

PLASTIC TOLERANCE				METAL TOLERANCE				RUBBER TOLERANCE					
0-15	15-30	30-60	60-120	0.5-6	6-30	30-120	120-400	0.5-3	3-6	6-30	30-120	120-400	400-1000
±0.1	±0.2	±0.3	±0.5	±0.1	±0.2	±0.3	±0.5	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0

DRAWING DESCRIPTION	
FINAL PRODUCTION	
TOLING	
ROUTING & SAMPLE	

MODIFICATIONS			
REV. NO.	Revision Note	Date	Signature/Checked

Kore Industries Zhongshan Co., Ltd.

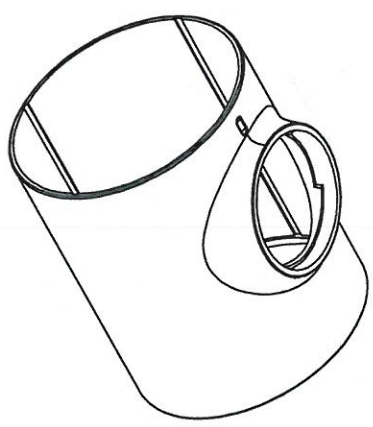
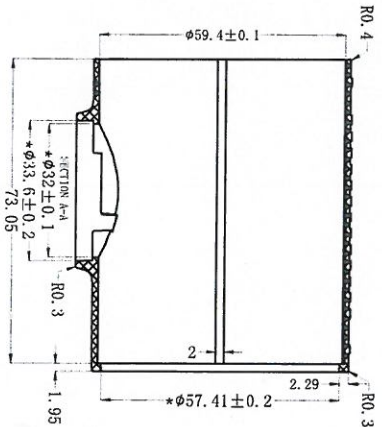
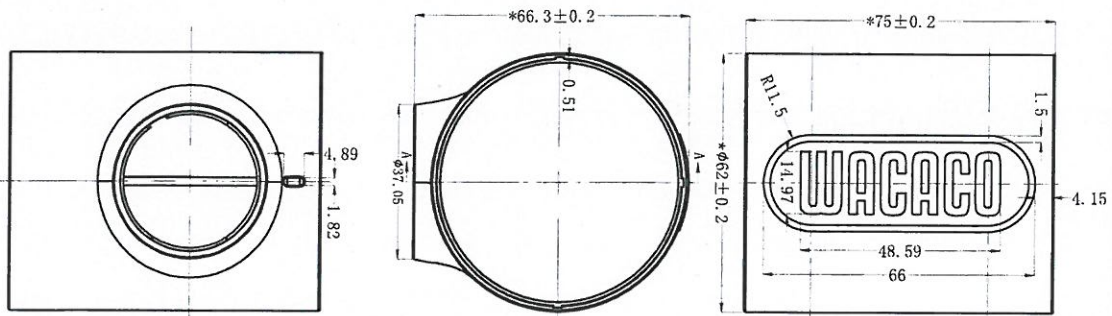
New Tooling 新模 Transfer Tooling 转模

Modification 改模 Reference 参考

Remarks备注: M20210015

Sign & Date 签名&日期: *[Signature]* 2021.08.28

Resp. Dept. 发放部门: 项目部. 品质部.



- 技术要求:
- 1, 零件不能有裂纹, 批锋, 烧焦, 变形等不良啤塑现象。
 - 2, 没有标注公差参考公差表, 未注拔模1~1.5°, 未注圆角R0.3MM
 - 3, 带*为工程重要尺寸, 带■为品管测量尺寸。
 - 4, 零件水口料混入比例: Max 0%
 - 5, 零件需符合ROHS、REACH、LFGB、FDA标准。
 - 6, 开模零件以3D模型为准, 不清楚尺寸请参考3D模型。

科捷塑胶工业(中山)有限公司

生效日期: 2021-08-28

受控文件

eternaliz

ETERNAL GUANGDONG TECH ELECTRIC CO.,LTD.

PART NAME: 大身外壳

PART NO.: 202027662

TITLE		DESIGNED BY		CHECKED BY		APPR BY	
CJ-269C手动压力咖啡机		余锐冠		陈学明		姚海有	
DATE	2021.03.12	DATE	2021.03.12	DATE	2021.03.12	DATE	2021.03.12

MATERIAL	REGRIND	MAX OZ	TYPE	WE	PL	PU	ASSY	PACK	DRAWING NO.	FINISH	GLOSS	ISSUE NO.
ABS				✓					269C-P06			A0

Kore Industries Zhongshan Co. Ltd.

