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NOTES:

1. MECHANICAL REQUIREMENTS:

- Grease, oil and dirt to be removed. (except in parting lines) unless otherwise specified.
- Dimensions of the unspecified features in 3D MASTER DATA to be followed
- General tolerance accuracy defined in title block unless otherwise specified
- All numbered dimensions marked by symbol (X) must be measured and reported from 3-5 samples from each cavity when requested. It is recommended to use iLOQ measuring report template.
- If any measuring point are unclear, correct measuring points to be checked and confirmed with designer.

2. SPECIFICATIONS AND OTHER DOCUMENTS:

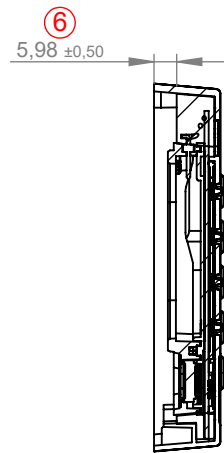
- DFM report to be submitted by manufacturer to iLoq and must be approved by design responsible before tooling starts.
- FAI report to be submitted by manufacturer to iLoq from tooling samples and must be approved by design responsible before mass production starts.
- Cpk report to be submitted by manufacturer to iLoq from preproduction order (min. qty. 200 pcs) and must be approved by design responsible before mass production starts.

3. OTHER REQUIREMENTS:

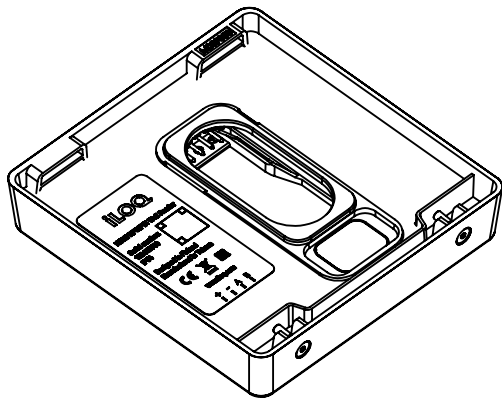
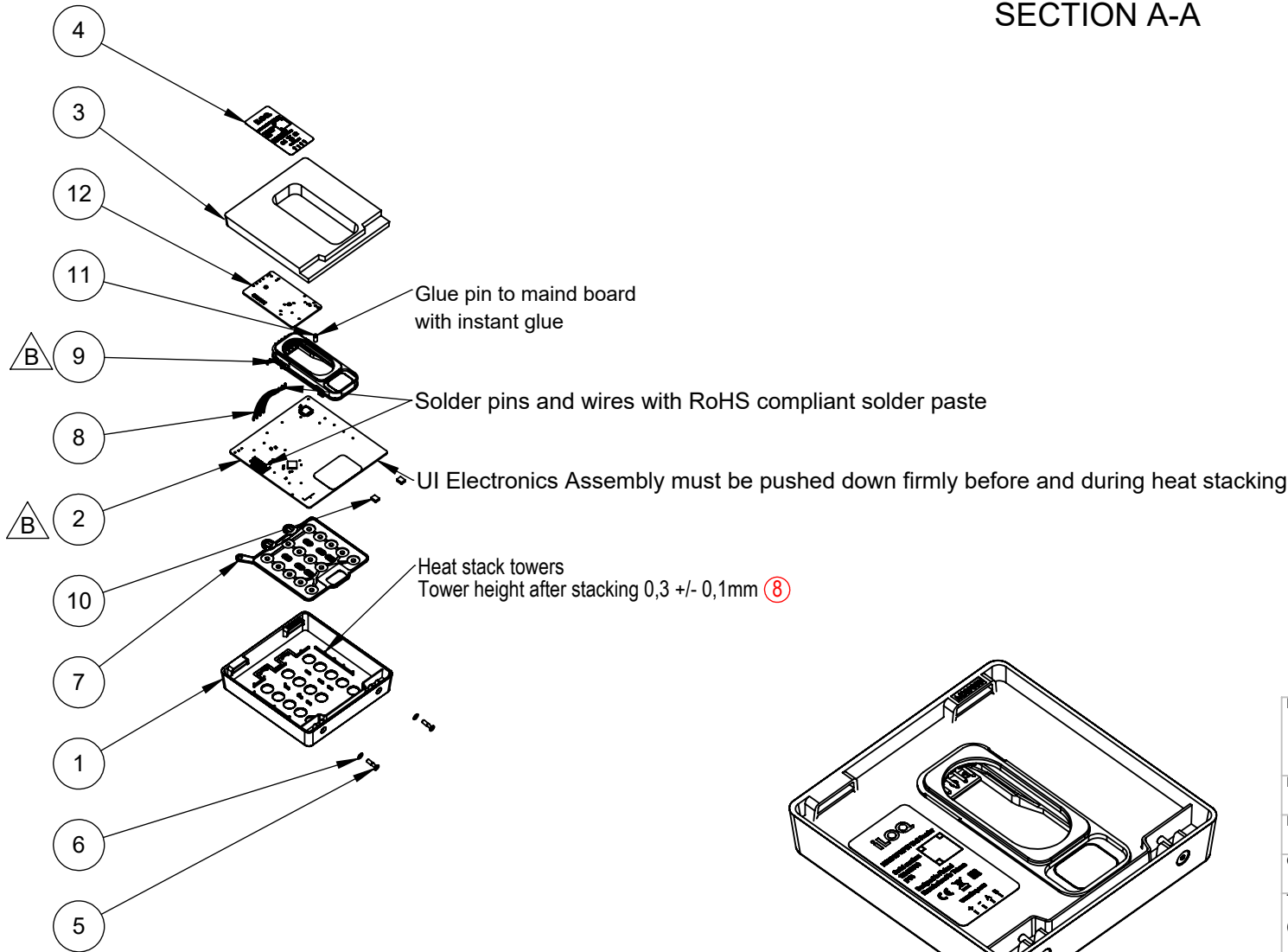
- Dimensions marked by symbol $\bigcirc$, Process capability (Cpk) to be proved
 - Quantity of numbers:3pcs
- Dimensions marked by symbol $\bullet$, Continuous statistical process capability (SPC) to be proven
 - Quantity of numbers:
- Dimensions marked by symbol $\blacklozenge$, Dimension will be measured in IQC.
 - Quantity of numbers:3pcs
- Cpk requirement >1,33
- Part package shall provide protection during transport, handling and storing.

