

2840-819

DWG. NO.

PRE PRODUCTION REVISIONS (PROJECT):
01) 11/27/12 MWM - FIRST DRAFT
02) 04/12/13 MWM - CHANGED MATERIAL
03) 05/17/13 MWM - RELEASE FOR TOOLING

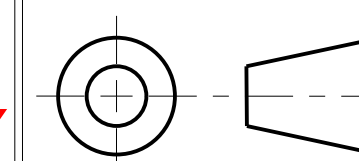
REV	ECO ECR	REVISION	APRVD. BY	DATE
APPROVAL SIGNATURES ON FILE				

NOTES:

1. MATERIAL:
 - THERMOPLASTIC ELASTOMER 70+/-10 SHORE A
 - COLOR: BLACK
 - MOLD SHRINKAGE: .XX%
2. FINISH: CAVITY: SPE/SPI #D-1
CORE: SPE/SPI #B-2
3. MAXIMUM PART FLASH .005
4. MAXIMUM PART MISMATCH .005
5. ELLIPTICAL BOXED DIMENSIONS REQUIRE DEMONSTRATED
PROCESS CAPABILITY (Cpk/Ppk) ≥ 1.33 WITH ACCEPTABLE
GAGE R & R.
 - 1st ARTICLE INSPECTION: MEASURE ALL DIMENSIONS (1 pc)
6. PART VOLUME = 0.285 in 3
7. PART WEIGHT = 4.9 GR (or 0.011 LB)
8. PART TO BE FREE OF DIRT, GREASE, OIL OR
ANY FOREIGN MATERIAL
9. CHECK CRITICAL DIMENSIONS FROM EACH
CAVITY AT THE BEGINNING OF EACH PRODUCTION
RUN AND AT THE START OF EACH SHIFT.
10. EACH MATERIAL LOT TO BE NOTCHED IZOD TESTED
PER ASTM D256, ISO 180. OR CERTIFICATE OF
COMPLIANCE ON FILE FROM SUPPLIER.
11. NO CONTAMINATION PARTICLES, FLOW LINES, OR
BURN MARKS ALLOWED ON "A" SURFACES. 3 PER
INCH PERMITTED ON "B" SURFACES. CHECK EACH
CAVITY AT THE BEGINNING OF EACH PRODUCTION
RUN AND AT THE START OF EACH SHIFT.
12. PART MUST MATCH GOJO APPROVED COLOR CHIP.
CHECK EACH CAVITY AT THE BEGINNING OF EACH
PRODUCTION RUN AND AT THE START OF EACH SHIFT.
13. SHIPPING REQUIREMENTS:
CAREFULLY PACKED TO AVOID DAMAGE IN QUANTITIES, IN
UNIFORM SIZED SHIPPING CONTAINERS ON UNIFORM SIZED
PALLET (48"LENGTH X 40"WIDTH X 66" TALL) CARTONS
TO BE MARKED CLEARLY IN 1" HIGH MINIMUM LETTERS.
WITH QUANTITY, GOJO PART, LOT, AND P.O. NUMBER.

INTERPRET DRAWING PER
ASME Y14.100
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

THIRD ANGLE PROJECTION



TITLE:
STATE:

ANTENNA SHEATH

Developmental

TOLERANCES:

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DRAWN BY: M. MOORE

SCALE 2:1

SHEET

DATE: 11/27/12

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REV.

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DATE: 11/27/12

11/27/12

**PRELIMINARY
DESIGN ENG:
REFERENCE ONLY**