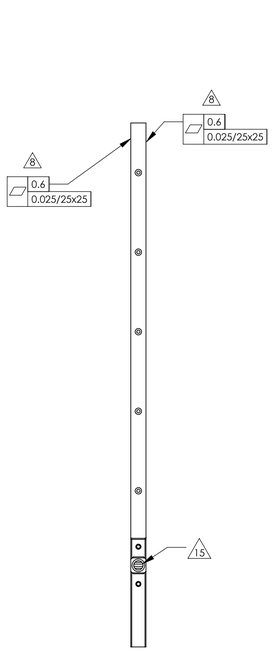
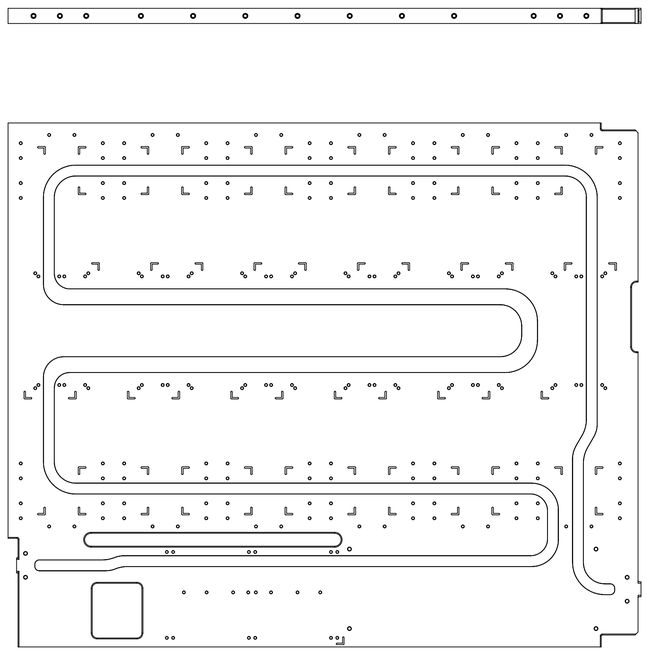
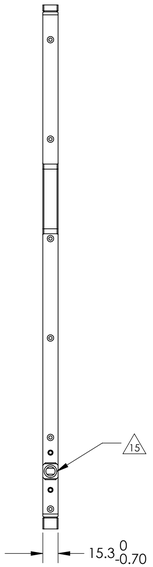
REVISIONS		
REV.	DESCRIPTION	CHANGE NO.
04	修改四周槽形特征，增加M4牙孔	

