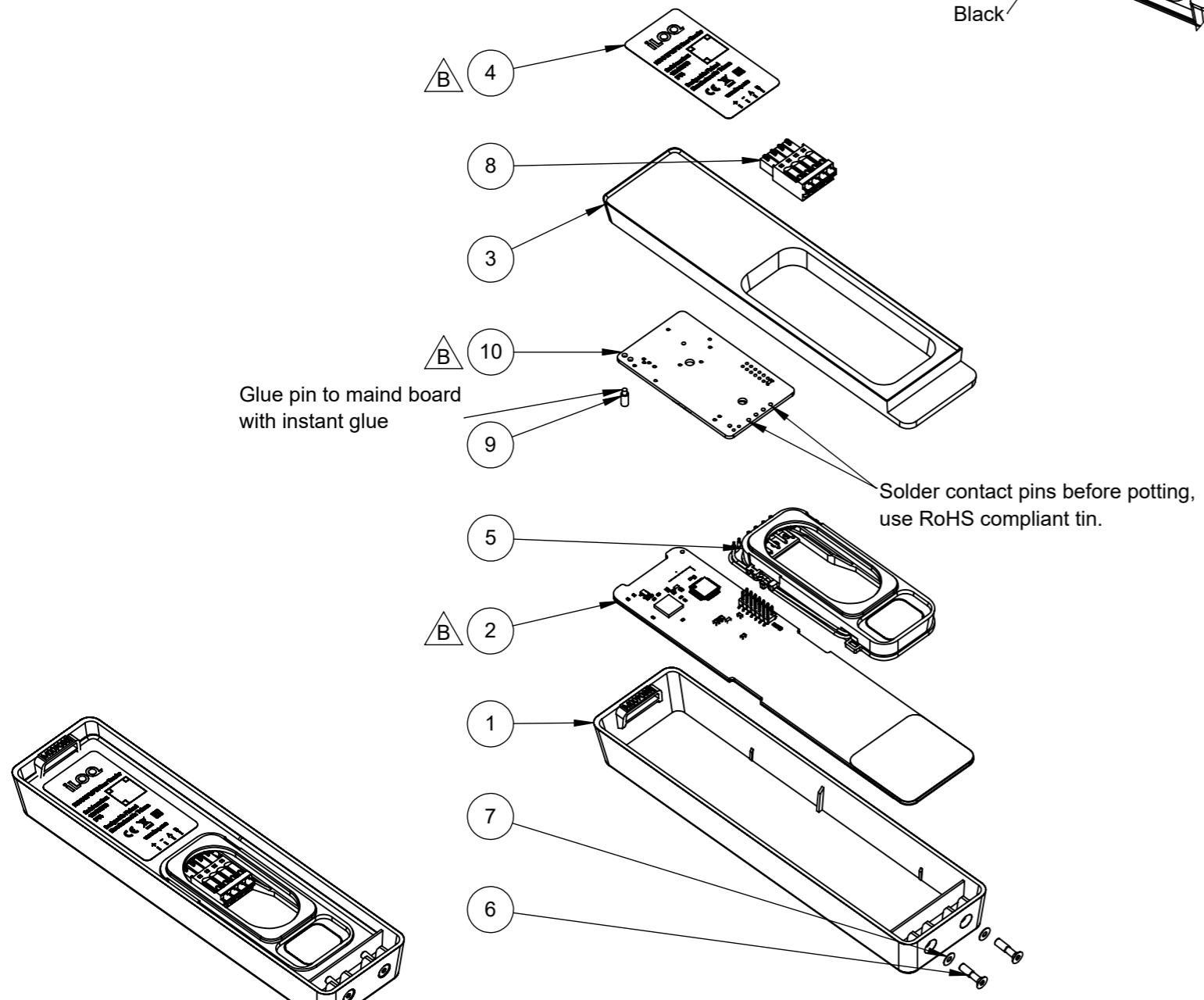


NOTES:  
 1. MECHANICAL REQUIREMENTS:  
 - Grease, oil and dirt to be removed.  
 - No flash or burr allowed unless otherwise specified.  
 - Dimensions of the unspecified features in 3D MASTER DATA to be followed  
 - General tolerance accuracy defined in title block unless otherwise specified  
 - All numbered dimensions marked by symbol  $\odot$  must be measured and reported from 3-5 samples. 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.