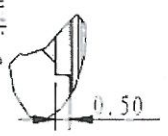
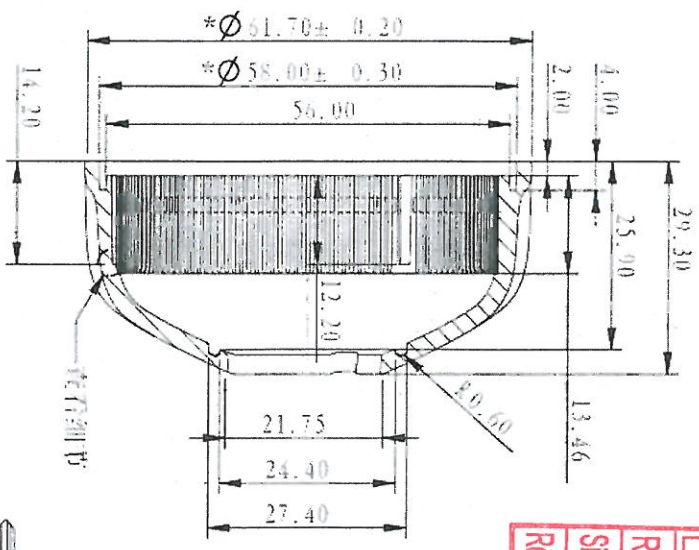
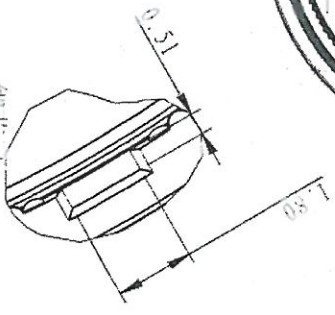
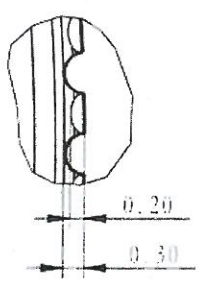
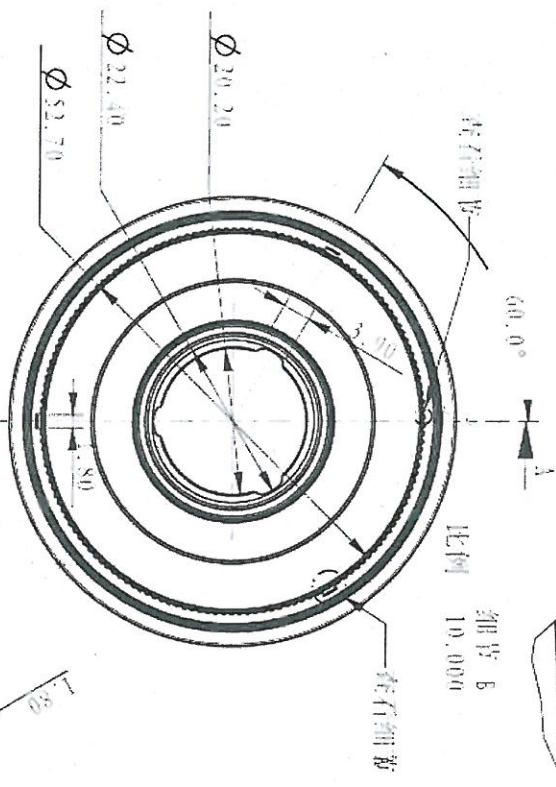
New Tooling 新模 Transfer Tooling 转模