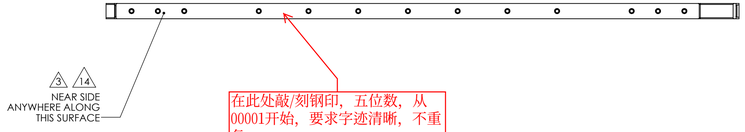




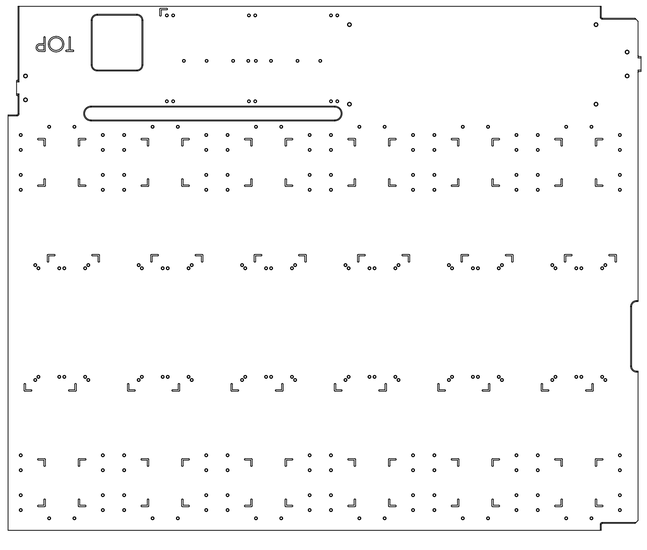


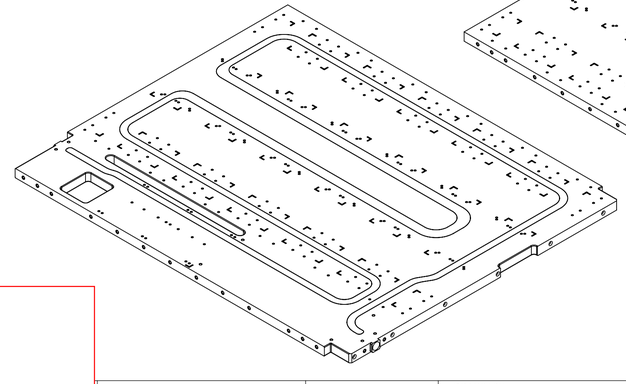
注意事项：

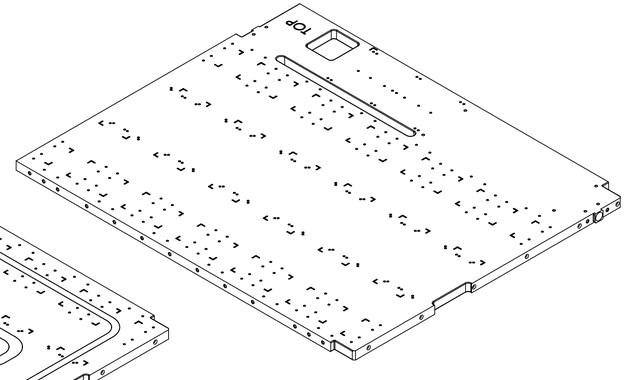
1、如果没有特别指定，请参用下面公差表：
+/-0.12 适用于所有的孔和半径尺寸。
+/-0.12 适用于所有的孔中心线之间的距离尺寸。
+/-0.25 适用于所有的孔中心线到边线的尺寸。
+/-0.50 适用于所有的边线到边线的尺寸。
+/- 2 ° 适用于所有角度的公差。
+/-0.60 适用于所有的凹槽，孔的深度尺寸。
+/-0.25 如果没有特别指定，适用于所有的沉头倒角标注。
2、按要求全检，特别留意所有牙孔均要求通规通，止规在2.5圈内止住；
3、所有牙孔用挤牙的方式加工；
4、所有组件均需满足最新的ROHS标准；
5、组件1与组件2用摩擦焊焊接；
6、除非特别要求，正反两面的表面粗糙度不能超过Ra1.6um;
7、泄露测试：将产品放在水中，高压150psig，测试5min，要求无连续的气泡；
8、表面处理：铜洗钝化 需要做抗指纹处理，要求来料表面无脏污氧化；
9、出货前要求用胶塞堵住进出水口；
10、材料：铜C11000 硬度范围1/4HARD到HARD，参照标准ASTM-B-187或ASTM-B-152.
11、未注尺寸参照3D档；
12、需遵循Copy Exact流程，参照QI-PRDE-87 MKS Copy Exact流程；
*13、针对每批来料，IQC抽选1pcs送检孔位尺寸；
14、成品压降要求为，流量为3GPM时，进出水口的压降小于11.5PSI；需保证焊接后流道截面尺寸以及截面面积在要求范围内，流道内不能有异物；
15、未经 工程允许，不能更换摩擦焊刀具型号，转速，进给量等会影响到焊接的参数；



