

VIEW Z-Z  
SCALE 12:000

MATERIAL : ANSI / SAE 4630, MIM 4630 OR EQUIVALENT  
HARDNESS : 83-86 HR 15N  
SUPPLY CONDITION : Mn PHOSPHATE

NOTE:-  
1) ALL DIMENSIONS ARE IN mm  
2) GENERAL TOLERANCES ARE  
WHOLE NUMBER = ±0.76 mm  
ONE DECIMAL = ±0.25 mm  
TWO DECIMAL = ±0.13mm  
ANGULAR DIMENSIONS = ±1°

SECTION S-S  
SCALE 20:000

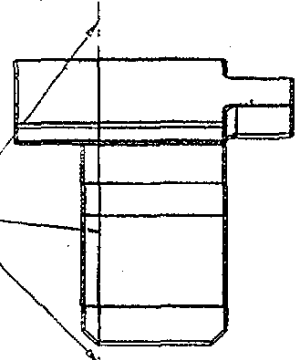
SEAR

(THROUGH MILL ROUTE)

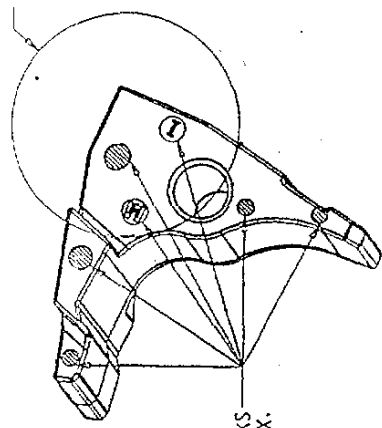
DRG. REF. NO. - D.S.CAT 1005-003172

DRG. NO. - RFI.SK 10125

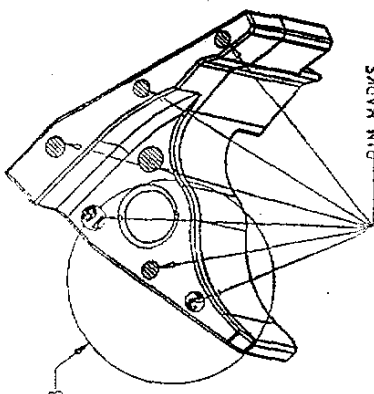
PARTING SURFACE



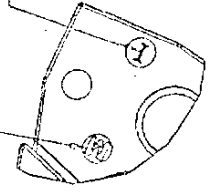
EJECTOR PIN MARKS  
DEPRESSION 0.1 MAX.



PIN MARKS  
DEPRESSION 0.1 MAX.

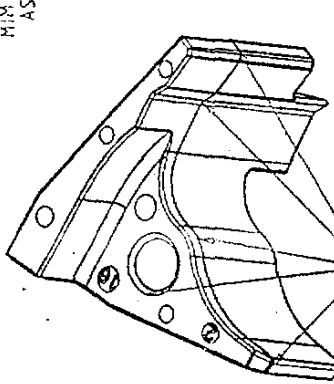


MIM. PROCESS ID MARK  
AS "M" DEPRESSION  
0.2 MAX.

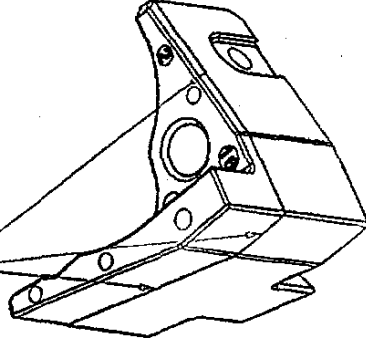


MANUFACTURING ID MARK  
AS "1" DEPRESSION  
0.2 MAX.

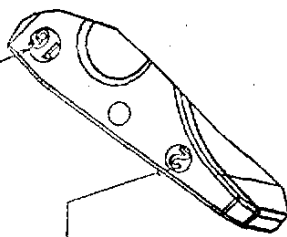
DETAIL A  
SCALE 7.000



PARTING AND INSERT LINE  
MARKS MISMATCH 0.05 MAX.  
(WILL BE WITHIN THE  
TOLERANCE SPECIFICATION)



YEAR ID MARK AS "15"(2015)  
DEPRESSION 0.2 MAX.

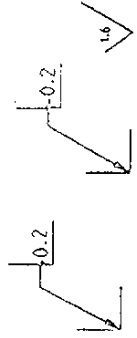
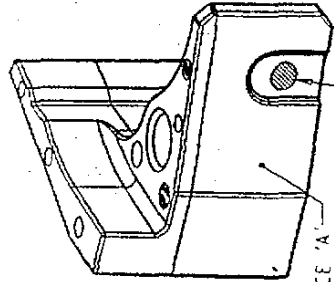


CAVITY ID MARK AS "#1.2..."  
DEPRESSION 0.2 MAX.  
(APPLICABLE FOR MULTI CAVITY)

DETAIL B  
SCALE 8.000

SURFACE 'A'

GATE MARK DEPRESSION  
0.2 MAX./PROTRUSION NOT  
ABOVE THE SURFACE 'A'