Modification 改模 Reference 参考

Remarks 备注: M20210938

Sign & Date 签名 & 日期: *[Signature]* 28/8/2021

Resp. Dept 发放部门: 工程部. 品质部



比例 6.000

比例 4.000

科捷塑胶工业(中山)有限公司
生效日期: 2021-08-28
REVISION: 1
设计: 罗伟伦
审核: 罗伟伦

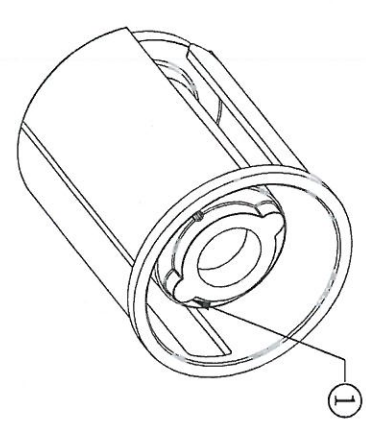
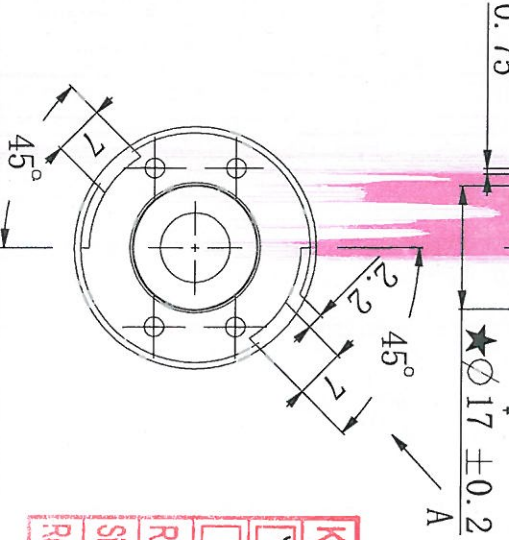
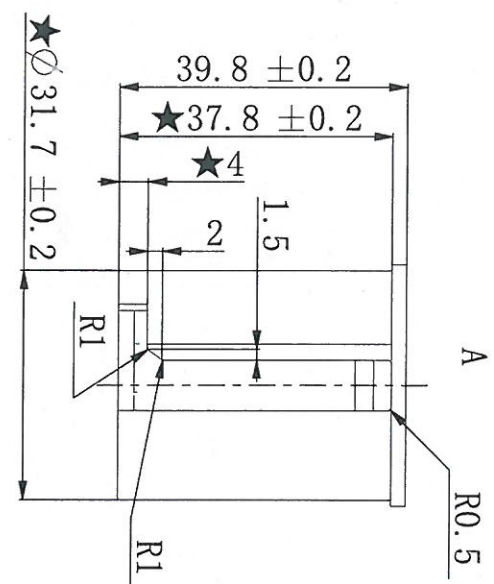
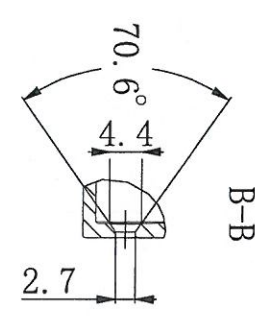
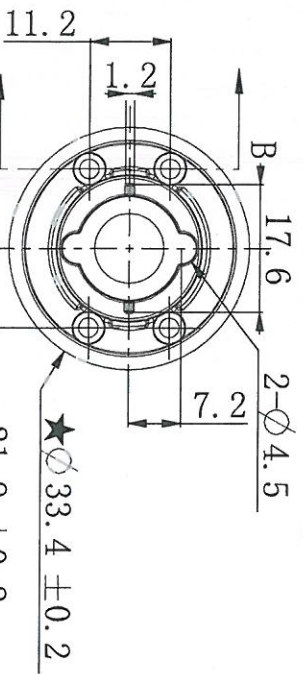
- 1、带*为重要尺寸, 未注公差按GB, FDA, RoHS, REACH 标准。
- 2、外形尺寸, 圆角及详细曲面尺寸按3D要求。
- 3、外观无缩水, 批锋, 气纹, 注塑不满, 变形等不良。

eternalizte

DATE	2021-08-28
DESIGNED BY	罗伟伦
CHECKED BY	张嘉成
DATE	2021-08-28
DATE	2021-08-28

PP	SCALE: 1:1	DATE: 2021-08-28	ISSUE NO: 1.0
PP	SCALE: 1:1	DATE: 2021-08-28	ISSUE NO: 1.0

1		2		3		4		5		6																								
PLASTIC		TOLERANCE		METAL TOLERANCE		RUBBER TOLERANCE		修订日期		修订说明																								
0-15	±0.1	15-53	±0.3	53-120	±0.5	120-200	±0.8	200-250	±1.0	250-315	±1.2	0.5-6	±0.1	6-30	±0.2	30-120	±0.3	120-400	±0.5	0.5-3	±0.2	3-6	±0.3	6-30	±0.5	30-120	±0.8	120-400	±1.2	400-1000	±2	2021.08.17	1、①增加一个凸台	Ning



- 技术标准:
1. 零件有裂纹, 批锋, 烧焦, 变形等不良啤塑现象;
 2. 零件有注角为R0.1-0.5mm, 未注拔模0.2°-0.3°;
 3. 未注圆角工程重要尺寸, 带■为品管测量尺寸;
 4. 带★为需外观以3D模型为准, 不清楚尺寸请参考3D模型。
 5. 零件为需外观以3D模型为准;
 6. 零件为需外观以3D模型为准;
 7. 零件为需外观以3D模型为准;

生效日期 2021-08-28 日期
 科锐塑胶工业(中山)有限公司
 受控文件

Kore Industries Zhongshan Co., Ltd.

New Tooling新模 Transfer Tooling转模
 Modification改模 Reference参考

Remarks备注: M20210029.

Sign & Date签名&日期: [Signature] 2021-08-28

Resp. Dept. 发放部门: 项目部、品质部

PART NAME		BUTTON_SUPPORT		TITLE		PICOPRESSO_POCKET	
PART NO		Pico_P006		DESIGNED BY		Ning	
MATERIAL		PC		CHECKED BY		DATE	
SCALE		1:1		APPROVAL BY		DATE	
REGING MAX %		0%		UNIT		mm	
TYPE		ME PL		DATE		DATE	
SCALE		1:1		DRAWING NO.		Page	
FINISH		GLOSS		ISSUE NO		A2	



PARTIAL TOLERANCE										TOTAL TOLERANCE									
±0.05	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05

KORE INDUSTRIES Zhongshan Co.

