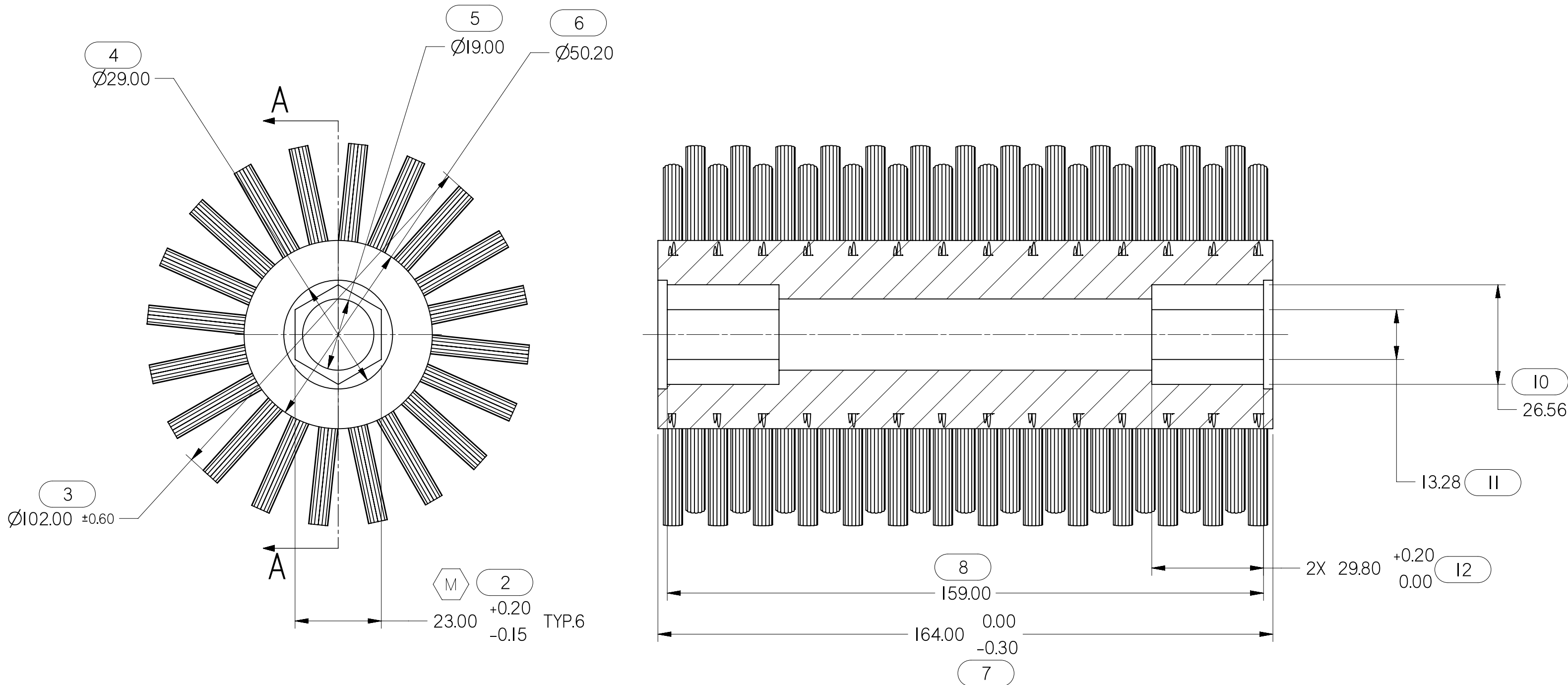


TOLERANCE FOR PLASTIC	
ISJ1372-1978MODIFIED	
DIMENSION RANGE	TOLERANCE (CLASS S)
0-10	±0.10
10-30	±0.15
30-50	±0.20
50-75	±0.25
75-100	±0.30
100-125	±0.35
125-150	±0.40
150-175	±0.45
175-200	±0.50
200-250	±0.60
250-315	±0.70
315-355	±0.80
355-400	±0.90
400-450	±1.00
450-500	±1.10

REV	CHANGE DESCRIPTION	ZONE	ECN #	DATE	APV BY
01	DESIGN RELEASE		ECN-HFE010323	KNIGHT 11/26/2018	BRIAN 11/28/2018
02	DIM #2 23.00 +0.20/-0.15 WAS 23.00 +0.20/-0.00	G5	ECN-HFE010433	KNIGHT 12/04/2018	BRIAN 12/05/2018



NOTES: 1

1. MATERIAL: PA6-30%GF KINGFA G30 N-104, BRUSH:DIAMETER 1.0MM PA COLOR: BLACK, BRUSH COLOR: BLACK
PART NEEDS TO COMPLY WITH HSF REQUIREMENTS AND HS RISK ASSESSMENT INSTRUCTION REFER TO DOCUMENT 01QSA0014.
2. GATES, PARTING LINES, EJECTOR PIN, AND EJECTOR PIN BOSS LOCATIONS TO BE AGREED UPON BY COMPANY'S ENGINEERING GROUP PRIOR TO DIE CONSTRUCTION
3. DEPT OF EACH BRUSH HOLE:8MM,PULL OUT FORCE OF EACH GROUP BRUSH:50N
BRISTLE DIAMETER 1.0 WITH 20 BRISTLES PER GROUP,
4. FOR ALL UNDEFINED GEOMETRY, REFER TO 3-D
5. UNLESS OTHERWISE SPECIFIED:
A) DRAFT ANGLES TO BE 0.5° TO 1.5°
B) EJECTOR PIN MARKS TO BE FLUSH TO 0.25 RECESSED WITH 0.13 MAX FLASH
C) SHARP CORNERS AND FILLETS TO BE BROKEN WITH A 0.38 TO 0.89 RADIUS
D) ANGLE TOLERANCE TO BE ±1°
E) GATE FLASH SHALL NOT PROTRUDE MORE THAN 0.75 FROM PART SURFACE
F) ALL SURFACES TO BE FREE OF SWIRLS, SINK MARKS, COLD FLOW AND KNIT LINES
G) USE TOLERANCES BLOCK ABOVE FOR LINEAR DIMENSION TOLERANCES