NOTES:-  
VOLUME OF THE PART = 0.56 CC  
MINIMUM WALL THICKNESS = 1.09 mm

SEAR  
(THROUGH MIM ROUTE)

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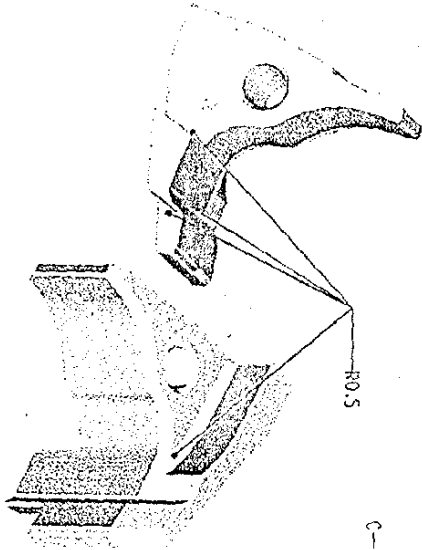
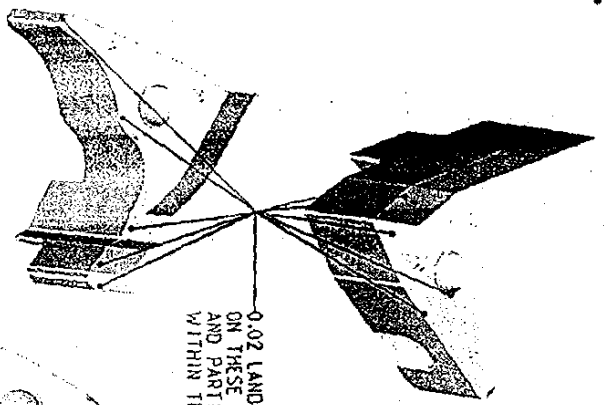
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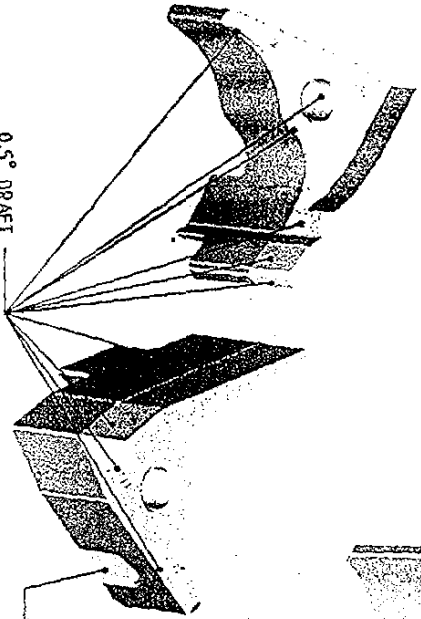
1 2 3 4 5 6

SLIT FOR GATE

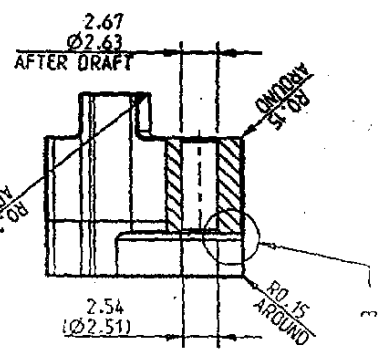
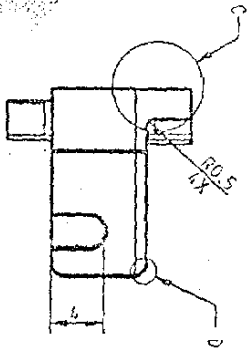
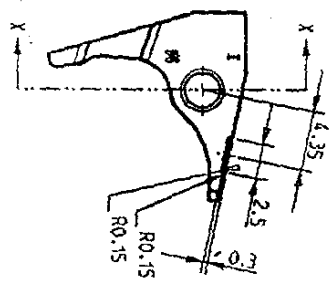
0.02 LAND AND OFFSET REQUIRED ON THESE SURFACE TO AVOID INSERT AND PARTING LINE MISMATCH (WILL BE WITHIN THE TOLERANCE SPECIFICATION)



0.5° DRAFT TO EASY MOLD RELEASE

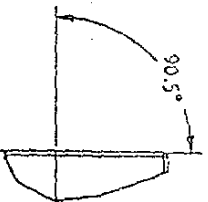


SLOT FOR GATE

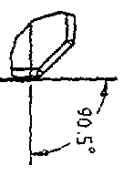


SECTION X-X

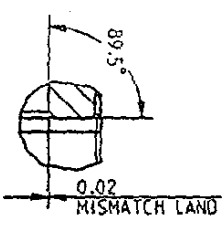
DETAIL C  
SCALE 8.000  
0.02 MISMATCH LAND  
90.5°



DETAIL D  
SCALE 15.000  
0.02 MISMATCH LAND  
90.5°



DETAIL E  
SCALE 8.000  
0.02 MISMATCH LAND  
89.5°



SEAR

(THROUGH MIN ROUTE)

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