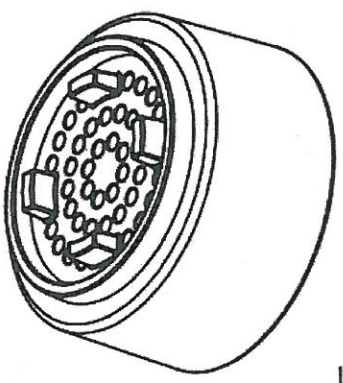
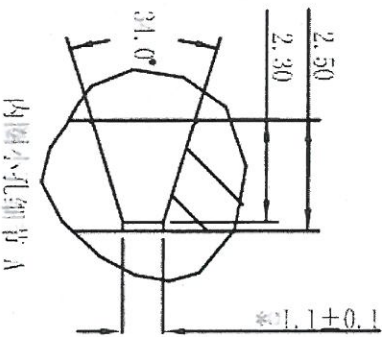
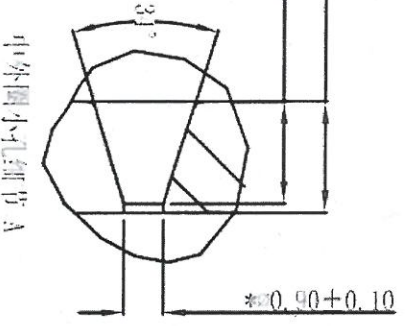
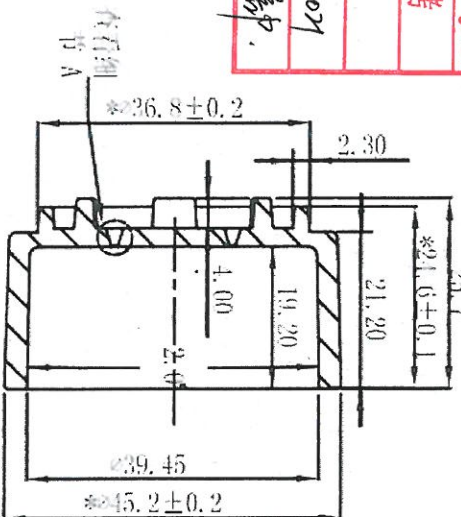
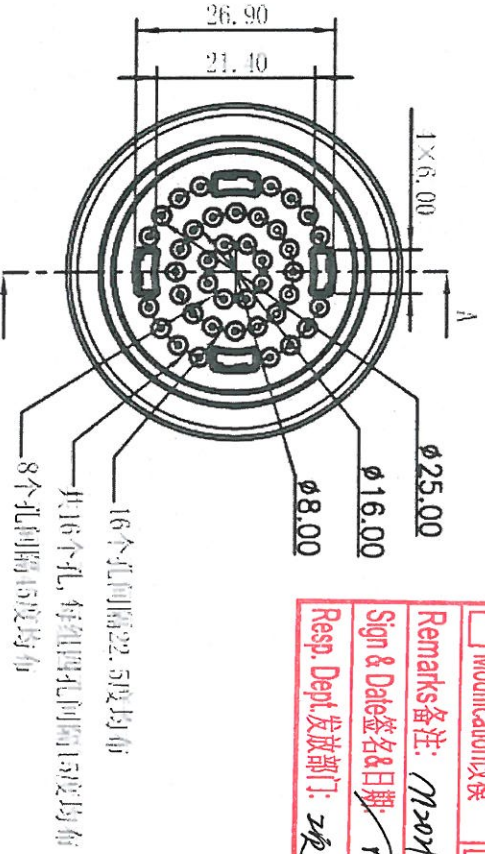
DRAWING DESCRIPTION	FINAL PRODUCTION
TITLING	DRAWING & SAMPLE

MODIFICATIONS			
REV. NO.	Revision Note	Date	Signature
01	初版	2018-01-23	陈家喜
02	修改	2018-12-21	魏海行

生效日期 2021-08-28
受控文件

New Tooling 新模
 Transfer Tooling 转模
 Modification 改模
 Reference 参考

Remarks备注: M2019035
Sign & Date 签名&日期: 2018-08-20
Resp. Dept 发放部门: 项目部、品质部



技术要求:

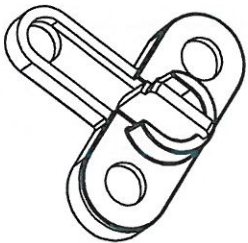
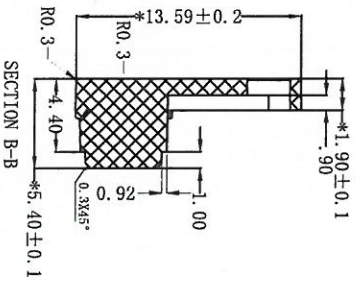
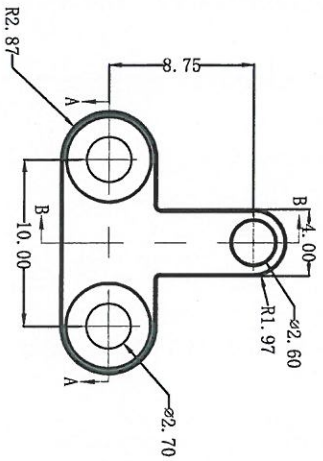
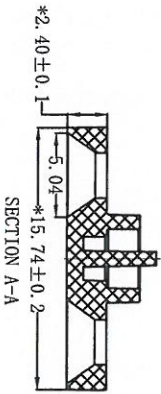
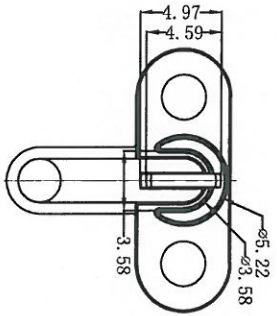
- 1、零件材料为: 081, 符合DIN, ROLLS, REACT等标准具体要求.
- 2、带*为重要尺寸, 未注公差按公差表要求, 未注外形尺寸, 圆角按详细曲面尺寸按3D要求.
- 3、外观无积水, 批结, 气纹, 注塑不满, 变形等不良.

eternaliz 永恒电气

DESIGNED BY	杜焕喜	DATE	2019-01-23
CHECKED BY	陈家喜	DATE	2019-01-23
APPR. BY	魏海行	DATE	2018-12-21

PART NAME		8g粉杯		TITLE		CJ-269 手动咖啡机	
PART NO.		22690-070-000		UNIT		1 OF 1	
MATERIAL	081	REGIND	MV 0	ME	PL	PU	AST
SCALE	1:1	TYPE		FINISH	GLOSS	ISSUE NO	43

1										2										3									
PLASTIC TOLERANCE										METAL TOLERANCE										RUBBER TOLERANCE									
0-15	15-30	30-120	120-200	200-250	250-315	315-400	400-500	500-630	630-800	0.3-6	0.3-6	0.3-6	0.3-6	0.3-6	0.3-6	0.3-6	0.3-6	0.3-6	0.3-6	0.3-3	0.3-3	0.3-3	0.3-3	0.3-3	0.3-3	0.3-3	0.3-3	0.3-3	0.3-3
±0.1	±0.2	±0.3	±0.5	±0.8	±1.0	±1.2	±0.1	±0.2	±0.3	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±0.1	±0.2	±0.3	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±0.1	±0.2	±0.3



4	
DRAWING DESCRIPTION	✓
FINAL PRODUCTION	
TOOLING	
QUOTING & SAMPLE	

5		6	
REV. NO.	Revision Note	Date	Signature/Checked

科敏塑胶工业(中山)有限公司
 生效 2021-08-28 日期
 受控文件

Korea Industries Zhongshan Co., Ltd.
 New Tooling 新模 Transfer Tooling 转模
 Modification 改模 Reference 参考
 Remarks 备注: M-2021031
 Sign & Date 签名 & 日期: [Signature] 28/8-2021
 Resp. Dept 发放部门: 工程部. 品质部.

技术要求:

- 1, 零件不能有裂纹, 批锋, 烧焦, 变形等不良啤塑现象。
- 2, 没有标注公差参考公差表, 未注拔模1~1.5°, 未注圆角R0.1MM
- 3, 带*为工程重要尺寸, 带■为品管测量尺寸。
- 4, 零件水口料混入比例: Max 0%
- 5, 零件需符合ROHS、REACH、LFGB、FDA标准。
- 6, 开模零件以3D模型为准, 不清楚尺寸请参考3D模型。

eternalize

ETERNAL (GUANGDONG) TECH ELECTRIC CO.,LTD.