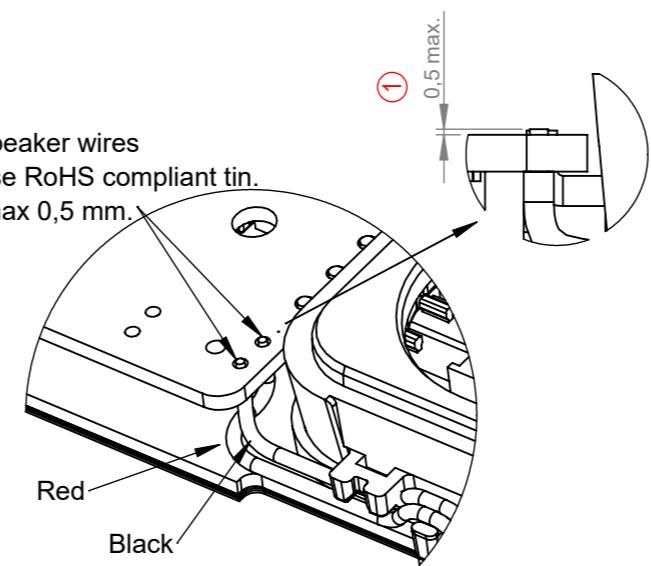
2. SPECIFICATIONS AND OTHER DOCUMENTS:  
 - FAI report to be submitted by manufacturer to iLOQ from assembly samples and must be approved by design responsible before mass production starts.  
 - Cpk report to be submitted by manufacturer to iLOQ from preproduction order (min. qty. 200 pcs) and must be approved by design responsible before mass production starts.

3. OTHER REQUIREMENTS:  
 - Dimensions marked by symbol  $\odot$ , 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  $\diamond$ , 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.

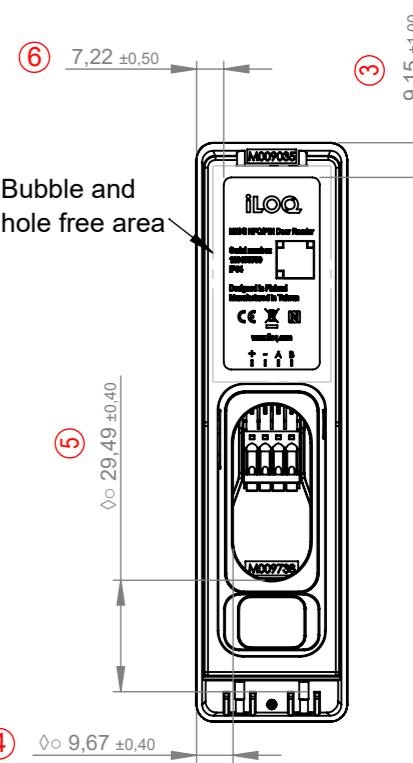
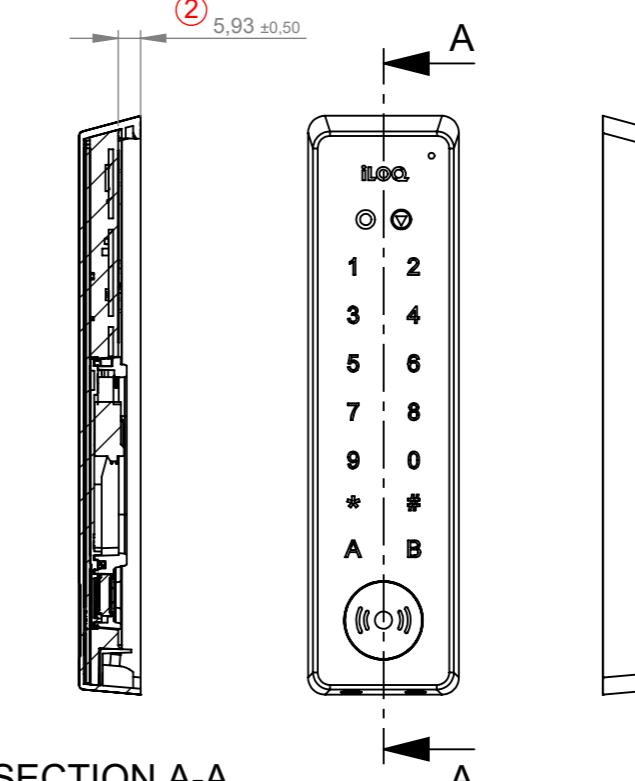
4. EXEMPTIONS  
 No changes allowed on assembly without written approval by iLOQ design responsible person



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



SECTION A-A



Material: (+delivery state)	Design: Sami Tuominen 21-04-2022
Part postprocessing:	Chek'd: Arttu Mantila 14-12-2023
Plating / Coating:	App'd: Timo Savikoski 15-12-2023
Color:	Based on:
Surface Texture / Roughness:	Description:
Tolerance:	Name: Door Reader Assembly
General tol. acc. ISO2768-1	Status: Released
Size ISO 14405 (E)	Drawing number: M014800
Geometric tol. symbols acc. ISO1101:2017	Rev. B
Surface rough. symbols acc. ISO1302:2002	Sheet: 1/1

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