在此处敲/刻钢印，五位数，从00001开始，要求字迹清晰，不重复

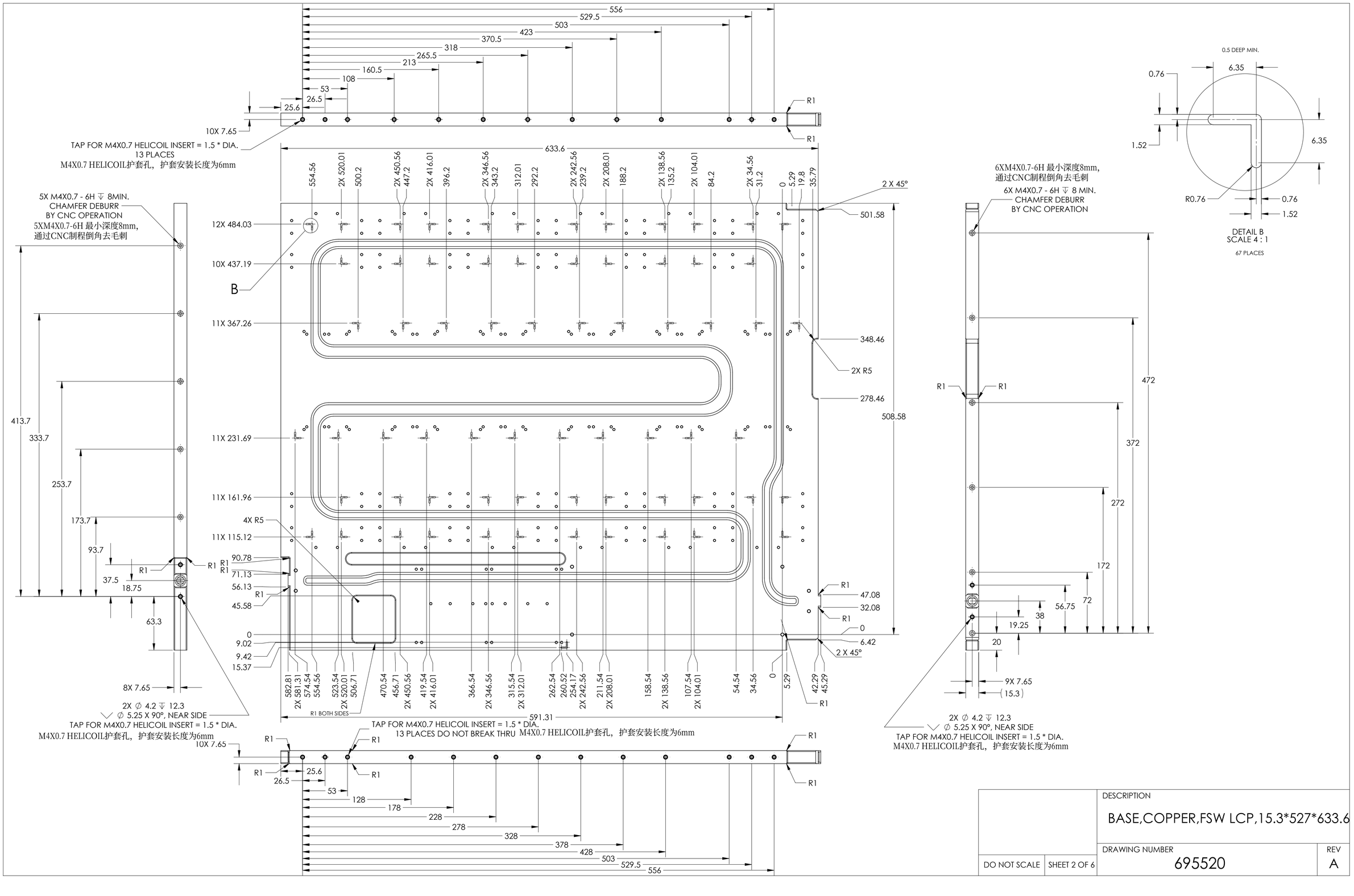




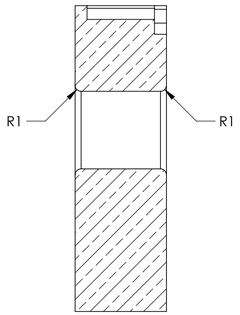


PN#695520
REV:A
Updated by:
Approved by:
Updated date:2023-12-21
Sheet: 1 of 6
EC#S2312048
EC内容：增加NOTE 14&15

