



- SCREEN PRINT TO BE DONE ON THE COSMETIC SURFACE OF WHISTLE HEALTH LIMITED BOTTOM COVER (112-30184-00-02).
- ALL UNSPECIFIED TOLERANCES SHOULD FOLLOW THE DOCUMENT TOLERANCE GUIDLINE MATCHING THE PROVIDED 2D FILE.
- COLOR: PANTONE WARM GRAY 2C
- QUALITY ASSURANCE REQUIREMENTS:
 - DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994.
 - THE SUPPLIER MUST DEVELOP A QUALITY ASSURANCE PLAN TO ENSURE CRITICAL PARAMETER COMPLIANCE, AND THE PLAN MUST BE APPROVED.
 - THE SUPPLIER MUST MAINTAIN STATISTICAL PROCESS CONTROL (SPC) OR 100% INSPECTION ON ALL OVAL DIMENSIONS AND MAINTAIN A Cpk OF 1.33 OR HIGHER.
 - FIRST ARTICLE INSPECTION OF ALL DIMENSIONS ON AT LEAST 30 PARTS IS REQUIRED PRIOR TO INITIAL TOOL OR PROCESS APPROVAL, OR APPROVAL OF A TOOLING CHANGE. A DIMENSIONAL REPORT MUST BE SUBMITTED ALONG WITH THE MEASURED PARTS.
 - DURING IQC, THE CM MUST SPC OR 100% INSPECT ALL OVAL DIMENSIONS.
- PART COSMETICS AND CLEANLINESS:
 - FINISHED PARTS MUST BE FREE OF OBVIOUS DEBRIS, DIRT, DUST, LINT, FIBERS, STAINS, FINGER OILS, WAX, AND CHEMICAL FILMS.
 - PARTS MUST NOT BE SCRATCHED, DENTED, OR OTHERWISE DAMAGED BOTH BEFORE AND AFTER SHIPPING.
 - EXTERNAL COSMETIC SURFACE

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UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN mm TOLERANCES: x ± 0.10, .xx ± 0.100, Angles: ±0.5		DRAWN BD	NAME BD	DATE 082222	Kinship TITLE: Whistle Health Limited Completed Frame... Screen Print
INTERPRET GEOMETRIC TOLERANCING PER: MATERIAL NA	CHECKED	ENG APPR.	MFG APPR.	Q.A. COMMENTS:	
NEXT ASSY	USED ON	FINISH	SPECIFIED	SCALE: 10:1	WEIGHT:
APPLICATION		DO NOT SCALE DRAWING		SIZE D	DWG. NO. 112-30189-00-02_Print_080822
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