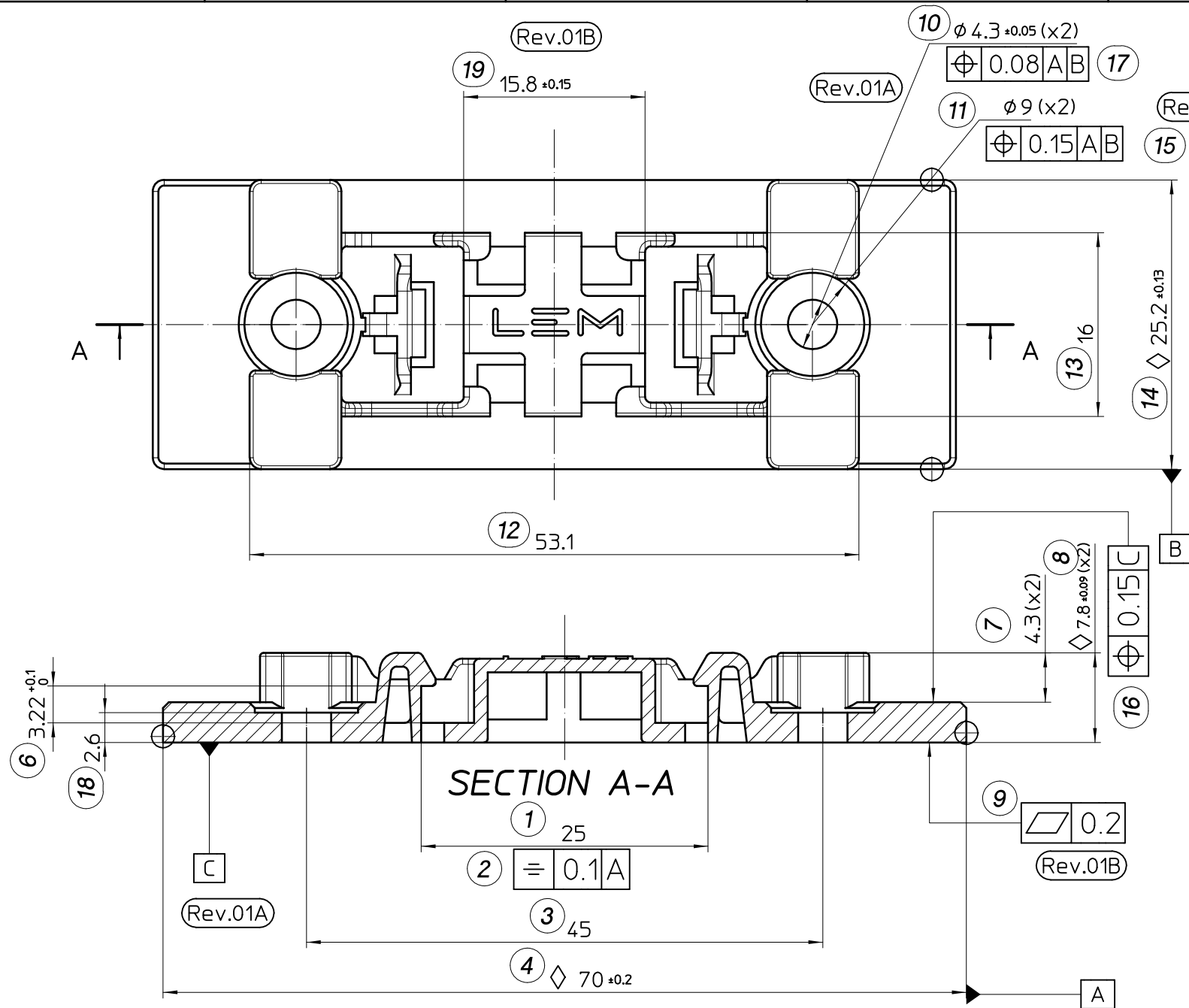




Date code marking

RM marking

LEM logo

Cavity marking

Revision marking

01B	11.23.2021	Update the tolerance	---	tyz
01A	05.06.2021	Modify the form of dimension	---	tyz
01	04.12.2021	Modify the structure	---	tyz
00	09.15.2020	New drawing	B19005A	tyz
Rev.	Date (MM.DD.YYYY)	Modification	CFU	Name

Nota 1: Denomination:

- Family: PA66/6
- Manufacturer : EMS
- Trade name: Grilon TS V0
- Colour : Black
- RoHS compliant

- Recommendation:

UL:

- Yellow card number requested: YES
- Coloured agent allowed: NO

Nota 2: Injection process

- No mould release agent or silicon agent (no grease or oil mark)
- Max regrind material percentage: 25 %

Nota 3: Dimension, tolerance

- Nominal constant plastic thickness on the part = 1.2mm
- All dimensions under moisture absorption condition
- For dimensions not specified refer to 3D file. (All dimensions are centered on the middle of the tolerance, and comply with the NF T-58000 reduced class).
- All the draft angle are designed on the 3D file
- Part Volume 4589.3 (mm3)
- General tolerance, displacement due to parts of the mold, shrink marks, burrs in accordance to NF T-58000
- The capability dimensions must be measured between (target) $\oplus \oplus$

Nota 4: Appearance

- Injection gate location must be approved by LEM design office.
- Ejectors location must be approved by LEM design office.
- Level of ejector marks must be in hollow mini 0.05mm maxi 0.3mm.
- Location of parting line must be approved by LEM design office.
- Burrs on parting line not allowed.
- General appearance: EDM (electro discharge machining) CH21 or Ra 1.12 μ m, unless otherwise specification.

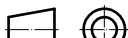
Nota 5: Traceability marking

- Marking raised, height max 0.3 mm in a hollow, unless otherwise specification. This marking must not exceed the face.
- Drawing revision on the part, location, refer to drawing (2 digits on a removable block) ex: drawing revision 00 = 00 on the part.
- Warning, the letter at the end of the drawing revision must not be marked on the part, ex: drawing revision 01A = 01 on the part.
- Cavity number, location, refer to the drawing, written with a number, directly marked on the mold (1 digit if cavity number between 2 and 9, 2 digits if more than 10 cavities)
- Date code (month, year),(on an ejector or a removable bloc), location, refer to the drawing.
- All the traceability marking locations can be moved, but must be defined in agreement with LEM design office.

Nota 6: Others marking

- For all marking (symbol, logo, text, etc..) refer to 3D file.
- The marking raised, refer to the 3D file.
- Material >PA66/6<, refer to 3D file.

Symbol	Definition	Qty
$\diamond$	SIGNIFICANT characteristics	3
$\text{m} \text{ } \text{S} \text{ } \text{R} \text{ } \text{n}$	SAFETY characteristics	m= 00
	REGULATION characteristics	n= 1

General tolerances Linear: See nota Angular: See nota			Folio: 1 / 1	LEM Electronics (China) Co., Ltd No.28,Linhe Str.,Linhe Industrial Development Zone Shunyi District 101300, Beijing China		LEM				
 SAFETY characteristics		 REGULATION characteristics		 SIGNIFICANT characteristics		Size A3	Scale 2:1	Writer	09.15.2020	tyz
All linear dimensions are in millimeter. All angles are in degree.						This document is the property of LEM International SA. No copy without prior written permission.		Checker	YHo	
SCREW PLATE <										