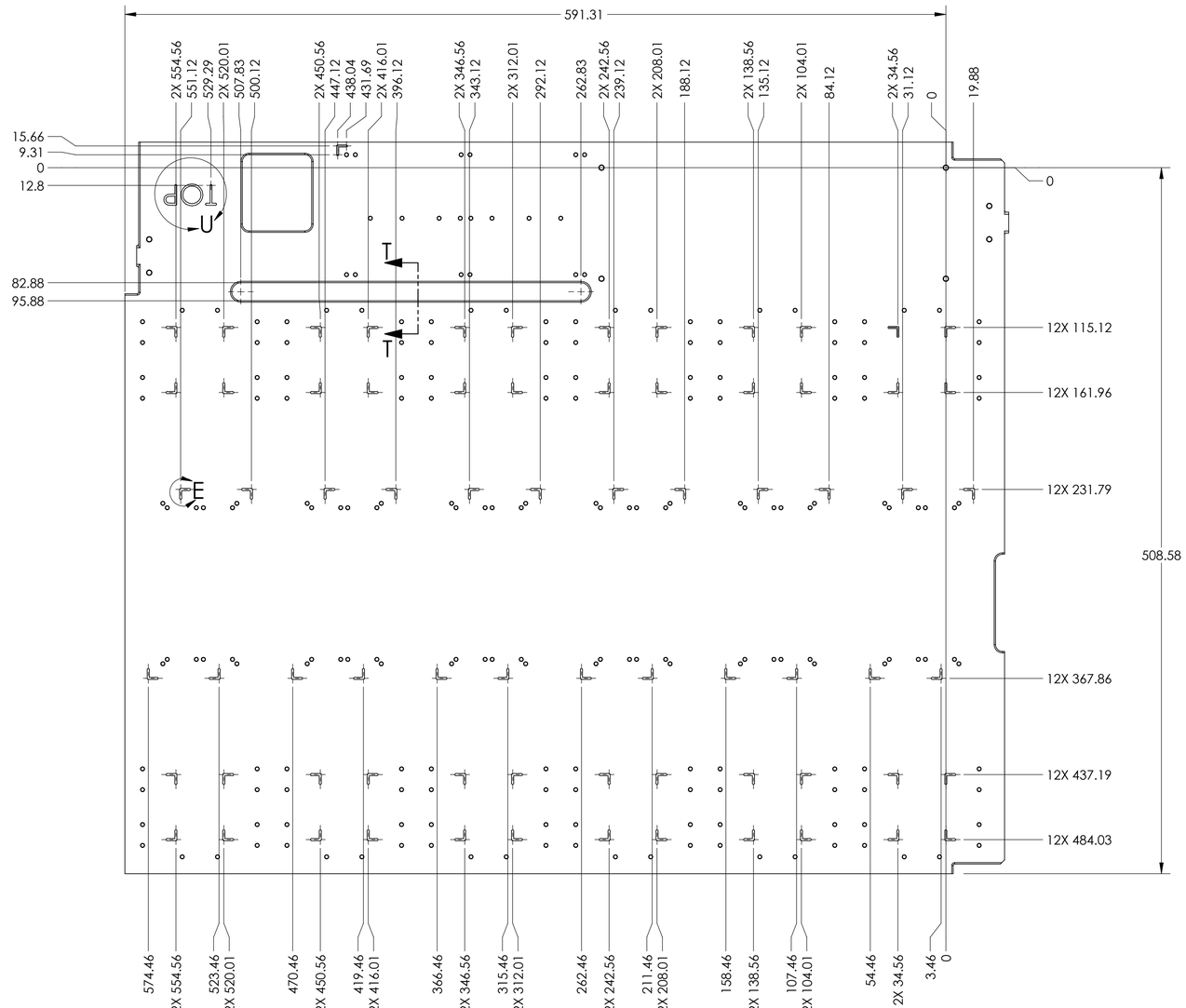
	THIRD ANGLE PROJ.	DRAWN BY :	DESCRIPTION: BASE,COPPER,FSW LCP,15.3*527*633.6
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MM.	CHECKED:	
		ENGINEER:	DRAWING NUMBER: 695520 / REV: A