PART NAME 出水阀门

PART NO. 202021665

MATERIAL PP REGIND MAX 0% TYPE

SCALE 1:3

TITLE CJ-269C手动压力咖啡机

DESIGNED BY 余锐冠 DATE 2021.02.27

CHECKED BY 陈学明 DATE 2021.02.27

APPR BY 姚海有 DATE 2021.02.27

UNIT: mm SHEET: 1 OF 1

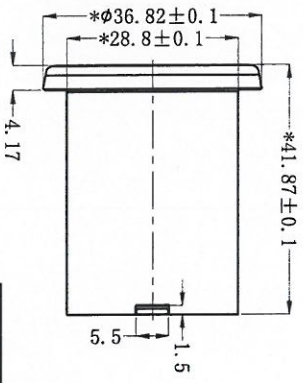
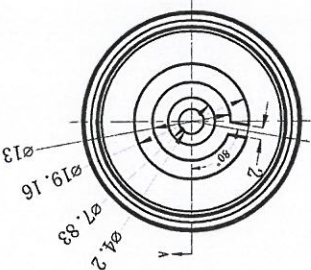
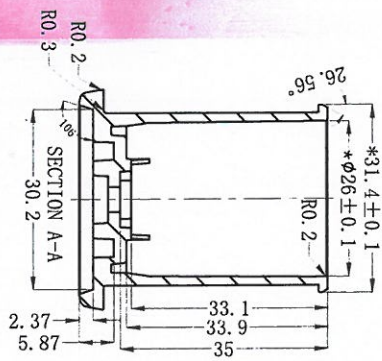
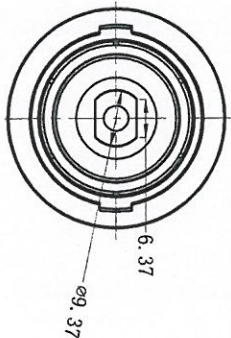
ME PL PU ASSY PACK DRAWING NO. 269C-P05

FINISH GLOSS ISSUE NO. A0

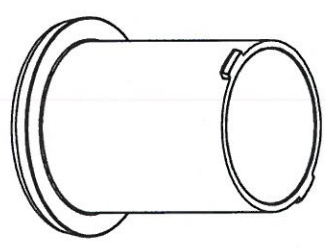
1					2					3					
PLASTIC TOLERANCE					METAL TOLERANCE					RUBBER TOLERANCE					
0-15	15-30	30-45	45-60	60-75	0.5-6	6-30	30-120	120-400	400-1000	0.5-3	3-6	6-30	30-120	120-400	400-1000
±0.1	±0.2	±0.3	±0.5	±0.8	±1.0	±0.2	±0.3	±0.5	±2.0	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0

DRAWING DESCRIPTION	FINAL PRODUCTION	TOOLING	QUOTING & SAMPLE
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MODIFICATIONS		REV NDL	Revision Note	Date	Signature	Checked



科锐塑胶工业(中山)有限公司
 生效日期 2021-08-28
 受控文件

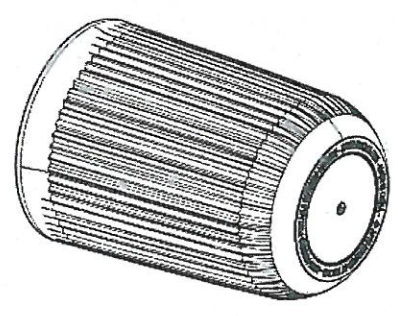
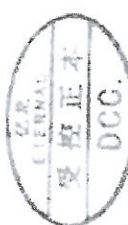
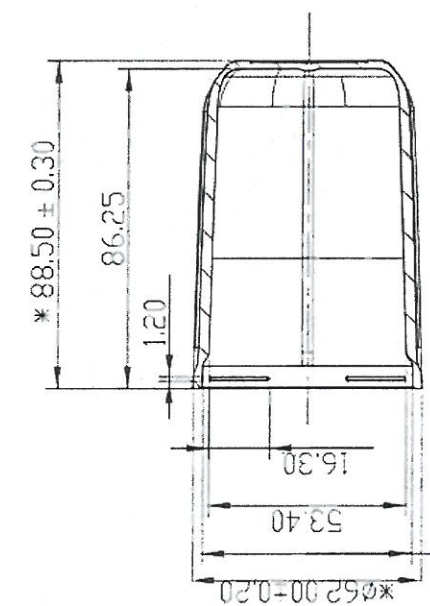
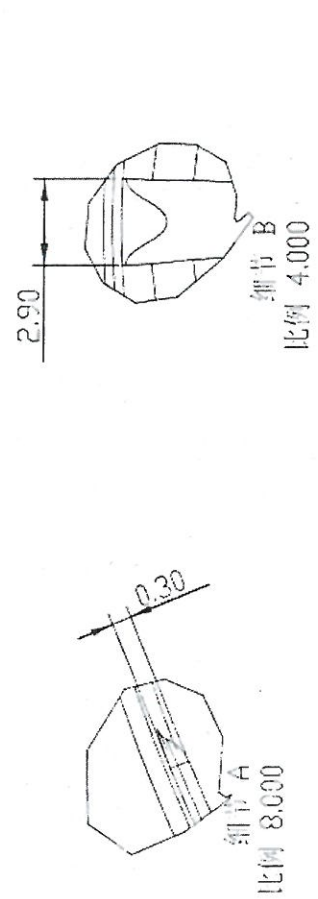


Korea Industries Zhongshan Co., Ltd.
 New Tooling 新模
 Transfer Tooling 转模
 Modification 改模
 Reference 参考
 Remarks 备注: N20210330.
 Sign & Date 签名日期: [Signature] 2021/8/28
 Resp. Dept. 发放部门: 项目部. 品质部.

