

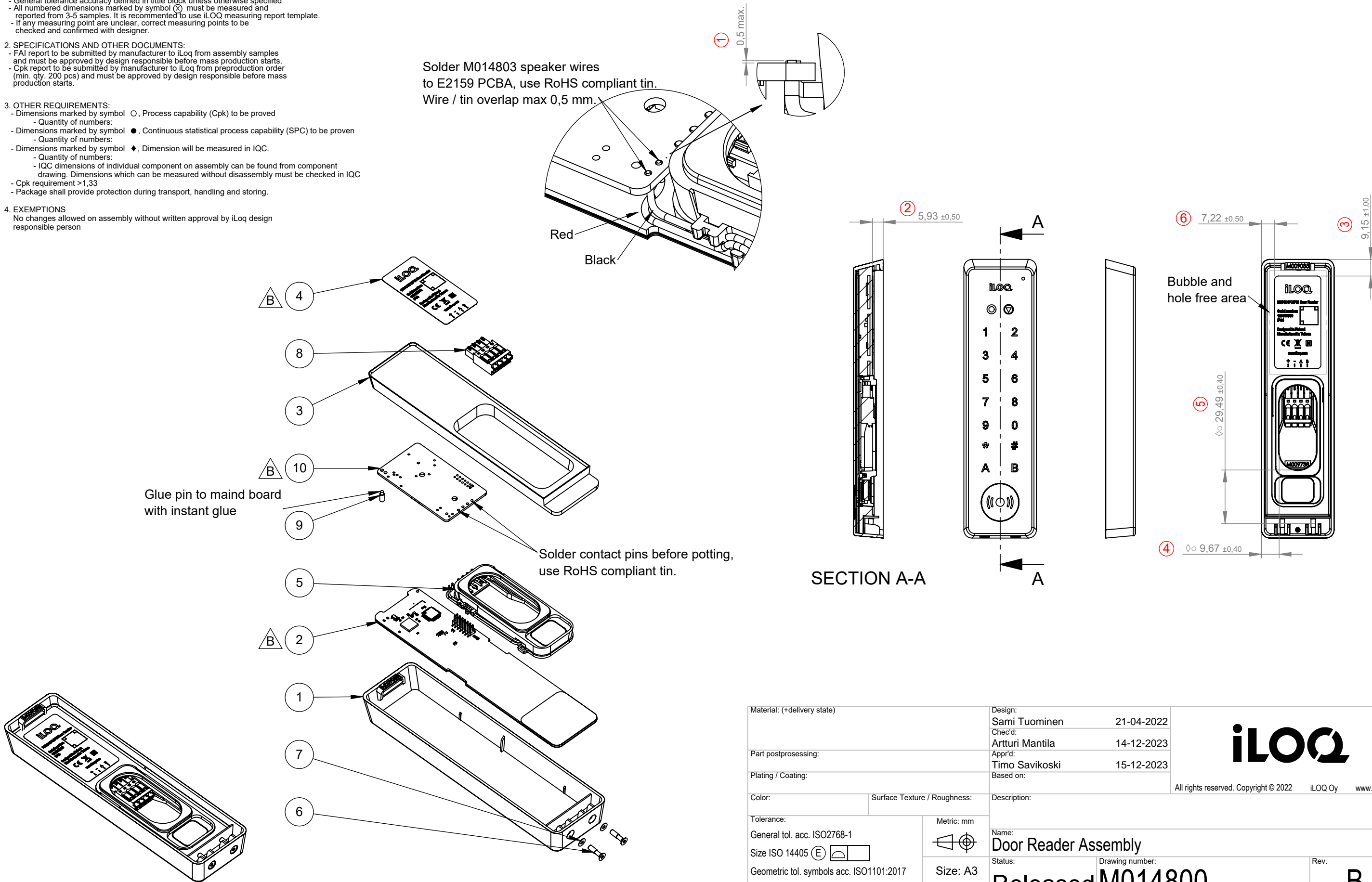
Rev.	Description	Designer
B	Item 2 ,4 and 10 modified.	Janne Virta 01-12-2023


NOTES:

1. MECHANICAL REQUIREMENTS:
  - Grease, oil and dirt to be removed.
  - No flash or burr allowed 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  $\otimes$  must be measured and reported from 3-5 samples. It is recommended to use iLOQ measuring report template.
  - If any measuring point is unclear, correct measuring points to be checked and confirmed with designer.
2. SPECIFICATIONS AND OTHER DOCUMENTS:
  - FAI report to be submitted by manufacturer to iLoq from assembly 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:
  - 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:
    - IQC dimensions of individual component on assembly can be found from component drawing. Dimensions which can be measured without disassembly must be checked in IQC
  - Cpk requirement >1,33
  - Package shall provide protection during transport, handling and storing.
4. EXEMPTIONS

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

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



Material: (+delivery state)		Design: Sami Tuominen 21-04-2022		
Part postprocessing:		Chec'd: Artturi Mantila 14-12-2023		
Plating / Coating:		Appr'd: Timo Savikoski 15-12-2023		
		Based on:		
Color:	Surface Texture / Roughness:	Description:		All rights reserved. Copyright © 2022 iLOQ Oy www.iloo.com
Tolerance:		Name:		
General tol. acc. ISO2768-1		Door Reader Assembly		
Size ISO 14405 (E) 		Status:		
Geometric tol. symbols acc. ISO1101:2017		Drawing number:		
Surface rough. symbols acc. ISO1302:2002		Rev.		
Metric: mm		Released		
Size: A3		M014800		
Sheet: 1/1		B		