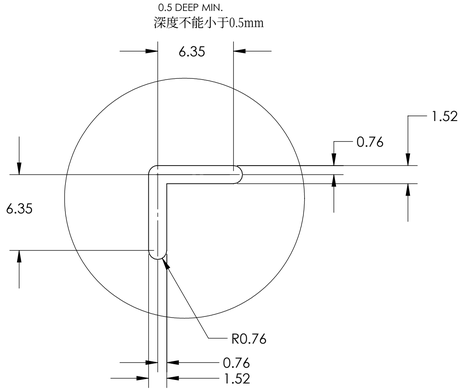


	DESCRIPTION	
	BASE,COPPER,FSW LCP,15.3*527*633.6	
DO NOT SCALE / SHEET 2 OF 6	DRAWING NUMBER 695520	REV A

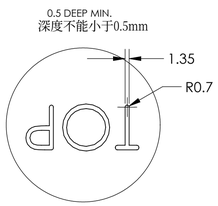


SECTION T-T
SCALE 2 : 1



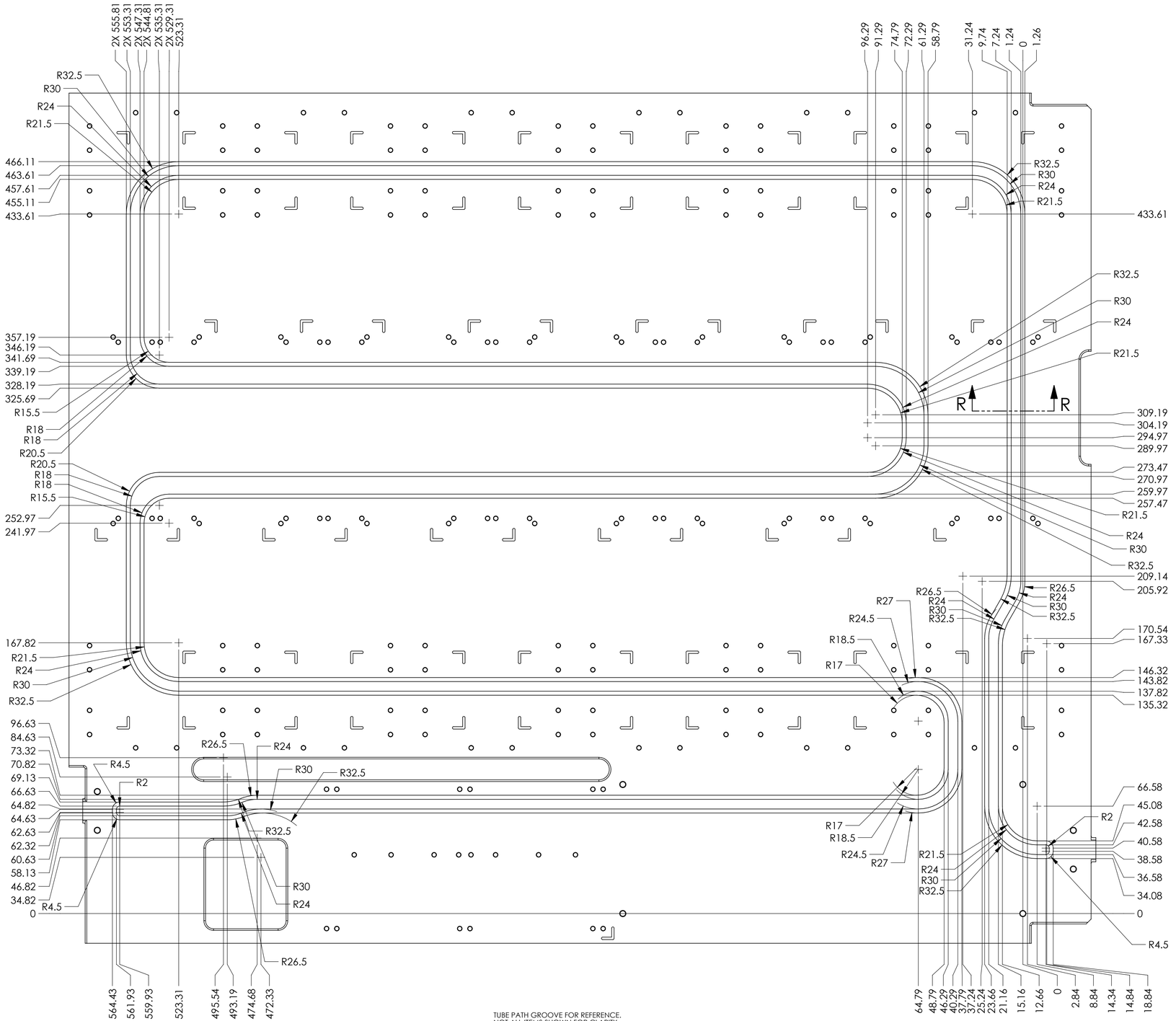


DETAIL E
SCALE 4 : 1
73 PLACES



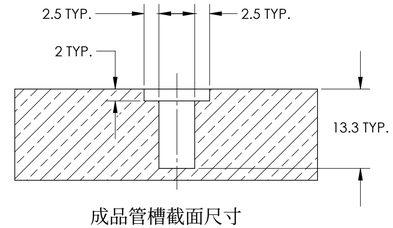
DETAIL U
SCALE 1 : 1

	DESCRIPTION	
	BASE,COPPER,FSW LCP,15.3*527*633.6	
DO NOT SCALE / SHEET 3 OF 6	DRAWING NUMBER 695520	REV A



TUBE PATH GROOVE FOR REFERENCE.
NOT ALL ITEMS SHOWN FOR CLARITY.
REFER TO SOLID MODEL.

