

REVISIONS					
REV	ECN NO	DESCRIPTION	BY	DATE	
	1	35580	RELEASE FOR QUOTE	DES	1/30/14
	2	35738	RELEASE FOR TOOLING	DES	4/10/14
	3	35763	FIX UNINTENDED UNDERCUT NEAR BATTERY HOLDER, 3-D MODEL CHANGE ONLY.	DES	4/15/14
	4	35794	ADD INSERT AREA FOR FUTURE MARKINGS	DES	4/30/14
	5	35877	ADD AGENCY MARKINGS TO INSERTED AREA	DES	6/12/14

D

C

B

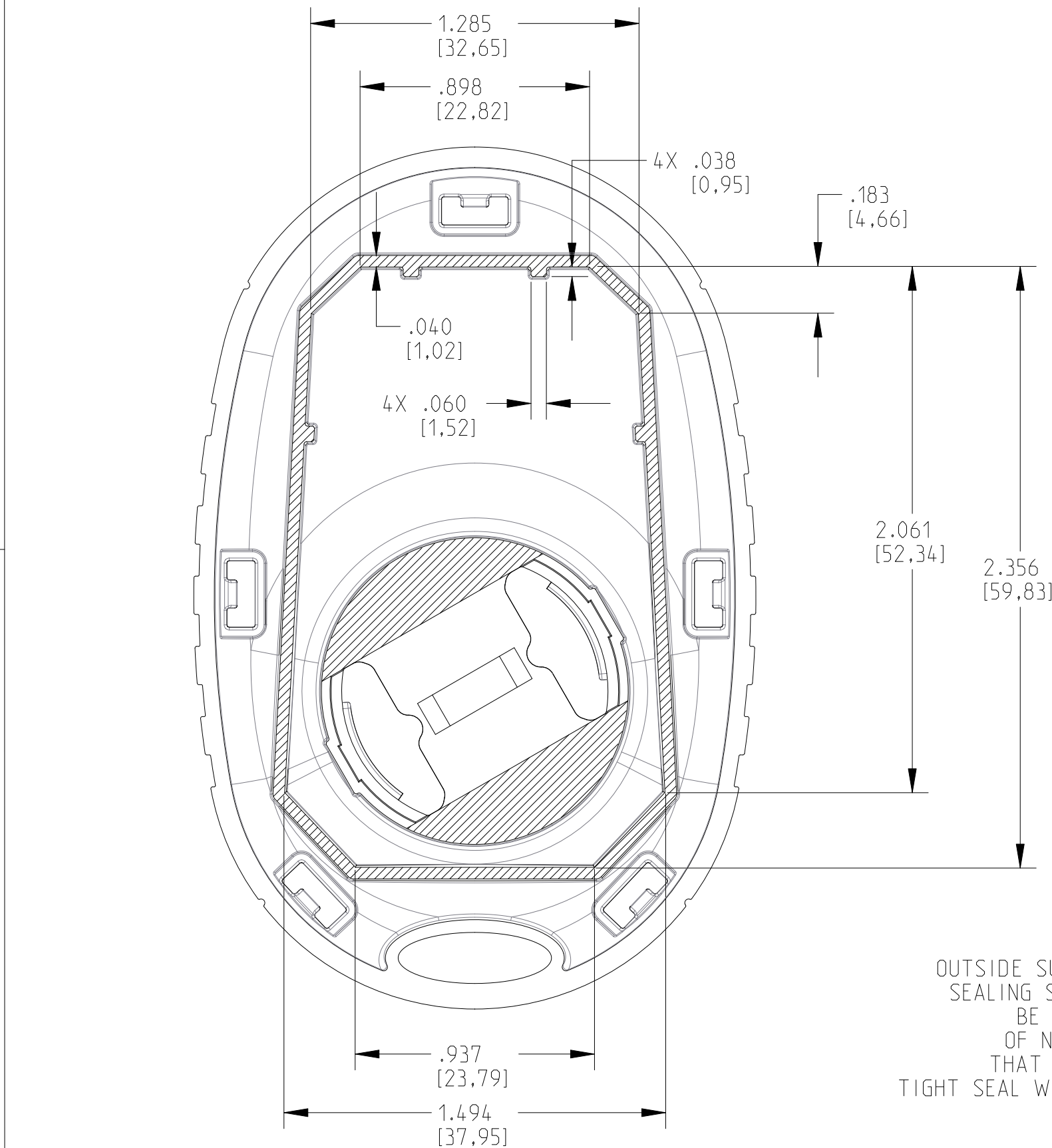
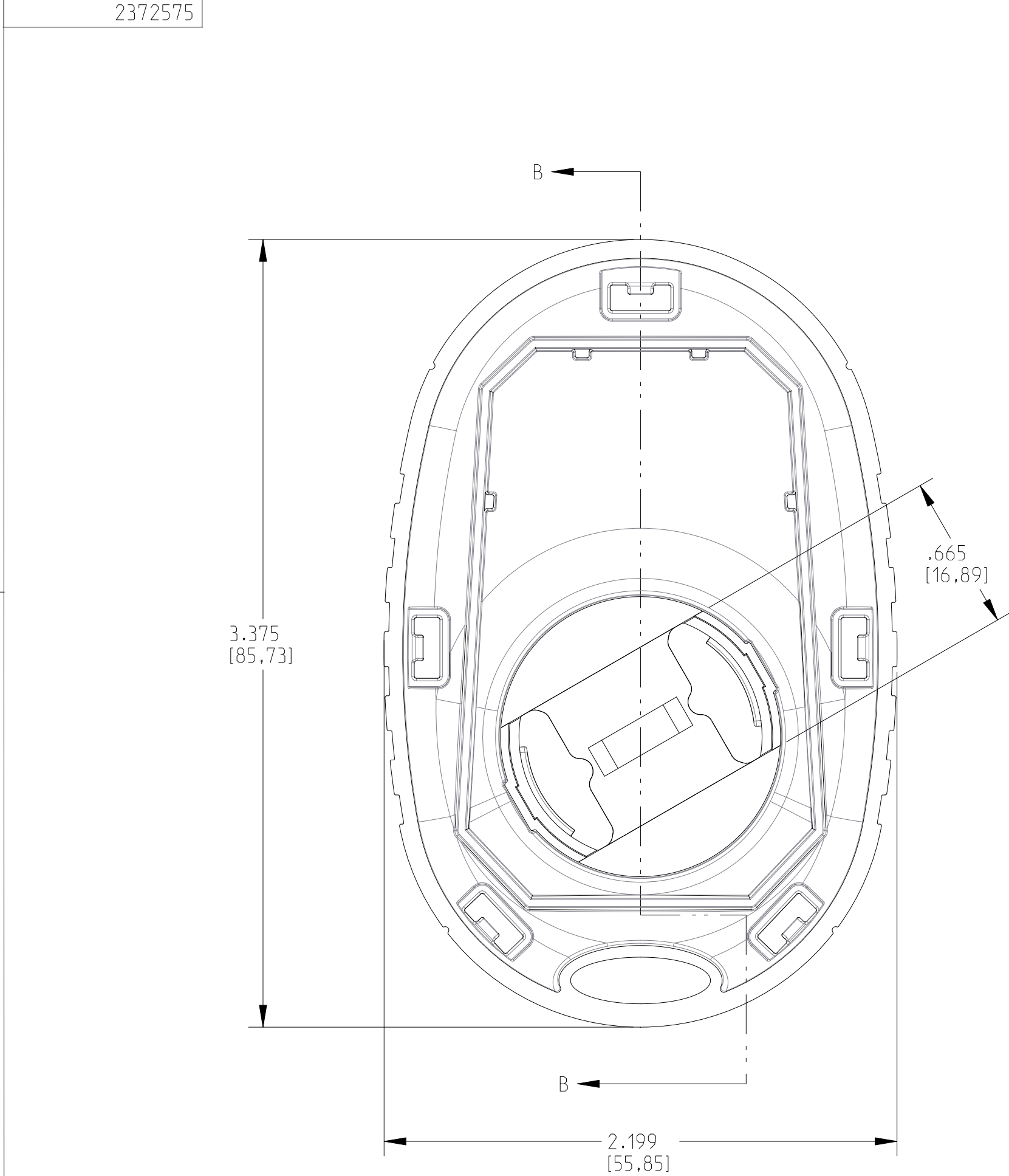
A

