

1 NOTES APPLICABLE TO PART MANUFACTURER

1. DESCRIPTION AND APPLICATION: BRACKET TO BE USED IN WIRELESS DEVICE

2. APPLICABLE DOCUMENTS:

ASME Y14.5M-1994 GEOMETRIC DIMENSIONING AND TOLERANCING
 DOC NO. 2140122 SIERRA WIRELESS - GENERAL COSMETIC SPECIFICATION
 MOUNT COMPONENTS FOR AUTOMATIC HANDLING IF APPLICABLE

3. MATERIAL AND TOOLING REQUIREMENTS:

- 3.1 MATERIAL: 304-1/2H STAINLESS STEEL
- 3.2 THICKNESS: 0.80mm +/- 0.05
- 3.3 PASSIVATE PER ASTM A-967
- 3.4 COMPLETE TOOL DRAWINGS TO BE SUBMITTED TO SIERRA WIRELESS MECHANICAL ENGINEERING GROUP FOR APPROVAL.
- 3.5 THE PART SHALL CONTAIN NO HAZARDOUS SUBSTANCES PER THE WASTE ELECTRICAL AND ELECTRONIC EQUIPMENT (WEEE) 2002/96/EC RoHS DIRECTIVE.

4. MECHANICAL REQUIREMENTS:

- 4.1 CONTROLLING GEOMETRY IS DEFINED BY THE 3D PRO/ENGINEER DATABASE. ALL SURFACES TO BE WITHIN 0.10mm OF DATABASE UNLESS OTHERWISE SPECIFIED. WHEREVER A CONFLICT EXISTS BETWEEN THE DRAWING AND THE DATABASE, THE DRAWING SHALL TAKE PRECEDENCE.
- 4.2 DIMENSIONING AND TOLERANCING PER ASME Y14.5M-1994
- 4.3 A REFERENCE DIMENSION IS USED FOR INFORMATIONAL PURPOSES ONLY AND HAS NO TOLERANCE. IT IS DESIGNATED BY: (XX.XX).
- 4.4 MAXIMUM BURR HEIGHT: 0.13mm. NO LOOSE BURRS PERMITTED.
- 4.5 ALL INSIDE BEND RADIUS NOT SHOWN SHALL BE 0.13mm.
- 4.6 ALL FILLETS AND ROUNDS NOT SHOWN SHALL BE 0.15mm.
- 4.7 DRAFT ANGLES SHALL BE PER THE 3D PART MODEL UNLESS OTHERWISE SPECIFIED.
- 4.8 MIN RADIUS SHALL BE 0.13mm FOR ALL UNMARKED FILLETS AND RADIUS, UNLESS OTHERWISE SPECIFIED.

5. QUALITY ASSURANCE REQUIREMENTS:

- 5.1 ALL DIMENSIONS INDICATED ON DRAWING ARE CRITICAL TO FORM, FIT, OR FUNCTION.
- 5.2 DIMENSIONS INDICATED WITH A [X] SYMBOL DENOTE QUALITY PROCESS CONTROL, (QPC), DIMENSIONS.
- 5.3 QUALITY ASSURANCE PLAN:
 - 5.3.1 THE SUPPLIER MUST DEVELOP A QUALITY ASSURANCE PLAN TO ENSURE CRITICAL PARAMETER COMPLIANCE. THE PLAN MUST BE SUBMITTED TO SIERRA WIRELESS FOR REVIEW.
 - 5.3.2 THE SUPPLIER MUST MAINTAIN STATISTICAL PROCESS CONTROL, (SPC), OR 100% INSPECTION ON [X] PARAMETERS.
 - 5.3.3 PRODUCTION LOT SAMPLES MUST DEMONSTRATE A Cpk VALUE OF 1.33 OR HIGHER. IF THE Cpk DROPS BELOW 1.33 AT ANY TIME DURING THE MANUFACTURE OF THIS PART, THEN THE SUPPLIER MUST 100% SCREEN ALL THOSE PARTS TO THOSE SPECIFIED CRITICAL PARAMETERS.
- 5.4 FIRST ARTICLE:
 - 5.4.1 FIRST ARTICLE VERIFICATION IS REQUIRED PRIOR TO INITIAL TOOL APPROVAL OR APPROVAL OF A TOOLING CHANGE. FIRST ARTICLE SHALL BE VERIFIED BY A RUN OF AT LEAST 50 PIECES UNDER CONDITIONS REPRESENTATIVE OF PRODUCTION.
- 5.5 DIMENSIONAL REPORT:
 - 5.5.1 CRITICAL PARAMETER CONFORMANCE MUST BE DEMONSTRATED BY INSPECTION OF AT LEAST 30 PIECES, PER CAVITY, FROM THE FIRST ARTICLE RUN. ALL DRAWING DIMENSIONS MUST BE MEASURED ON AT LEAST 5 PARTS, PER CAVITY, OF THE FIRST ARTICLE RUN. A DIMENSIONAL REPORT MUST BE SUBMITTED TO SIERRA WIRELESS ALONG WITH THE MEASURED PARTS.