- 技术要求:
- 1, 零件不能有裂纹, 批锋, 烧焦, 变形等不良啤塑现象。
 - 2, 没有标注公差参考公差表, 未注拔模1~1.5°, 未注圆角R0.1MM
 - 3, 带*为工程重要尺寸, 带■为品管测量尺寸。
 - 4, 零件水口料混入比例: Max 0%
 - 5, 零件需符合ROHS、REACH、LFGB、FDA标准。
 - 6, 开模零件以3D模型为准, 不清楚尺寸请参考3D模型。

		ETERNAL (GUANGDONG) TECH ELECTRIC CO.,LTD.		TITLE		CJ-269C手动压力咖啡机	
		PART NAME	按键	DESIGNED BY	余锐冠	DATE	2021.03.23
PART NDL	2020276558	CHECKED BY	陈学明	DATE	2021.03.23	APPR BY	姚海有
MATERIAL	PC	REGIND	MAX 0%	TYPE	UNIT: mm	SHEET:	1 OF 1
SCALE	1:1	ME	PL	PU	ASSY/PACK	DRAWING NDL	269C-P04
						FINISH/GLOSS	ISSUE NDL
							A0

PLASTIC TOLERANCE		METAL TOLERANCE		RUBBER TOLERANCE														
0.6	6-30	20-12	120-40	45-100	15-4	6.10	10.25	25-6.3	15-50	100-100	0-4	4.63	2.316	16-25	25-40	40-63	63-100	100-160
101	152	203	405	608	1015	1525	2030	3048	4064	6096	10160	15240	20320	30480	40640	60960	101600	



Kore Industries Zhongshan Co., Ltd.

New Tooling 新模 Transfer Tooling 转模

Modification 改模 Reference 参考

Remarks 备注: M20210039

Sign & Date 签名&日期: [Signature] 2021/8/20

Resp. Dept. 发放部门: 项目部. 研发部.

MODIFICATIONS		
REV. NO.	Revisor Note	Date

DRAWING DESCRIPTION	
FINAL PRODUCTION	TOOLING

科隆塑胶工业(中山)有限公司

技术部 2021.08.12.8

REACH 符合欧盟要求

受控文件

符合LFGB, FDA, RoHs, REACH 符合欧盟要求

本注公差按公差表要求, 未注公差按图样标注尺寸按3D要求。

3、外观无缩水, 批号一致, 注塑不满, 变形等不良。

eternal		TITLE		CJ-269 手动咖啡机	
ETERNAL (GUANGDONG) TECH ELECTRIC CO., LTD.		DESIGNED BY	廖世洲	DATE	2018-1-13
PART NAME		CHECKED BY	张嘉敏	DATE	2018-1-15
PART NO.		APPR. BY	姚海行	DATE	2018-1-17
MATERIAL		UNIT	mm	SHEET	1 OF 1
RECORD		ME	PL	PU	ASSY/PACK
SCALE		DRAWING NO.		2601-24	
TYPE		FINISH		GLOSS/ISSUE NO	
				A0	

PLASTIC TOLERANCE		METAL TOLERANCE		RUBBER TOLERANCE	
0-4	0-30	05-4	05-30	05-4	05-30
5-9	30-120	31-43	31-120	31-43	31-120
10-14	120-250	44-56	44-250	44-56	44-250
15-19	250-500	63-85	63-500	63-85	63-500
20-24	500-1000	83-110	83-1000	83-110	83-1000
25-29	1000-2000	105-140	105-2000	105-140	105-2000
30-34	2000-4000	130-170	130-4000	130-170	130-4000
35-39	4000-8000	160-210	160-8000	160-210	160-8000
40-44	8000-15000	200-260	200-15000	200-260	200-15000
45-49	15000-30000	250-330	250-30000	250-330	250-30000
50-54	30000-60000	320-420	320-60000	320-420	320-60000
55-59	60000-120000	400-530	400-120000	400-530	400-120000
60-64	120000-250000	500-660	500-250000	500-660	500-250000
65-69	250000-500000	630-830	630-500000	630-830	630-500000
70-74	500000-1000000	800-1050	800-1000000	800-1050	800-1000000
75-79	1000000-2000000	1000-1300	1000-2000000	1000-1300	1000-2000000
80-84	2000000-4000000	1250-1650	1250-4000000	1250-1650	1250-4000000
85-89	4000000-8000000	1600-2100	1600-8000000	1600-2100	1600-8000000
90-94	8000000-15000000	2000-2650	2000-15000000	2000-2650	2000-15000000
95-99	15000000-30000000	2500-3300	2500-30000000	2500-3300	2500-30000000

DRAWING DESCRIPTION	
FINAL PRODUCTION	
TUOLING	
OUTDING & SAMPLE	

MODIFICATIONS	
REV. NO.	Revision Note
1	按图生产
2	
3	
4	
5	
6	
Date	Signature
Checked	

Kore Industries Zhongshan Co., Ltd.