D

C

B

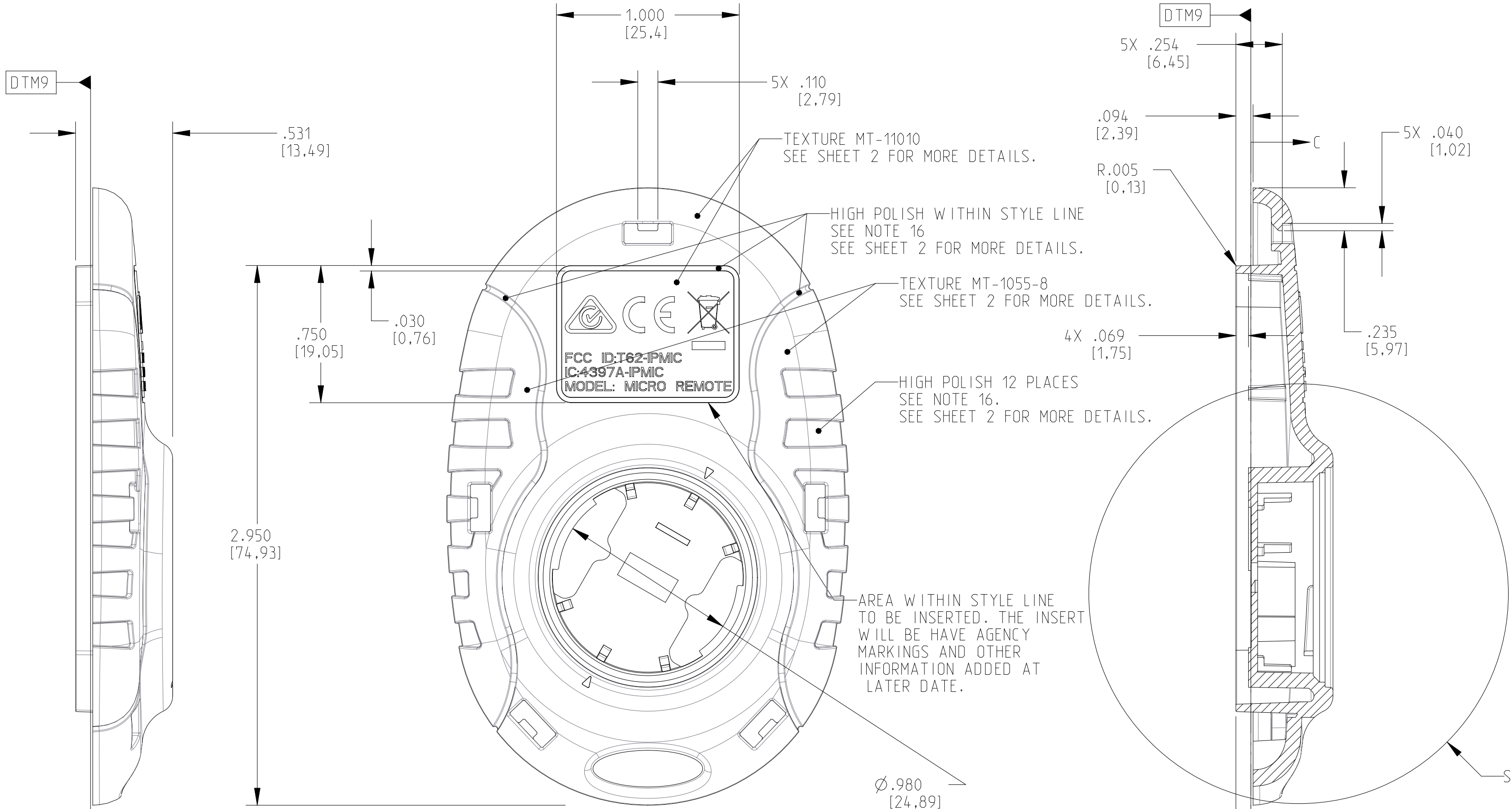
A



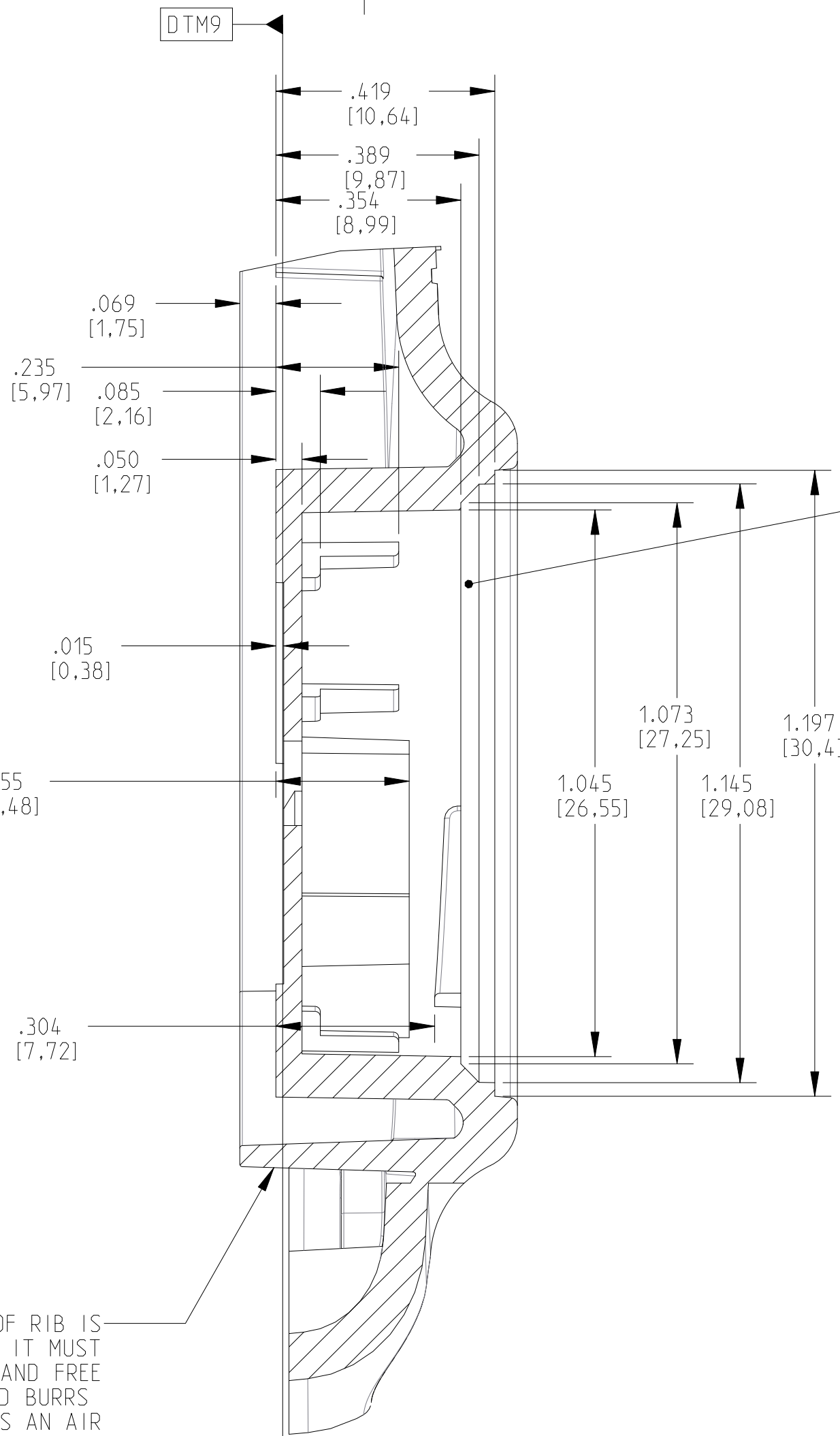
SECTION C-C

OUTSIDE SURFACE OF RIB IS SEALING SURFACE. IT MUST BE SMOOTH AND FREE OF NICKS AND BURRS THAT PREVENTS AN AIR TIGHT SEAL WITH THE MATING PART 2375133.