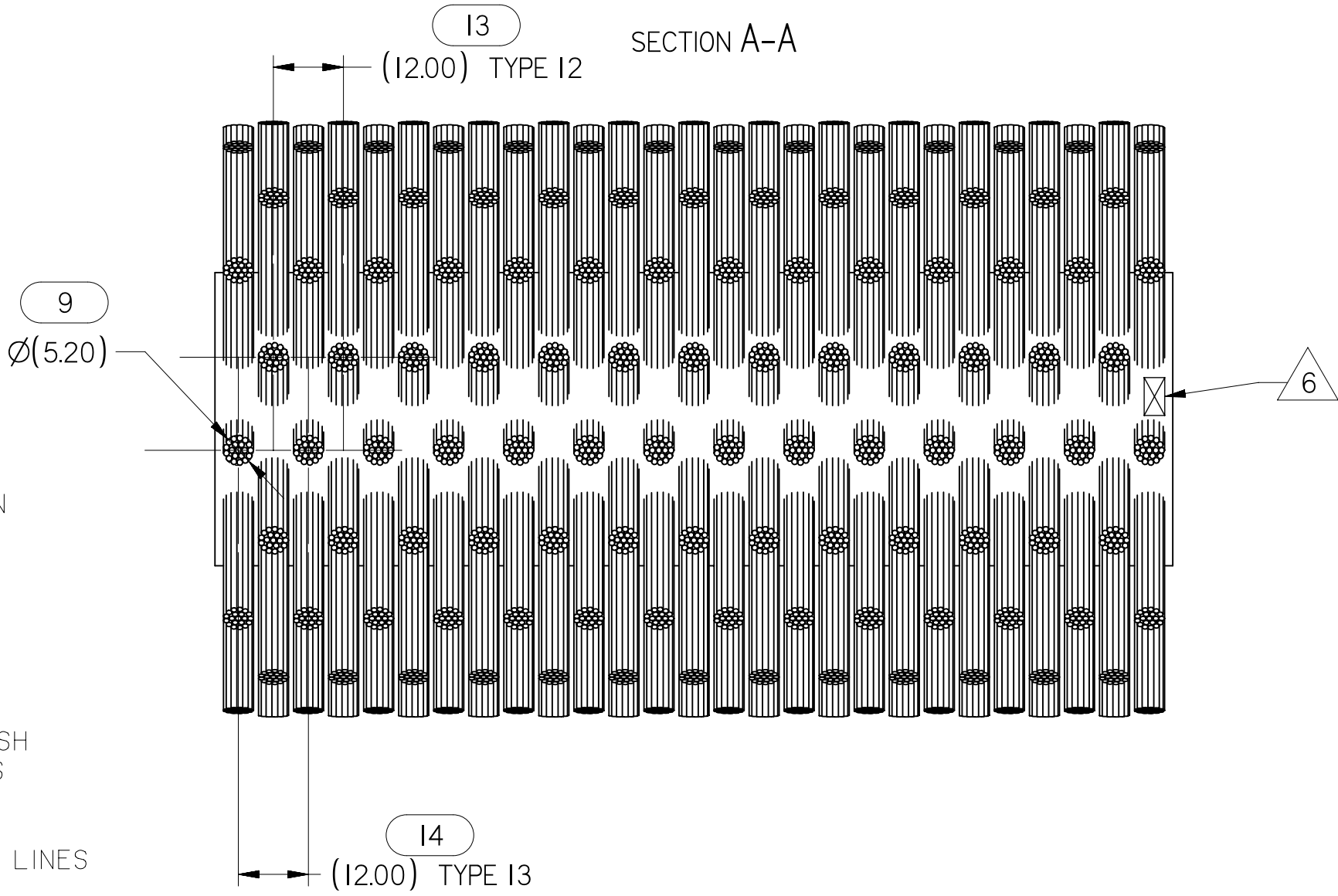
CAVITY NUMBER, PART NUMBER, RAW MATERIAL NUMBER AND DATE STAMP TO BE IN .15-.38
RAISED CHARACTERS AND PLACED IN LOCATION SHOWN

7. SEE QUALITY ASSURANCE FOR ADDRESSING CRITICAL AND MAJOR DIMENSIONS

TOTAL THIS PAGE = 0

TOTAL THIS PAGE = 3

TOTAL INSPECTION = 14



 CONFIDENTIAL: THIS DRAWING IN DESIGN AND DETAIL IS THE PROPERTY OF TECHTRONIC INDUSTRIES COMPANY LIMITED. ALL RIGHTS OF DESIGN OR INVENTION ARE RESERVED.	Techtronic Industries Co. Ltd.		METRIC UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS		3RD ANGLE PROJECTION	
	DIMENSION & TOLERANCE PER ASME Y14.5 - 2009	UNSPECIFIED DIMENSIONS REFERENCE CAD MODEL	CN GRA PIN 314190001		PART NAME PLASTIC,ROLLER BRUSH1090419001	
	WEIGHT	WEIGHT & TOLERANCE	DRAWN BY		MODEL NO.	
	COLOR	COLOR NAME, COLOR CHIP #	BU		CAD TOOL NX	SCALE 1:1
		SHEET 1 OF 1	SIZE A1		PLM ID CL00034802	REV 02