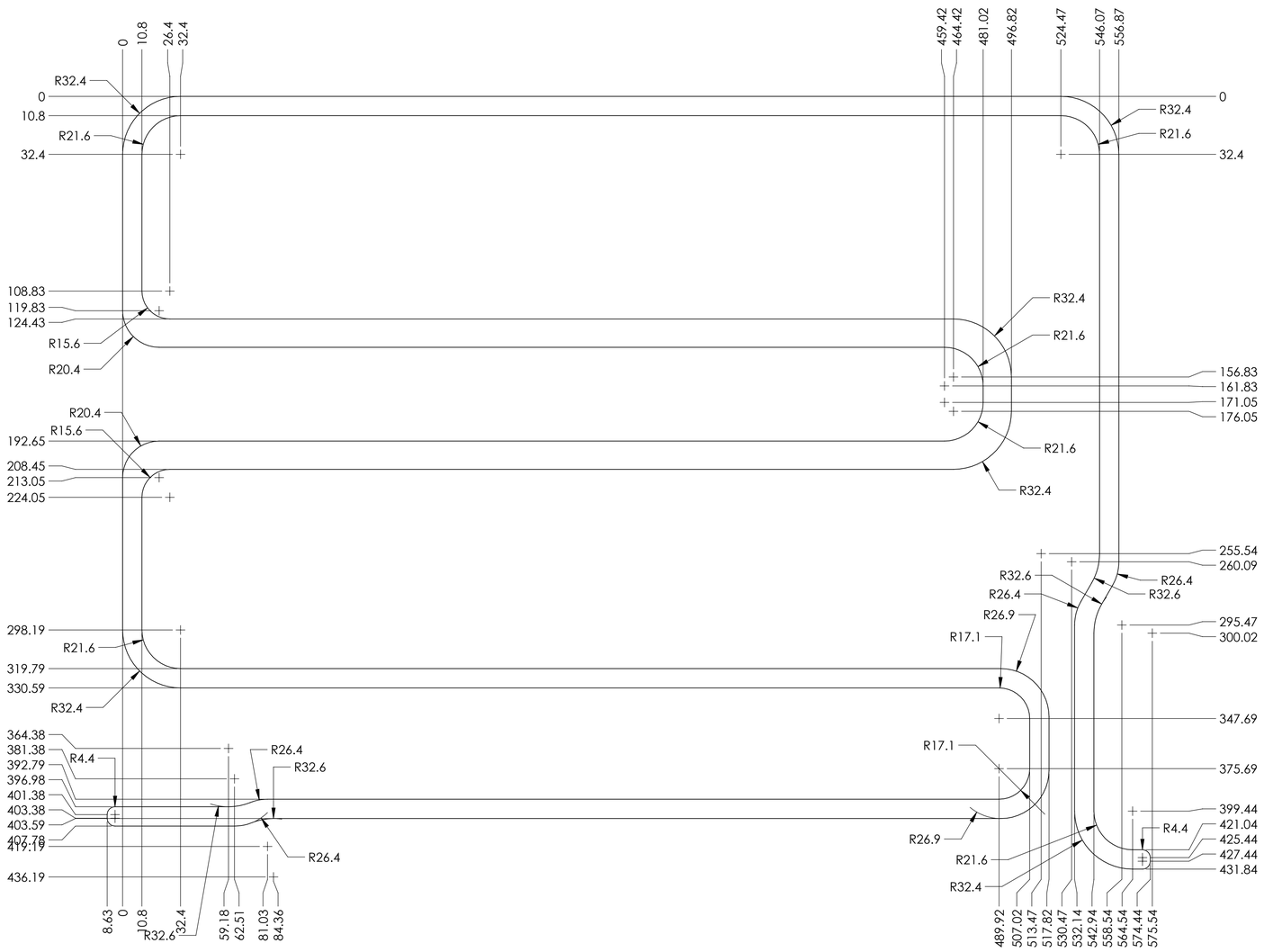
管槽特征供参考，有部分组件被隐藏，详见3D图



成品管槽截面尺寸

SECTION R-R
SCALE 2 : 1

	DESCRIPTION	
	BASE,COPPER,FSW LCP,15.3*527*633.6	
	DRAWING NUMBER	REV
DO NOT SCALE / SHEET 4 OF 6	695520	A



此页图纸的尺寸仅供参考

DIMENSIONS SHOWN FOR REFERENCE ONLY,
SUPPLIER OPTION TO FABRICATE PLATE IN ORDER
TO FACILITATE WELDING REQUIREMENTS.