DETAIL A
SCALE 4.000



SECTION B-B



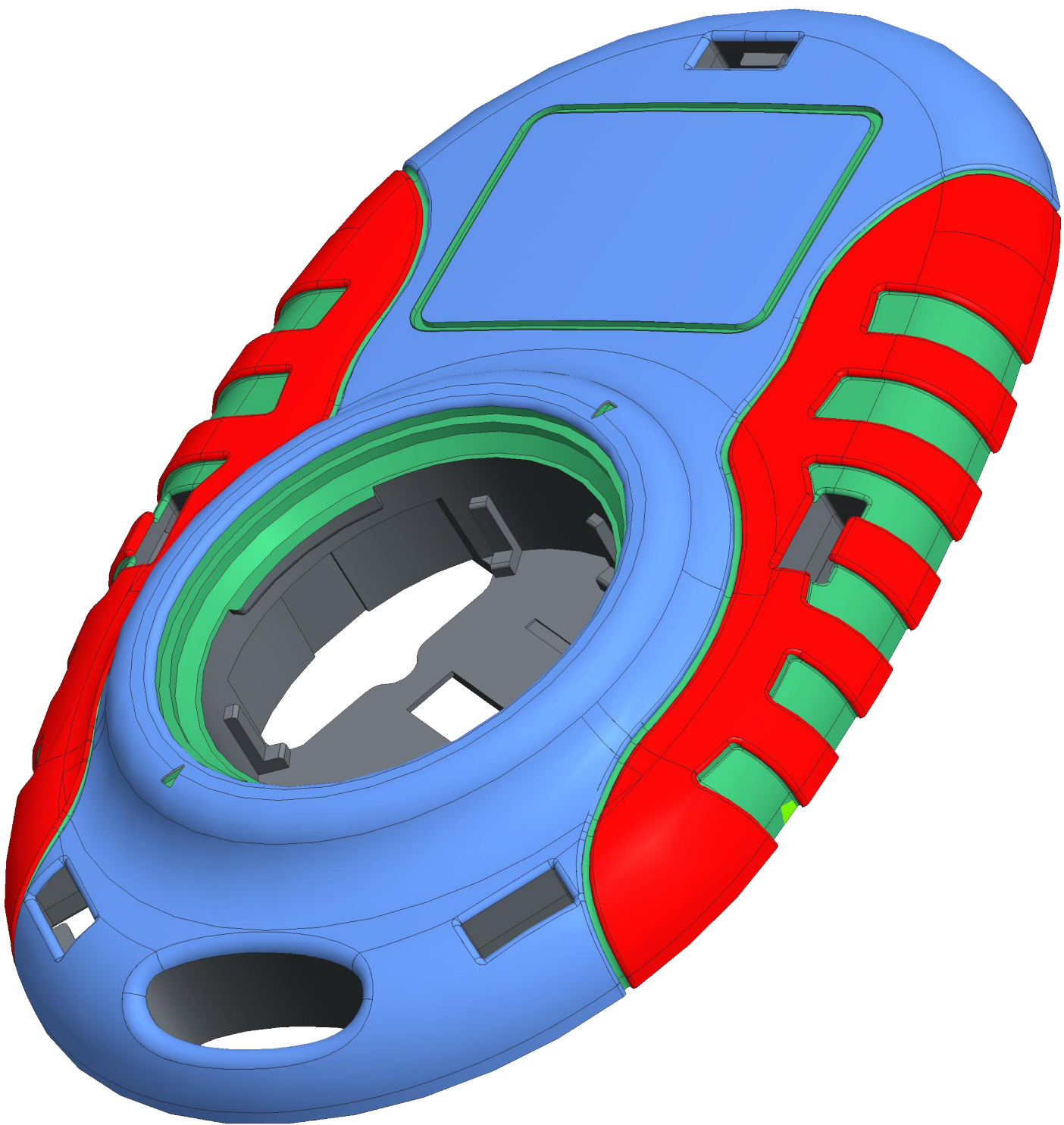