6. PACKAGING:

6.1 PARTS SHALL BE PACKAGED IN REUSEABLE, DIVIDED BOXES OF 100 TO 200 PARTS PER BOX

7. EXCEPTIONS:

7.1 NO CHANGE SHALL BE ALLOWED ON PRODUCTION MATERIAL, REGARDLESS OF WHETHER SUCH CHANGE AFFECTS REQUIREMENTS SPECIFIED, WITHOUT PRIOR EXPLICIT WRITTEN APPROVAL BY SIERRA WIRELESS MECHANICAL ENGINEERING GROUP.

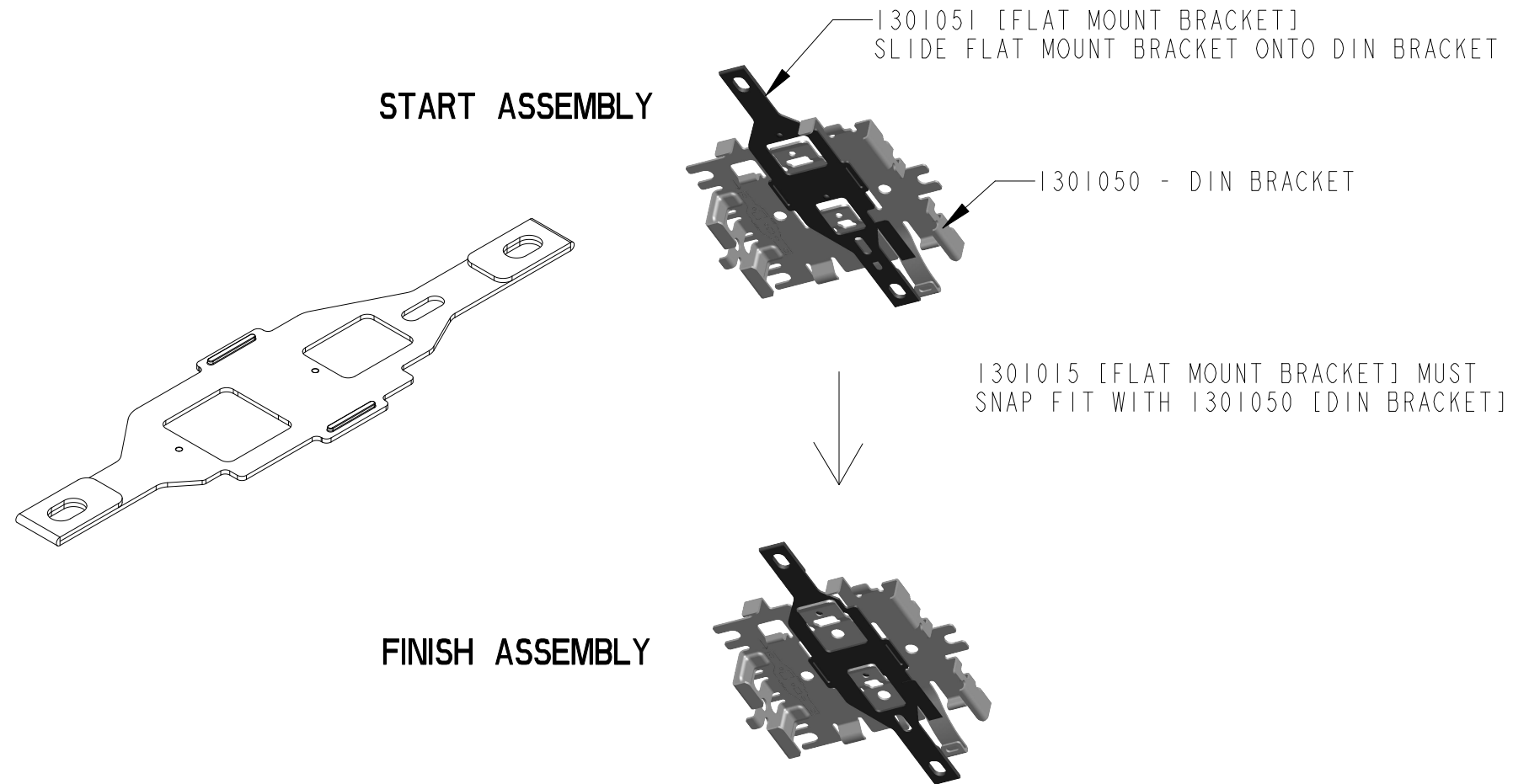
11 NOTES APPLICABLE TO CONTRACT MANUFACTURER

1. INCOMING INSPECTION DIMENSION MARKED BY (XX.XX)

2. SAMPLE INSPECTION PER QE1-11-0000-18

3. CONTRACT MANUFACTURER SHALL REQUIRE PART MANUFACTURER TO PROVIDE SPC DATA AND REVIEW WITH SIERRA WIRELESS MECHANICAL ENGINEERING GROUP

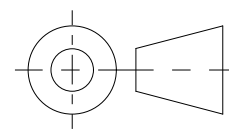
REV	DESCRIPTION	ECO	DATE	DRAWN	APPD
1	INITIAL RELEASE		AUG/2/2016	SM	
2	1. MATERIAL CHANGE FROM SUS301 TO SUS304-1/2H 2. DESIGN UPDATED TO AID MFG 3. ADDED VIEWS OF ASSEMBLY TO 1301050 - PAGE 1		2016/08/19	SM	
3	UPDATD FLATNESS TOLERANCE (S2, B4)		2016/08/24	SM	
4	DESIGN UPDATED TO EXTEND MOUNTING HOLES ϕ - ϕ TO 101.2MM		2016/08/29	SM	
5	2X SIDE VERTICAL WALL UPDATED (A6, A5, D5, C5, C4, B4, B5, SHEET 2)		2016/10/11	SM	
6	2X SIDE VERTICAL WALL UPDATED WITH DFM FEEDBACK FROM VENDOR (S2, ∇ 6)		2016/10/12	SM	
7	FLATNESS UPDATED (B3, SHEET 2) ∇ 7		2016/12/28	SM	



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UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE PER THE FOLLOWING TOLERANCES:

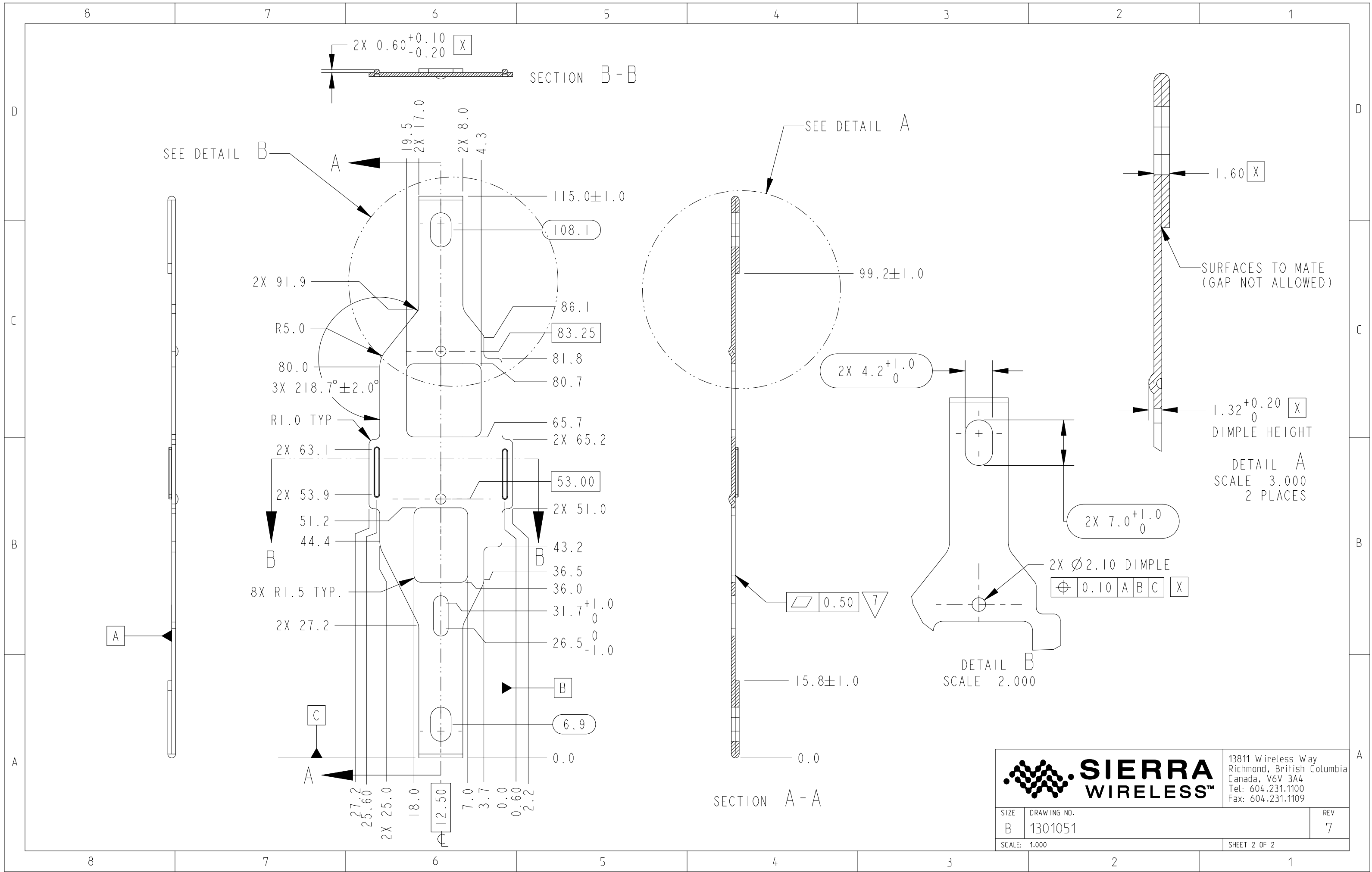
MM		ANGLES	
.X	± .50	X	±5°
.XX	± .25	X.X	±1°
.XXX	± .05		



PROJECT NAME FX30		DATE AUG/2/2016	
DRWN S.MAR	DES ENGR S.MAR	DATE AUG/2/2016	DATE
PRT FILENAME 1301051		DRAWING NO. 1301051	
DRW FILENAME 1301051		RELEASE LEVEL Development	
9		9	

PART DESCRIPTION FLAT MOUNT BRACKET (FX100)				13811 Wireless Way Richmond, British Columbia Canada, V6V 3A4 Tel: 604.231.1100 Fax: 604.231.1109
SIZE B	UNITS MM	DRAWING NO. 1301051		
SCALE: 1.000			SHEET 1 OF 2	

DO NOT SCALE PRINT



SURFACES TO MATE
(GAP NOT ALLOWED)

DETAIL A
SCALE 3.000
2 PLACES

DETAIL B
SCALE 2.000

		13811 Wireless Way Richmond, British Columbia Canada, V6V 3A4 Tel: 604.231.1100 Fax: 604.231.1109	
		SIZE B	DRAWING NO. 1301051
SCALE: 1.000		SHEET 2 OF 2	