		DESCRIPTION	
		BASE,COPPER,FSW LCP,15.3*527*633.6	
DO NOT SCALE	SHEET 5 OF 6	DRAWING NUMBER 695520	REV A



ORIGIN

Hole Table			
TAG	X LOC	Y LOC	SIZE
B1	-573.8	-75.6	M4X0.7 - 6H THRU ALL CHAMFER DEBURR BOTH SIDES BY CNC OPERATION M4X0.7-6H贯穿 通过CNC制程在两侧倒角去毛刺
B2	-573.8	-51.6	
B3	31.3	-51.6	
B4	31.3	-27.6	
B5	-248	-80	
B6	-248	0	
B7	0	-80	
B8	0	0	
AA1	-431.6	-77.1	M3X0.5 - 6H THRU CHAMFER DEBURR BOTH SIDES BY CNC OPERATION M3X0.5-6H贯穿 通过CNC制程在两侧倒角去毛刺
AA2	-431.6	9.3	
AA3	-425.3	-77.1	
AA4	-425.3	9.3	
AA7	-414.5	-36.4	
AA12	-391.6	-36.4	
AA18	-365	-36.4	
AA22	-349.7	-36.4	
AA23	-349.1	-77.1	
AA24	-349.1	9.3	
AA25	-342.7	-77.1	
AA26	-342.7	9.3	
AA27	-342.1	-36.4	
AA31	-326.9	-36.4	
AA37	-300.2	-36.4	
AA42	-277.3	-36.4	
AA45	-266.5	-77.1	
AA46	-266.5	9.3	
AA47	-260.2	-77.1	
AA48	-260.2	9.3	

Hole Table			
TAG	X LOC	Y LOC	SIZE
A124	-184	-433.1	M3X0.5 - 6H THRU ALL CHAMFER DEBURR BOTH SIDES BY CNC OPERATION M3X0.5-6H贯穿 通过CNC制程在两侧倒角去毛刺
A125	-184	-166.1	
A126	-184	-151.1	
A127	-184	-126	
A128	-184	-111	
A129	-162.6	-488.2	
A130	-162.6	-473.2	
A131	-162.6	-448	
A132	-162.6	-433.1	
A133	-162.6	-166.1	
A134	-162.6	-151.1	
A135	-162.6	-126	
A136	-162.6	-111	
A137	-148	-357.4	
A138	-148	-241.8	
A139	-144.8	-354.2	
A140	-144.8	-245	
A141	-134	-496.4	
A142	-134	-102.7	
A143	-123.8	-354.2	
A144	-123.8	-245	
A145	-118.7	-354.2	
A146	-118.7	-245	
A147	-108.6	-496.4	
A148	-108.6	-102.7	
A149	-97.8	-354.2	
A150	-97.8	-245	
A151	-94.6	-357.4	
A152	-94.6	-241.8	
A153	-80	-488.2	
A154	-80	-473.2	
A155	-80	-448	
A156	-80	-433.1	
A157	-80	-166.1	
A158	-80	-151.1	
A159	-80	-126	
A160	-80	-111	
A161	-58.6	-488.2	
A162	-58.6	-473.2	
A163	-58.6	-448	
A164	-58.6	-433.1	
A165	-58.6	-166.1	
A166	-58.6	-151.1	
A167	-58.6	-126	
A168	-58.6	-111	
A169	-44	-357.4	
A170	-44	-241.8	
A171	-40.8	-354.2	
A172	-40.8	-245	
A173	-30	-496.4	
A174	-30	-102.7	
A175	-19.8	-354.2	
A176	-19.8	-245	
A177	-14.7	-354.2	
A178	-14.7	-245	
A179	-4.6	-496.4	
A180	-4.6	-102.7	
A181	6.2	-354.2	
A182	6.2	-245	
A183	9.4	-357.4	
A184	9.4	-241.8	
A185	24	-488.2	
A186	24	-473.2	
A187	24	-448	
A188	24	-433.1	
A189	24	-166.1	
A190	24	-151.1	
A191	24	-126	
A192	24	-111	

