
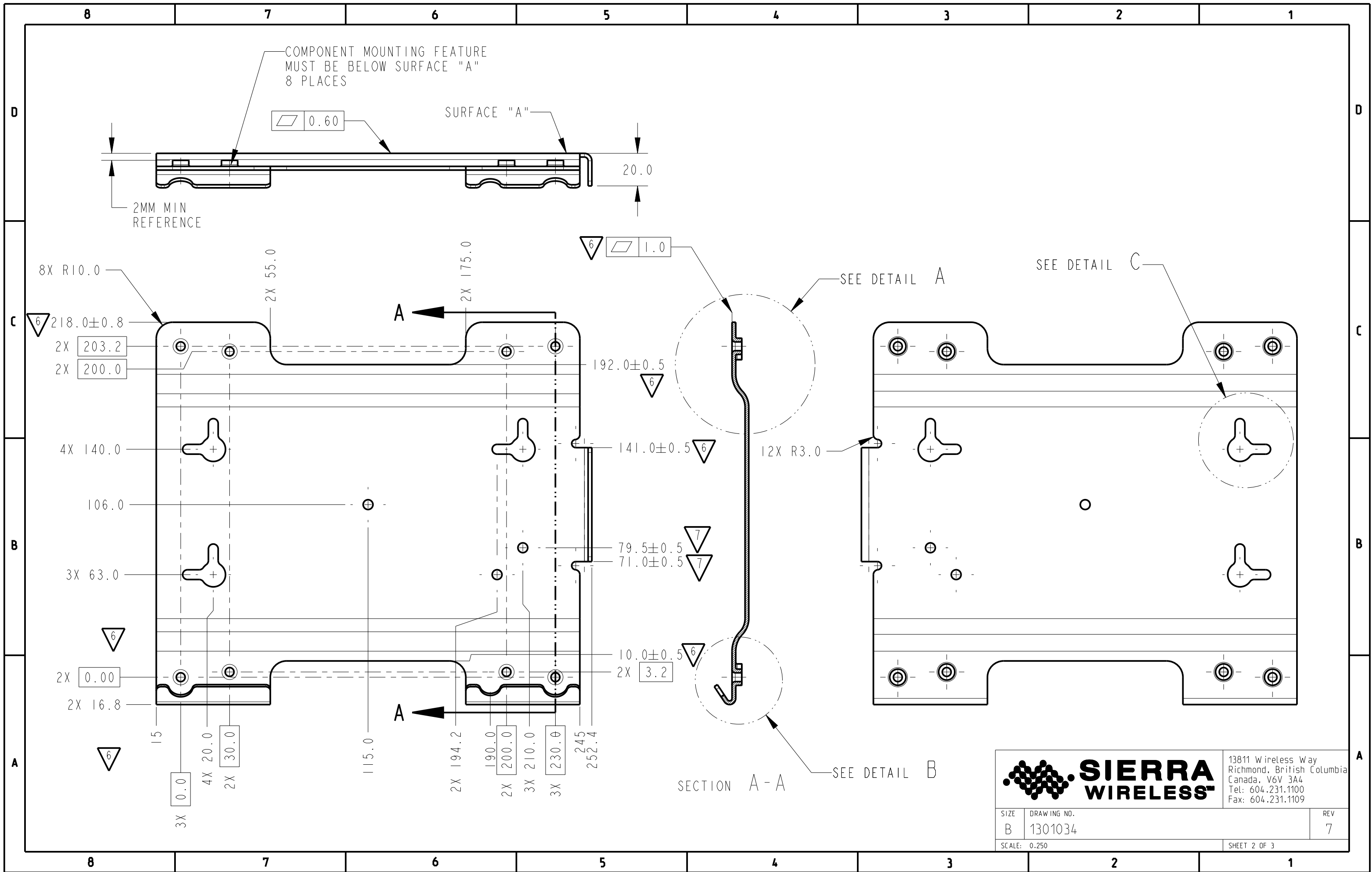


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| 8 | | 7 | | 6 | | 5 | | 4 | | 3 | | 2 | | 1 | | | | | | | |
| <p>NOTES APPLICABLE TO PART MANUFACTURER</p> <p>1. DESCRIPTION AND APPLICATION: MOUNTING BRACKET TO BE USED IN WIRELESS DEVICE</p> <p>2. APPLICABLE DOCUMENTS:</p> <p>ASME Y14.5M-1994 GEOMETRIC DIMENSIONING AND TOLERANCING DOC NO. 2140122 SIERRA WIRELESS - GENERAL COSMETIC SPECIFICATION</p> <p>3. MATERIAL AND TOOLING REQUIREMENTS:</p> <p>3.1 MATERIAL: COLD ROLLED STEEL, AISI 1010, 1/2H (HALF-HARD)</p> <p>3.2 THICKNESS: 2.28 +/- 0.13mm</p> <p>3.3 FINISH: APPLY ROHS COMPLIANT CHROMATE (TRIVALENT) ALL SURFACES PRIOR TO POWDER COATING. POWDER COAT: BLACK SANDEX (COLOR & TEXTURE MUST MATCH AIRLINK MG90 TOP ENCLOSURE - 1304105) POWDER COAT THICKNESS: 40um TO 120um X</p> <p>3.4 REMOVE BURRS AND SHARP EDGES</p> <p>3.5 MASK ALL THREADS PRIOR TO POWDER COATING.</p> <p>3.6 COMPLETE TOOL DRAWINGS TO BE SUBMITTED TO SIERRA WIRELESS MECHANICAL ENGINEERING GROUP FOR APPROVAL.</p> <p>3.7 THE PART/ASSEMBLY SHALL CONTAIN NO HAZARDOUS SUBSTANCES PER THE WASTE ELECTRICAL AND ELECTRONIC EQUIPMENT (WEEE) 2002/96/EC RoHS DIRECTIVE 2011/65/EU (RoHS 2) AND REACH DIRECTIVE</p> <p>4. MECHANICAL REQUIREMENTS:</p> <p>4.1 CONTROLLING GEOMETRY IS DEFINED BY THE 3D PRO/ENGINEER DATABASE. ALL SURFACES TO BE WITHIN 0.10mm OF DATABASE UNLESS OTHERWISE SPECIFIED. WHEREVER A CONFLICT EXISTS BETWEEN THE DRAWING AND THE DATABASE, THE DRAWING SHALL TAKE PRECEDENCE.</p> <p>4.2 DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994</p> <p>4.3 A REFERENCE DIMENSION IS USED FOR INFORMATIONAL PURPOSES ONLY AND HAS NO TOLERANCE. IT IS DESIGNATED BY: (XX.XX).</p> <p>4.4 MAXIMUM BURR HEIGHT: 0.13mm. NO LOOSE BURRS PERMITTED.</p> <p>4.5 BURRS SIDE OF PART AS SPECIFIED.</p> <p>5. QUALITY ASSURANCE REQUIREMENTS:</p> <p>5.1 ALL DIMENSIONS INDICATED ON DRAWING ARE CRITICAL TO FORM, FIT, OR FUNCTION.</p> <p>5.2 DIMENSIONS INDICATED WITH A X SYMBOL DENOTE QUALITY PROCESS CONTROL, (QPC), DIMENSIONS.