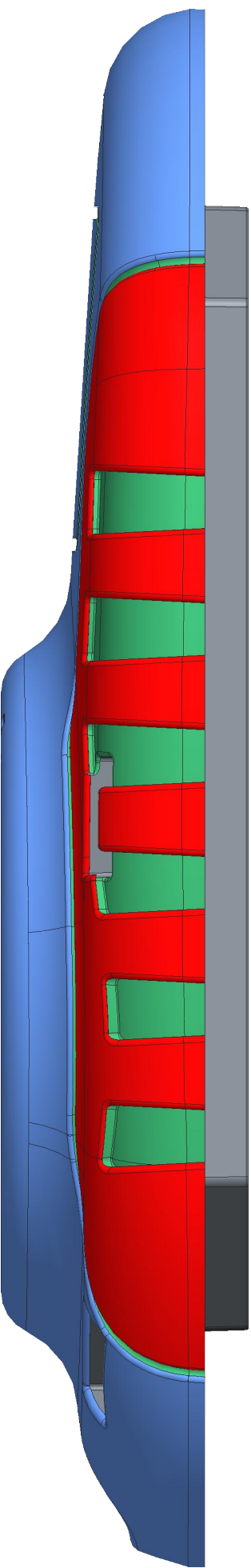
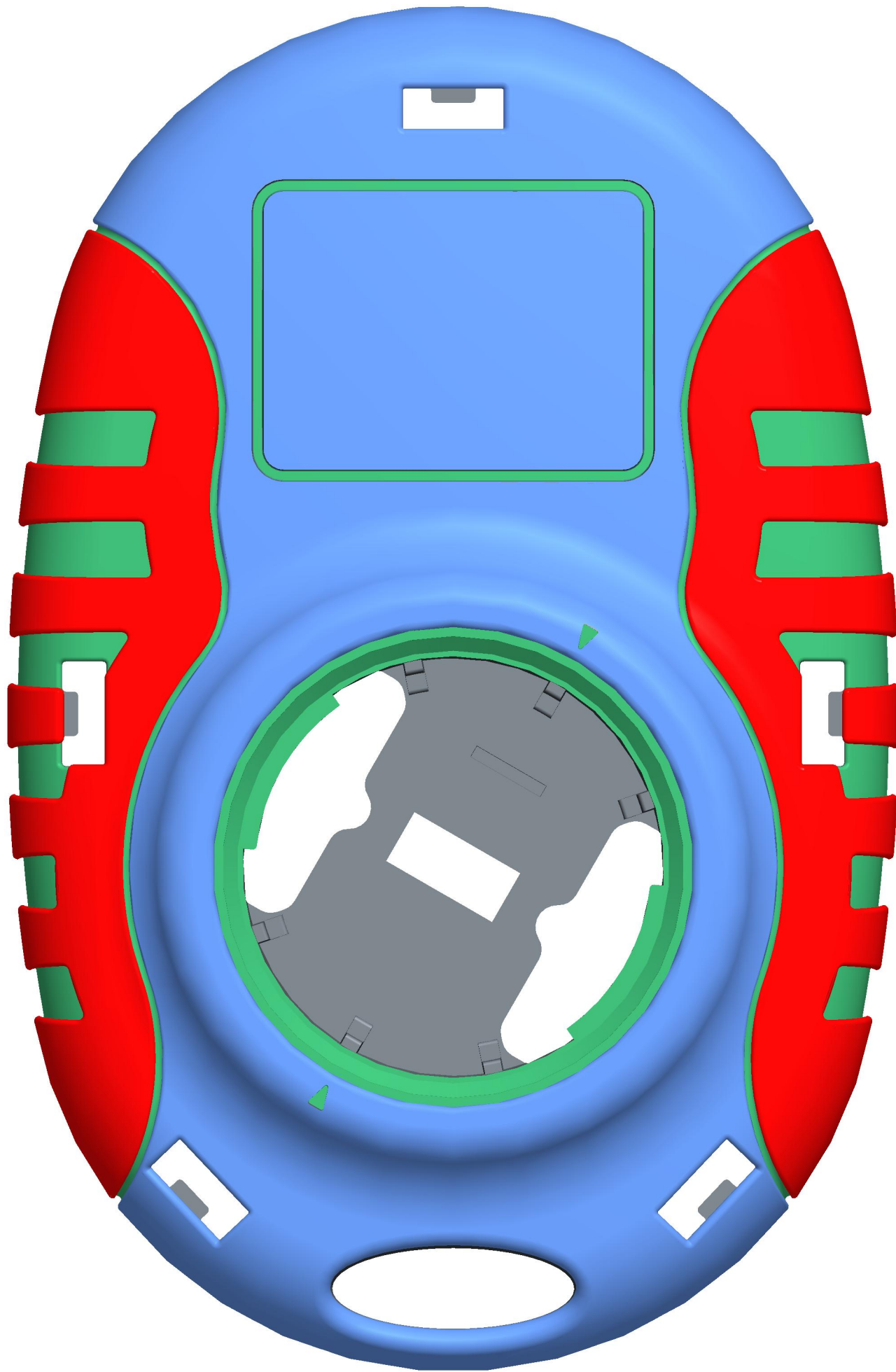
