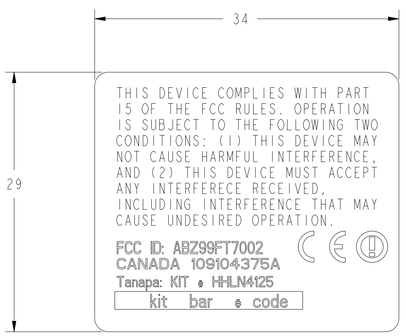
DRAWING NUMBER
5485842M



SCALE 3/1

SCALE 1/1

1. DESCRIPTION AND APPLICATION: LABEL FOR USE IN PORTABLE COMMUNICATION EQUIPMENT.

2. APPLICABLE DOCUMENTS:
   12M05022A33 MOTOROLA QUALIFICATION PROCEDURE
   12M80967A78 MOTOROLA VENDOR MATERIAL QUALITY CONTROL
   12S10301A MOTOROLA ADHESIVE BONDED MATERIAL
   12S10334A MOTOROLA APPEARANCE STANDARD
   12S10601A MOTOROLA PACKAGING RULES FOR VENDORS
   ANSI Y14.5M-1982 DIMENSIONING AND TOLERANCING FOR ENGRG DWGS

3. REQUIREMENTS:
   3.1. GENERAL:
   3.1.1. PARTS SHALL BE CLEAN AND FREE OF ALL FOREIGN MATTER.
   3.1.2. PARTS SHALL BE FREE OF FRAYED AND RAGGED EDGES.
   3.1.3. SAMPLE PARTS SHALL BE SUBMITTED TO MOTOROLA FOR APPROVAL BEFORE PROCEEDING WITH PRODUCTION RUN.
   3.1.4. PURCHASING CYCLE SHALL NOT EXCEED (6) MONTHS SUPPLY TO AVOID ADHESIVE CURE IN STORAGE BEFORE USE.
   3.1.5. VENDOR SHALL SUPPLY WRITTEN CERTIFICATION (WITH EACH PACKAGE) OF DATE OF PURCHASE OF SHEET STOCK CERTIFICATE DATE SHALL BE NO MORE THAN (6) MONTHS PRIOR TO RECEIPT OF PARTS.
   3.1.6. DIMENSIONING AND TOLERANCING PER ANSI Y14.5.
   3.1.7. PACKAGING FOR SHIPMENT: 12S10601A AND EIA556-A.
   3.1.7.1. PARTS SUPPLIED ON ROLLS 1000-2000 PARTS PER ROLL (MANUAL PLACEMENT). DATE CODE, PART NUMBER AND ISSUE LETTER SHALL BE MARKED ON PACKAGE (HUMAN READABLE AND BAR CODED).
   3.1.7.2. SPECIAL PACKAGING REQUIREMENTS PER 12M05041A53 FOR PARTS ORDERED BY A 13 DIGIT PART NUMBER.
   3.1.8. LETTERING AND BORDER TO BE BLACK ON WHITE BACKGROUND.
   3.1.8.1. LETTERING TO BE 3.2MM TALL X 1.5MM WIDE.
   3.2. MATERIALS:
   3.2.1. MATERIAL: UARCO 1242 OR EQUIVALENT, RAW MATERIAL FROM P/N 5480948X01, ROLLED WITH CARDBOARD CENTER.
   3.2.2. ADHESIVE MATERIAL: PERMANENT SENSITIVE TYPE WITH PEEL OFF BACK PER 12S10301A METHOD 3C.
   3.2.2.1. ADHESIVE STRENGTH: TEST PARA. 3E, 3F AND 3G. (2.0 LBS/IN. MIN.)
   3.2.2.2. SHALL NOT ATTACK POLYCARBONATE.
   3.2.2.3. MINIMUM SHELF-LIFE BEFORE CURING OCCURS: (1) YEAR FROM DATE OF CERTIFICATION.
   3.2.2.4. RATE OF FORCE APPLICATION: 1 LB/SEC MAXIMUM.
   3.2.3. BACKING MATERIAL: PAPER, TREATED FOR EASY PEEL-OFF FROM ADHESIVE.

4. VENDOR QUALITY ASSURANCE PROVISIONS: PER 12M80967A78 AND 12M05022A33.
   4.1. PART QUALIFICATION: VENDOR SHALL MEASURE DATA ON (5) RANDOMLY SELECTED PIECES, PER CAVITY IF MULTIPLE, FOR ALL DIMENSIONS OR PARAMETERS. DATA SHALL BE SUBMITTED IN PLOTTED DISTRIBUTION FORM TO RADIUS ENGINEERING AND/OR PURCHASING DEPARMENT.
   4.2. PRODUCTION LOTS: VENDOR SHALL MEASURE DIMENSIONS OR PARAMETERS ON A MINIMUM OF (5) RANDOMLY SELECTED PARTS FROM THE LOT FOR DIMENSIONS OR PARAMETERS MARKED AS CRITICAL CHARACTERISTICS. DATA MUST BE INCLUDED AND PARTS MEASURED IDENTIFIED WITH THE LOT SHIPPED TO MOTOROLA.

5. EXCEPTIONS: NO CHANGE SHALL BE ALLOWED ON PRODUCTION MATERIAL. REGARDLESS OF WHETHER SUCH CHANGE AFFECTS REQUIREMENTS SPECIFIED. WITHOUT PRIOR EXPLICIT WRITTEN APPROVAL BY MOTOROLA ENGINEERING AND PURCHASING DEPARTMENTS.

3rd ANGLE PROJECTION

REV	DESCRIPTION	MEMO
0	RELEASED FOR PRODUCTION	EV 1193 05/01
A	REMOVED TABLE ADDED INFO TO MAIN VIEW ADDED INDUSTRY CANADA NUMBER	ECN 4018 06/01

PART NUMBERS
5485842M01

DEVELOPMENT IDENTIFICATION CODE
prjaccessories
5485842M_01-LABEL-ADAPTER

APC	NPR	UNITS
742	N/A	MM

DRAWN BY	DATE	DESIGNED BY	DATE
DIAZ A.	05/08/01	R. GRANT	

APPROVED BY	DATE	TOOLING ENGINEER
J.ST.PIERRE		

SCALE	SHEET
1/1 (DO NOT SCALE DRAWING)	1 OF 1

DRAWING DESCRIPTION
LABEL ADAPTER

DRAWING NUMBER
5485842M

QUALITY ASSURANCE SAMPLE PLAN PER 12M80967A78
☒ X-BAR-R PROCESS CONTROL CHARTS REQUIRED WITH EACH SHIPMENT
☐ CRITICAL DIMENSIONS THAT AFFECT FORM, FIT OR FUNCTION

TOLERANCES UNLESS OTHERWISE SPECIFIED		
ONE PLACE DECIMAL	.X	± 3.2
TWO PLACE DECIMAL	.XX	± 1.5
HOLE DIA. VARIATION	.XX	± .08
ANGULAR DIMENSION	(DEG)	± 1°

MOTOROLA

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JAN 01