

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

Symbol	Definition	Qty
◇	SIGNIFICANT characteristics	3
Ⓜ Ⓢ Ⓡ	SAFETY characteristics	m= 00
Ⓡ	REGULATION characteristics	n= 1

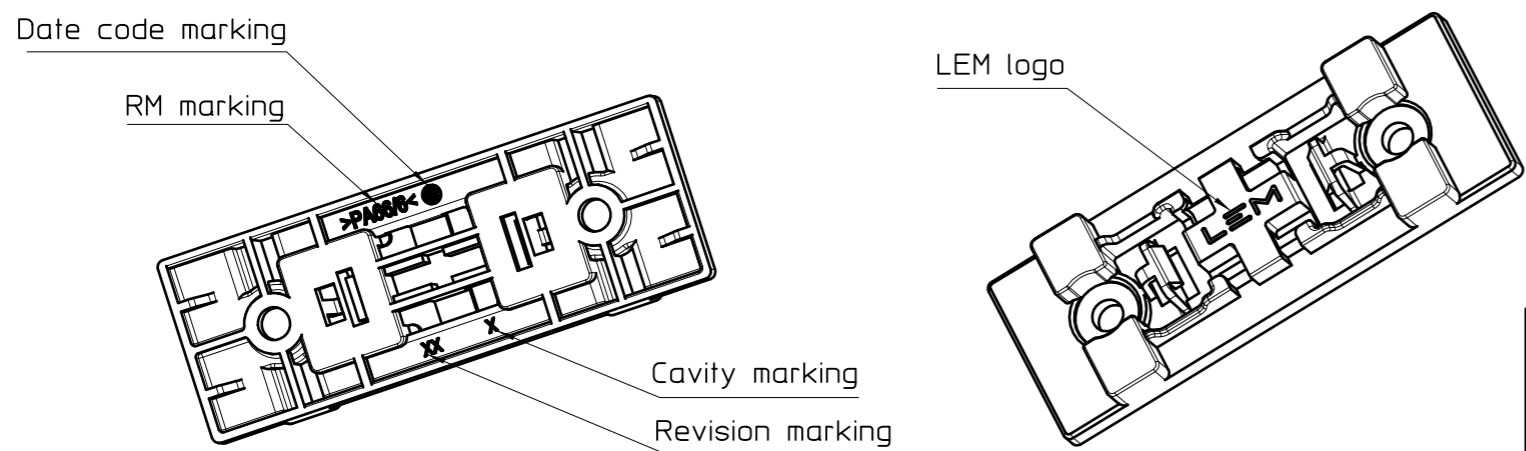
Nota 2: Injection process  
 - No mould release agent or silicon agent (no grease or oil mark)  
 - Max regrind material percentage: 25 %

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) ⊕ ⊕

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 um, 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.



Rev.	Date (MM.DD.YYYY)	Modification	CFU	Name
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

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	<b>LEM</b>		
Ⓜ Ⓢ Ⓡ 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.		
<b>SCREW PLATE</b>  <b>HTRS</b>					
			Drawing reference		Revision
			<b>50.34.02.550.0</b>		<b>01B</b>