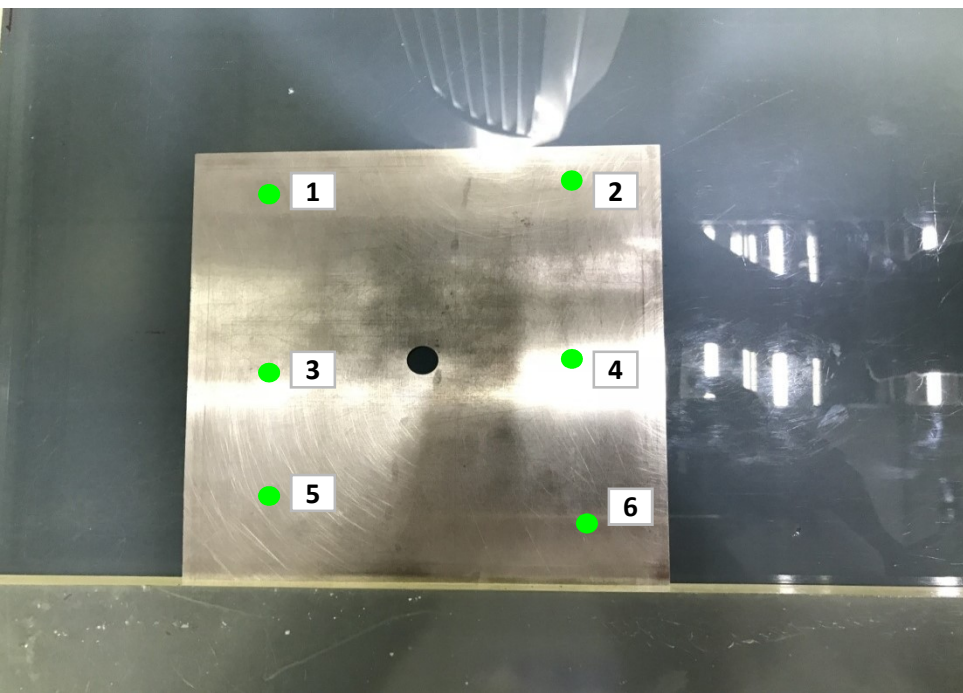
1. 以上尺寸测试设备为三次元.
2. 将样品放在固定柱上，保证不会晃动
3. 在样品上取8点（以外形4个R角的圓心取4個點；2, 中間4個點如下圖，不能太靠近BOSS柱邊緣）构造平面即可计算其平面度。



Measurement Method

SPC E	FAI 13	70.5+/-0.3 mm	CMM
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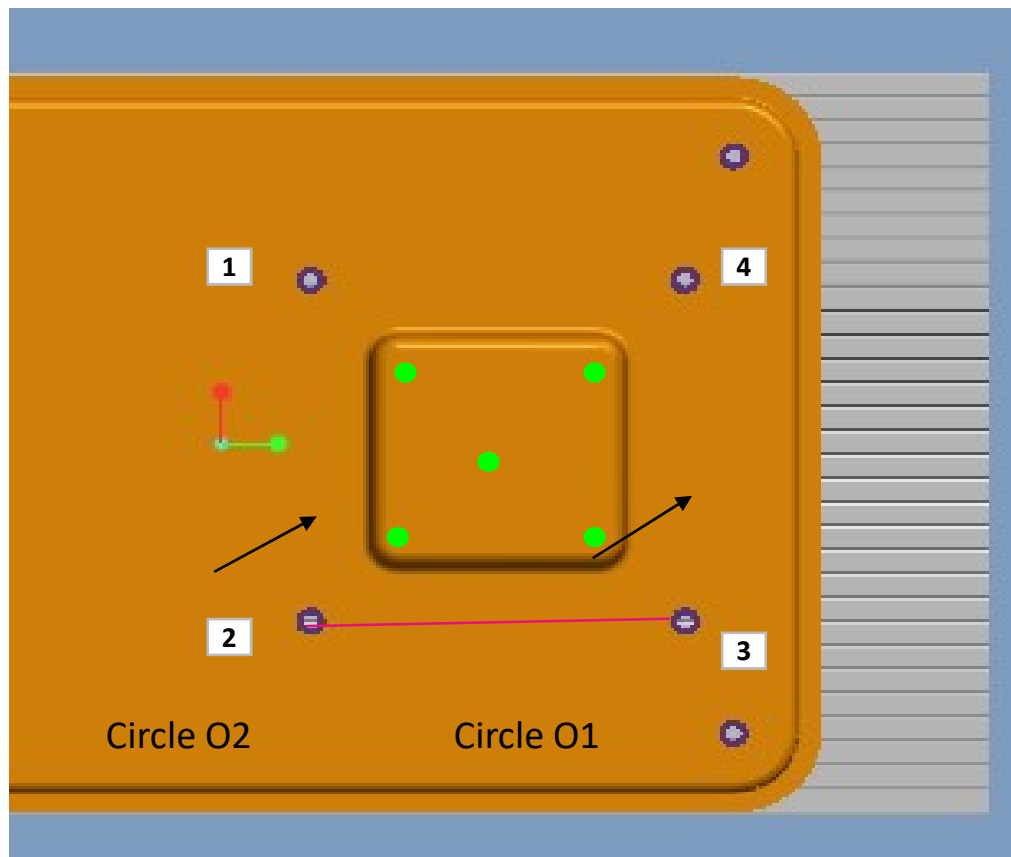
1. 以上尺寸测试设备为投影仪.
2. 在标准块上均匀取6点构造平面且把Z归零
3. 将样品放在标准块上，在凸台面中心取一点即可算出其高度



Measurement Method

SPC I	FAI 12	0+/-0.1mm	OMM
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- 1.以上尺寸测试设备为投影仪.
- 2.在凸台面上取五点且将Z归零.
- 3在螺柱上取圆1，圆2.圆1设为原点且与圆2构造直线作轴.
- 4在每个螺柱上取3点，取每个螺柱上的最高值





THANK YOU
THERMAL SOLUTIONS FOR YOUR NEEDS