4. EXEMPTIONS

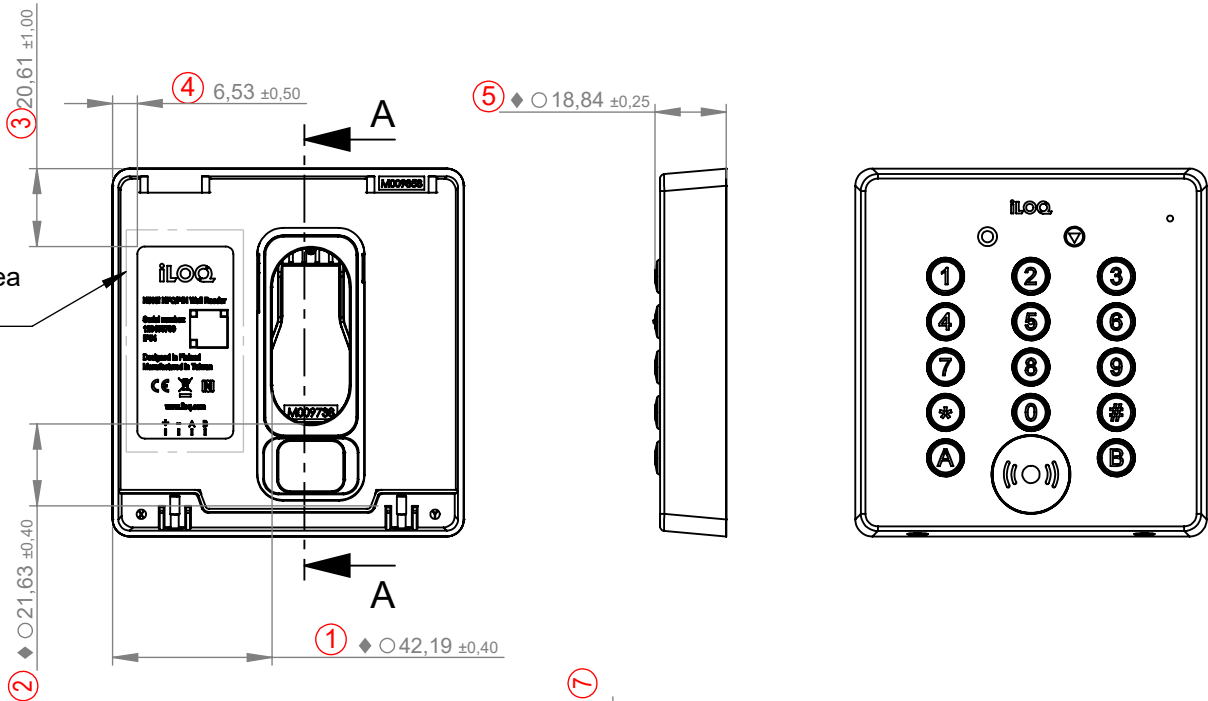
No changes allowed on part without written approval by iLoq design responsible person



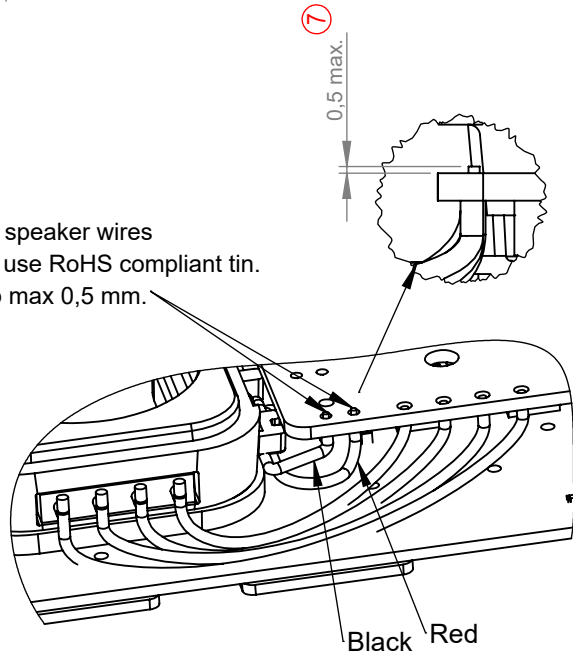
SECTION A-A



Rev.	Description	Designer
B	Item 2 and 9 modified.	Janne Virta 21-11-2023



Solder M014803 speaker wires to E2159 PCBA, use RoHS compliant tin. Wire / tin overlap max 0,5 mm.



Material: (+delivery state)		Design: Sami Tuominen 26-04-2022	 All rights reserved. Copyright © 2022 iLOQ Oy www.iloq.com
Part postprocessing:		Chec'd: Artturi Mantila 24-11-2023	
Plating / Coating:		Appr'd: Timo Savikoski 01-12-2023	
Color:		Based on: M014835_A-Wall Reader Assembly	
Surface Texture / Roughness:		Description:	Name: Wall Reader Assembly Status: Released Drawing number: M014835 Rev. B
Tolerance:		Metric: mm	
General tol. acc. ISO2768-1 m			
Size ISO 14405 (E)			
Geometric tol. symbols acc. ISO1101:2017		Size: A3	
Surface rough. symbols acc. ISO1302:2002		Sheet: 1/1	