



—This tool is exactly the same as 3139-224-3964-010 except for the difference on the engraving for the FCC ID: RCSR02843003.

All dimension please
please refer to
3139-224-3964-010.prt

IDENTIFICATION OF THE PRODUCTS

- Each cavity must have an identification mark (Y).
- Identification mark figures recessed/ protrude, max height 0.2mm.
- The product number (12NC) must be indicated.
- The last figure of the product number(X) may be indicated with dots.
- Recycling Logo and type of material must be indicated

MOLDING AND COSMETIC REQUIREMENTS

- Parts free from mold release agents on all surfaces.
- Visual imperfections according to sample in approved Philips sample card.
- Parting lines must be free from burrs.
- Warpage: Maximum 0.2mm/100mm

GENERAL TOLERANCE

- For complex surfaces and undimensioned features, please refer to 3D CAD data: 3139-224-3964-010. general tolerance applies.
- Draft within tolerance
- If otherwise not indicated in the drawing:
 - ± 0.05 mm for 0 to 20 mm.
 - ± 0.10 mm for 20 to 50 mm.
 - ± 0.15 mm for 50 to 100 mm.
 - $\pm 0.2\%$ for 100 mm and above.
 - $\pm 0.5^\circ$ for angles
- All keyholes size tolerance should follow $+0.1/-0$
- All ribs tolerance should follow $0/-0.1$ unless otherwise stated
- All keyholes locations tolerance should follow ± 0.05

FINISHING AND OUTLOOK REQUIREMENTS:

- Finishing of visible surfaces: High Gloss Polished / Textured ACC. TO XXXX
- Finishing must be equal for all mating parts.
- Visible areas must be free from injection points, sink marks, flow lines, ejector marks, burrs, damages and other defects.
- Unless otherwise stated in the drawing:
 - a. Maximum radius for sharp drawn edges: 0.2mm.
 - b. Finishing non-visual areas acc to 2-UN-D249.
- Gating points should be trimmed properly to prevent assembly issues
- All ejector pins must be 0.2 mm below rib surfaces.
- Ejector pins should be at least 1 mm away from all key holes.

INSPECTION (QDS) DIMENSIONS

- QDS dimensions marked in oval boxes must be inspected.
- QDS dimension in drawing should not change.
- Matching between parts is the primary check point at which the QDS tolerance may be redefined.
- Always refer to the approved sample cards for final QDS tolerance.

MATCHING STATEMENT:

- XXXX 3139 224 XXXX has to match with:
 - XXXX 3139 224 XXXX
 - XXXX 3139 224 XXXX
 - XXXX 3139 224 XXXX
 - XXXX 3139 224 XXXX
- Max. mismatch at visible areas $\pm 0.05\text{mm}$

ENVIRONMENTAL REQUIREMENT: NO BANNED
SUBSTANCES ACC. TO UAT-0480/100

CN: -----			Set Name: RC2843002/01								
			UN-D 1041			TOLERANCES UNLESS OTHERWISE STATED					
						DIMENSIONS			ANGLE		
						±0.2			±0.5		
						ITEM			ASSEMBLY NO.		
									QUANT		
GENERAL ROUGHNESS		UNIT	MATERIAL						PATTERN NO.		
0.8		mm							ORDER NO.		
SCALE		PROJ FIRST ANGLE	TREATMENT								
1:1											
CLASS NO.			Top Part RC2843002						3139 224 4174		
2XX000											
.....											
.....											
2012-03-22											
NAME Vincent Neo			SUPERS xxxx xxx xxxx			1			10		
						110 - 1			A3		
CHECK			DATE 2012-03-21			KONINKLIJKE PHILIPS ELECTRONICS N.V.			vvvv		