</p> <p>5.3 QUALITY ASSURANCE PLAN:</p> <p>5.3.1 THE SUPPLIER MUST DEVELOP A QUALITY ASSURANCE PLAN TO ENSURE CRITICAL PARAMETER COMPLIANCE. THE PLAN MUST BE SUBMITTED TO SIERRA WIRELESS FOR REVIEW.</p> <p>5.3.2 THE SUPPLIER MUST MAINTAIN STATISTICAL PROCESS CONTROL, (SPC), OR 100% INSPECTION ON X PARAMETERS.</p> <p>5.3.3 PRODUCTION LOT SAMPLES MUST DEMONSTRATE A Cpk VALUE OF 1.33 OR HIGHER. IF THE Cpk DROPS BELOW 1.33 AT ANY TIME DURING THE MANUFACTURE OF THIS PART, THEN THE SUPPLIER MUST 100% SCREEN ALL THOSE PARTS TO THOSE SPECIFIED CRITICAL PARAMETERS.</p> <p>5.4 FIRST ARTICLE:</p> <p>5.4.1 FIRST ARTICLE VERIFICATION IS REQUIRED PRIOR TO INITIAL TOOL APPROVAL OR APPROVAL OF A TOOLING CHANGE. FIRST ARTICLE SHALL BE VERIFIED BY A RUN OF AT LEAST 100 PIECES UNDER CONDITIONS REPRESENTATIVE OF PRODUCTION.</p> <p>5.5 DIMENSIONAL REPORT:</p> <p>5.5.1 CRITICAL PARAMETER CONFORMANCE MUST BE DEMONSTRATED BY INSPECTION OF AT LEAST 30 PIECES, PER CAVITY, FROM THE FIRST ARTICLE RUN. ALL DRAWING DIMENSIONS MUST BE MEASURED ON AT LEAST 5 PARTS, PER CAVITY, OF THE FIRST ARTICLE RUN. A DIMENSIONAL REPORT MUST BE SUBMITTED TO SIERRA WIRELESS ALONG WITH THE MEASURED PARTS.</p> <p>6. PACKAGING:</p> <p>6.1 PARTS SHALL BE CLEAN AND INDIVIDUALLY PACKGED IN A POLYBAG</p> <p>7. EXCEPTIONS:</p> <p>7.1 NO CHANGE SHALL BE ALLOWED ON PRODUCTION MATERIAL, REGARDLESS OF WHETHER SUCH CHANGE AFFECTS REQUIREMENTS SPECIFIED, WITHOUT PRIOR EXPLICIT WRITTEN APPROVAL BY SIERRA WIRELESS MECHANICAL ENGINEERING GROUP.</p> <p>11 NOTES APPLICABLE TO CONTRACT MANUFACTURER</p> <p>1. INCOMING INSPECTION DIMENSION MARKED BY XX.XX</p> <p>2. SAMPLE INSPECTION PER ANSI/ASQ Z1.4 LEVEL 2, AQL=0.25, C=0 OR OTHERWISE ACCEPTED BY SWI QUALITY REP IN PROCESS CONTROL PLAN.</p> <p>3. CONTRACT MANUFACTURER SHALL REQUIRE PART MANUFACTURER TO PROVIDE SPC DATA AND REVIEW WITH SIERRA WIRELESS MECHANICAL ENGINEERING GROUP</p> | | | | | | | | REV | DESCRIPTION | | | | | | ECO | DATE | | DRAWN | APPD | | |
| | | | | | | | | A | RELEASE FOR DESIGN FEEDBACK ONLY | | | | | | | MAY 10 2016 | | SM | | | |