Hole Table			
TAG	X LOC	Y LOC	SIZE
A1	-578.6	-488.2	M3X0.5 - 6H THRU ALL CHAMFER DEBURR BOTH SIDES BY CNC OPERATION M3X0.5-6H贯穿 通过CNC制程在两侧倒角去毛刺
A2	-578.6	-473.2	
A3	-578.6	-448	
A4	-578.6	-433.1	
A5	-578.6	-166.1	
A6	-578.6	-151.1	
A7	-578.6	-126	
A8	-578.6	-111	
A9	-564	-357.4	
A10	-564	-241.8	
A11	-560.8	-354.2	
A12	-560.8	-245	
A13	-550	-496.4	
A14	-550	-102.7	
A15	-539.8	-354.2	
A16	-539.8	-245	
A17	-534.7	-354.2	
A18	-534.7	-245	
A19	-524.6	-496.4	
A20	-524.6	-102.7	
A21	-513.8	-354.2	
A22	-513.8	-245	
A23	-510.6	-357.4	
A24	-510.6	-241.8	
A25	-496	-488.2	
A26	-496	-473.2	
A27	-496	-448	
A28	-496	-433.1	
A29	-496	-166.1	
A30	-496	-151.1	
A31	-496	-126	
A32	-496	-111	
A33	-474.6	-488.2	
A34	-474.6	-473.2	
A35	-474.6	-448	
A36	-474.6	-433.1	
A37	-474.6	-166.1	
A38	-474.6	-151.1	
A39	-474.6	-126	
A40	-474.6	-111	
A41	-460	-357.4	

Hole Table			
TAG	X LOC	Y LOC	SIZE
A42	-460	-241.8	M3X0.5 - 6H THRU ALL CHAMFER DEBURR BOTH SIDES BY CNC OPERATION M3X0.5-6H贯穿 通过CNC制程在两侧倒角去毛刺
A43	-456.8	-354.2	
A44	-456.8	-245	
A45	-446	-496.4	
A46	-446	-102.7	
A47	-435.8	-354.2	
A48	-435.8	-245	
A49	-430.7	-354.2	
A50	-430.7	-245	
A51	-420.6	-496.4	
A52	-420.6	-102.7	
A53	-409.8	-354.2	
A54	-409.8	-245	
A55	-406.6	-357.4	
A56	-406.6	-241.8	
A57	-392	-488.2	
A58	-392	-473.2	
A59	-392	-448	
A60	-392	-433.1	
A61	-392	-166.1	
A62	-392	-151.1	
A63	-392	-126	
A64	-392	-111	
A65	-370.6	-488.2	
A66	-370.6	-473.2	
A67	-370.6	-448	
A68	-370.6	-433.1	
A69	-370.6	-166.1	
A70	-370.6	-151.1	
A71	-370.6	-126	
A72	-370.6	-111	
A73	-356	-357.4	
A74	-356	-241.8	
A75	-352.8	-354.2	
A76	-352.8	-245	
A77	-342	-496.4	
A78	-342	-102.7	
A79	-331.8	-354.2	
A80	-331.8	-245	
A81	-326.7	-354.2	
A82	-326.7	-245	

Hole Table			
TAG	X LOC	Y LOC	SIZE
A83	-316.6	-496.4	M3X0.5 - 6H THRU ALL CHAMFER DEBURR BOTH SIDES BY CNC OPERATION M3X0.5-6H贯穿 通过CNC制程在两侧倒角去毛刺
A84	-316.6	-102.7	
A85	-305.8	-354.2	
A86	-305.8	-245	
A87	-302.6	-357.4	
A88	-302.6	-241.8	
A89	-288	-488.2	
A90	-288	-473.2	
A91	-288	-448	
A92	-288	-433.1	
A93	-288	-166.1	
A94	-288	-151.1	
A95	-288	-126	
A96	-288	-111	
A97	-266.6	-488.2	
A98	-266.6	-473.2	
A99	-266.6	-448	
A100	-266.6	-433.1	
A101	-266.6	-166.1	
A102	-266.6	-151.1	
A103	-266.6	-126	
A104	-266.6	-111	
A105	-252	-357.4	
A106	-252	-241.8	
A107	-248.8	-354.2	
A108	-248.8	-245	
A109	-238	-496.4	
A110	-238	-102.7	
A111	-227.8	-354.2	
A112	-227.8	-245	
A113	-222.7	-354.2	
A114	-222.7	-245	
A115	-212.6	-496.4	
A116	-212.6	-102.7	
A117	-201.8	-354.2	
A118	-201.8	-245	
A119	-198.6	-357.4	
A120	-198.6	-241.8	
A121	-184	-488.2	
A122	-184	-473.2	
A123	-184	-448	

DESCRIPTION

BASE,COPPER,FSW LCP,15.3*527*633.6

DRAWING NUMBER 695520

REV A

DO NOT SCALE

SHEET 6 OF 6