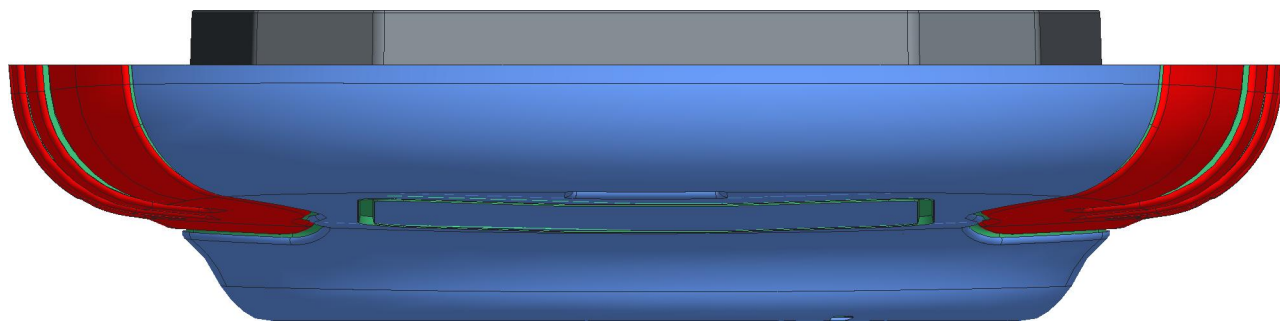
SCALE 1.000