| | | | | | | | | 1 | 1. REV UPDATED FROM "A" TO "1" 2. KEYHOLES HAS BEEN MOVED (S2) 3. DRAWING NUMBER CHANGE FROM 1301034-B TO 1301034 | | | | | | | MAY 30 2016 | | SM | | | |
| | | | | | | | | 2 | 1. ADDED SLOT TO ONE KEYHOLE (S2) 2. REMOVE ONE CENTER HOLE (S2) 3. ADDED RADIUS CUTOUT (S3) 4. MINOR GEOMETRY UPDATE | | | | | | | JUN 1 2016 | | SM | | | |
| | | | | | | | | 3 | 1. ADDED NOTE 3.4, SHEET TWO D-7 GTOL 0.60 WAS 0.25 2. ADDED DIMENSION (C1, S3) 3. UPDATED DETAIL C (S3) 4. ADDED DIMENSION (C6, S3) | | | | | | | JULY 27 2016 | | SM | | | |
| | | | | | | | | 4 | NOTE 6.1 UPDATED | | | | | | | AUG 19 2016 | | WT | | | |
| | | | | | | | | 5 | UPDATED TOLERANCES (B3,S3;C3,S3;C2,S3;C1,S3;IN TITLE BLOCK) | | | | | | | SEP 13 2016 | | WM | | | |
| | | | | | | | | 6 | DESIGN UPDATED - PLEASE REFER TO 6 REFERENCE MARKERS. | | | | | | | NOV 3 2016 | | SM | | | |
| | | | | | | | | 7 | TOLERANCE UPDATED - PLEASE REFER TO 7 REFERENCE MARKERS. | | | | | | | NOV 3 2016 | | SM | | | |
| | | | | | | | | <div><div><div>NOTE 4.5</div><div>PART NUMBER & REV</div></div></div> | | | | | | | | PROJECT NAME MG90 | | | | | |
| DRWN S.MAR | | | | DATE 04/14/16 | | <div><div>13811 Wireless Way Richmond, British Columbia Canada, V6V 3A4 Tel: 604.231.1100 Fax: 604.231.1109</div></div> | | | | | | | | | | | | | | | |
| DES ENGR S.MAR | | | | DATE 04/14/16 | | | | | | | | | | | | | | | | | |
| CHK (Checked By) | | | | DATE XX/XX/XX | | SIZE B | | | | | | | | | | UNITS MM | | DRAWING NO. 1301034 | | REV 7 | |
| PRT FILENAME 1301034 | | | | DRW FILENAME 1301034 | | RELEASE LEVEL *** | | | | | | | | | | SCALE: 0.250 | | SHEET 1 OF 3 | | | |
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| INCHES .X ± .05 .XX ± .01 .XXX ± .005 | | | | MM .X ± .25 .XX ± .13 .XXX ± .05 | | ANGLES X ± 5° X.X ± 1° | | | | | | | | | | | | | | | |
| MATERIAL SEE NOTES | | | | SEE NOTES | | | | | | | | | | | | | | | | | |
| FINISH SEE NOTES | | | | DO NOT SCALE PRINT | | | | | | | | | | | | | | | | | |



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