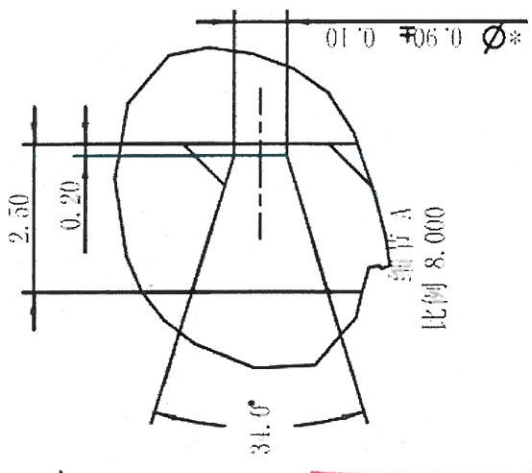
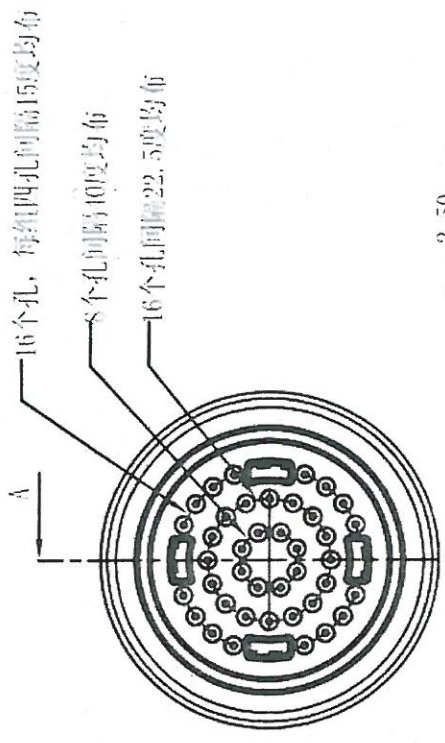
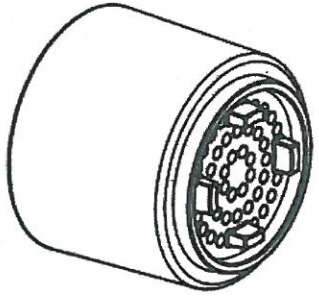
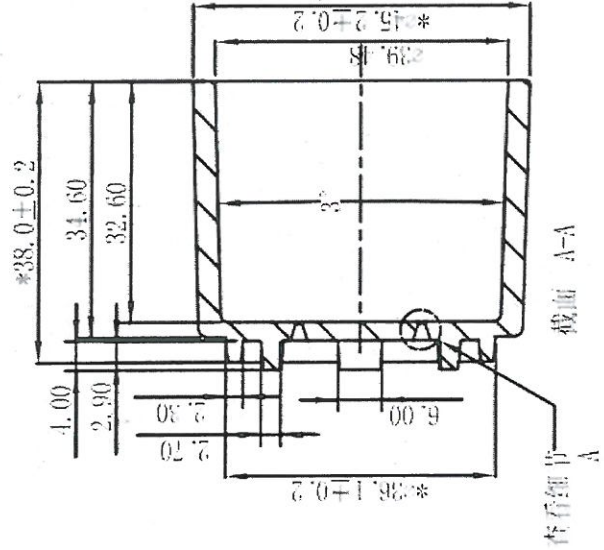
New Tooling 新模 Transfer Tooling 转模

Modification 改模 Reference 参考

Remarks备注: 1720210041

Sign & Date 签名&日期: 2021.8.28. 姚清有

Resp. Dept. 发版部门: 模具部 品保部



科锐塑胶工业(中山)有限公司

生效 2021-08-28 日期

受控文件

- 技术规格:
- 零件材料为: PBT, 符合DIN, walls, REACH等欧盟环保要求;
 - 带*为重要尺寸, 本注公差按公差表要求, 未注外形尺寸, 圆角及详细曲面尺寸按3D要求;
 - 外观无伤疤, 批号, 气纹, 注塑不满, 变形等不良。

eternal 艾龙		TITLE		CJ-260X胶囊咖啡机	
ETERNAL (GUANGDONG) TECH ELECTRIC CO.,LTD.		DESIGNED BY	杜焕喜	DATE	2019-01-23
PART NAME		CHECKED BY	陈家喜	DATE	2019-01-23
PART NO.		APPR. BY	姚清有	DATE	2019-01-23
MATERIAL		UNIT	mm	SHEET	1 OF 1
REGIND		ME PL	PU	ASTY	PACK
SCALE		DRAWING NO.	202003		
TYPE		FINISH	GLASS		
1:1		ISSUE NO	A2		