SCALE 1.000

- NOTES:
- MATERIAL:
SABIC LEXAN 143R-701, COLOR:BLACK
MATERIAL REGRIND: NOT ALLOWED
VOLUME: 0.7049 IN³
 - COSMETIC SURFACE QUALITY:
UNLESS OTHERWISE SPECIFIED ALL EXTERIOR SURFACES, TO BE PER SPI "COSMETIC SPECIFICATION OF INJECTION MOLDED PARTS" GRADE 1, SURFACE A
 - MATERIAL PROCESSING:
ALL MATERIALS MUST BE PROCESSED WITHIN THE MATERIAL MANUFACTURER'S SPECIFIED PROCESSING PROPERTIES UNLESS OTHERWISE AUTHORIZED BY JOI ENGINEERING.
 - TEXTURING:
ALL EXTERIOR SURFACES TO BE TEXTURED AS NOTED
ALL INTERIOR OR CORE FEATURES TO BE FINISHED FOR SMOOTH AND REPEATABLE PART EJECTION FROM TOOL
ALL TEXTURING TO BE APPLIED AFTER SAMPLES HAVE BEEN SUBMITTED TO JOI AND UPON JOI APPROVAL OF ALL DIMENSIONS
 - FILLETS AND RADII: PER 3-D DATABASE, R.005 MINIMUM UNLESS OTHERWISE SPECIFIED.
 - FLASH AND BURRS TO BE .005 MAXIMUM UNLESS OTHERWISE SPECIFIED.
 - GATES, PARTING LINES, WELD LINES AND EJECTOR PIN LOCATIONS TO BE APPROVED BY JOI ENGINEERING PRIOR TO TOOL CREATION. EJECTOR PIN MARKS TO BE FLUSH WITH PART SURFACE +.005/- .010.
 - PART TO BE TOOLED PER 3-D DATABASE PROVIDED BY JOI ENGINEERING. DIMENSIONS SHOWN ON DRAWING MUST BE MEASURED ON THE FIRST ARTICLE INSPECTION REPORT. FOR ALL OTHER NON-DIMENSIONED FEATURES USE 3-D DATABASE.
 - DRAFT ANGLES AND DIRECTION DETERMINED BY 3-D DATABASE. DURING MOLD DESIGN BY TOOLMAKER/SUPPLIER DRAFT & PART GEOMETRY MUST BE REVIEWED. IF DRAFT IS REQUIRED, PREFERRED, OR IN NEED OF MODIFICATION IT IS THE RESPONSIBILITY OF THE TOOLMAKER/SUPPLIER TO NOTIFY JOI ENGINEERING FOR REVIEW AND POSSIBLE UPDATE OF PART GEOMETRY.
 - FOR DIMENSIONS SHOWN TO CORNERS WITH RADII ASSUME DIMENSION APPLIES TO THEORETICAL SHARP CORNER (INCLUDING DRAFT IF APPLICABLE) UNLESS OTHERWISE SPECIFIED.
 - JOI ENGINEERING MUST REVIEW AND APPROVE ALL PRINTS AND DATABASES ASSOCIATED PRIOR TO TOOLING, RELOCATING, OR RETOOLING OF THIS PART.
 - CAVITY # REQUIRED FOR MULTIPLE CAVITIES. NOMENCLATURE TO BE RAISED OR RECESSED .015 MAX ABOVE OR BELOW SURFACE. CHARACTER HEIGHT TO BE .05 MINIMUM/.100 MAXIMUM.
 - STEEL SAFE DIMENSIONS ON PART FEATURES ARE TO BE MADE OUT OF TOLERANCE BY X.XX" ON INITIAL PART SAMPLING. THESE FEATURES WILL THEN BE READJUSTED TO WITHIN NOMINAL PRINT. DIMENSIONS AFTER INITIAL SAMPLES ARE INSPECTED.
 - PART TO BE FREE OF OILS, LUBRICANTS, MOLD RELEASE, AND ANY FOREIGN DEBRIS AND PACKAGED TO PREVENT DAMAGE DURING SHIPMENT.
 - PART MUST MATE AND FIT WITH PART NUMBER 2372570.
 - HIGH POLISH SURFACE TO MEET SPI "COSMETIC SPECIFICATION OF INJECTION MOLDED PARTS" GRADE 1, SURFACE A.

TOLERANCES: UNLESS OTHERWISE SPECIFIED XXXX ±.0010 XXX ±.005 XX ±.010		CONFIDENTIAL PROPERTY- This document is the confidential property of Johnson Outdoors and is loaned subject to return upon demand. Title to same is never sold/transferred for any reason. This document is to be used only pursuant to written instructions of Johnson Outdoors. All rights to designs and inventions are reserved by Johnson Outdoors. Possession of this document is accepted subject to the foregoing.		QUALITY REQUIREMENTS: Supplier certifies that this part complies with 2011/65/EU (RoHS2) and (EC) No 1907/2006 (EU REACH). Upon request, supplier will furnish verification of compliance via JOI form, supplier declaration or analytical testing referencing JOI part number.		LIFE CYCLE STATUS: Concept	
DRAWN BY: DES		DATE: 1/30/14		SCALE: 2.0:1		PART NO: 2372575	
MATERIAL: UHMWPE		LIFE CYCLE STATUS: Concept		U/M: IN.		SHEET 1 OF 2	
REV: 5		D SIZE: 1		REV: 5		REV: 5	

REVISIONS			
REV/ECN NO	DESCRIPTION	BY	DATE
	SEE SHEET 1 FOR DETAILS		



TEXTURE DETAILS:

1. RED COLORED AREAS TO BE TEXTURED TO MT-1055-8
2. GREEN COLORED AREAS TO BE HIGH POLISH SURFACE TO MEET SPI "COSMETIC SPECIFICATION OF INJECTION MOLDED PARTS" GRADE 1, SURFACE A.
3. BLUE COLORED AREAS TO BE TEXTURED TO MT-11010