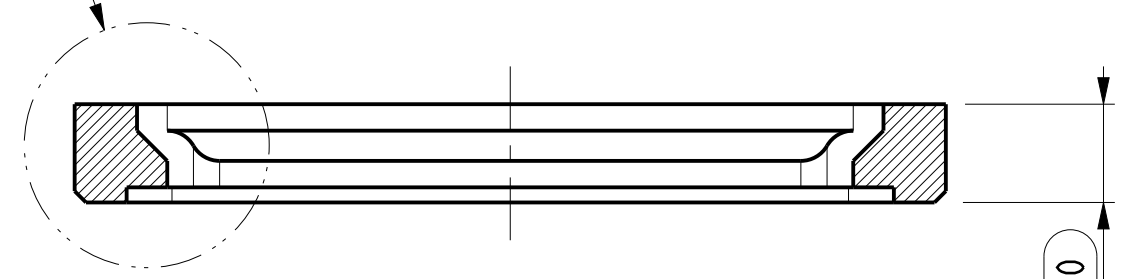


REV	DESCRIPTION	ECO	DATE	DRAWN	APPD
01	Prototype release		17 OCTO 17	JPM	PYK

SEE DETAIL A

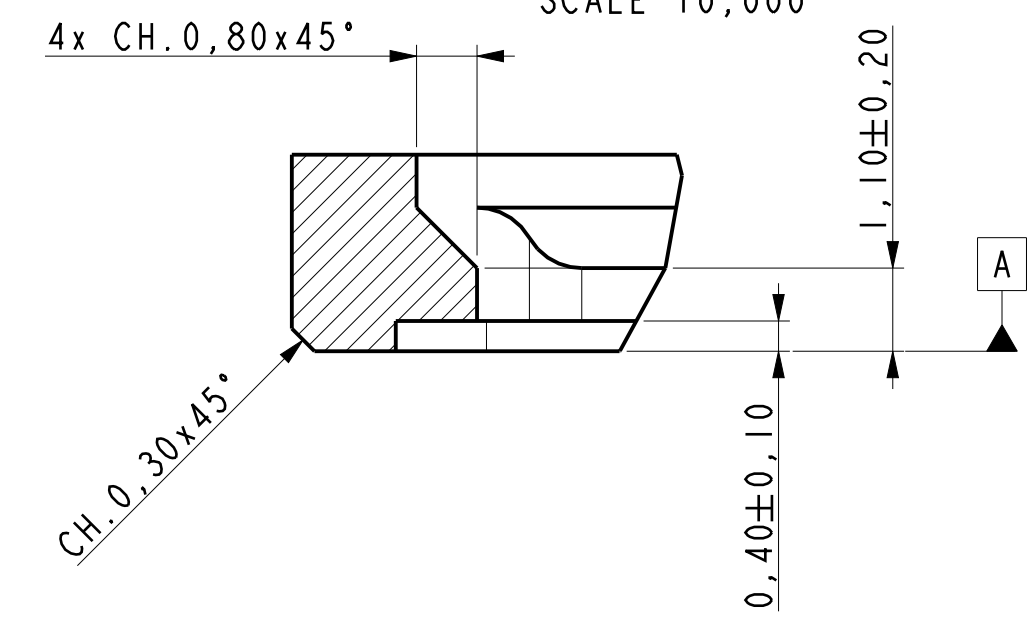


SECTION A-A

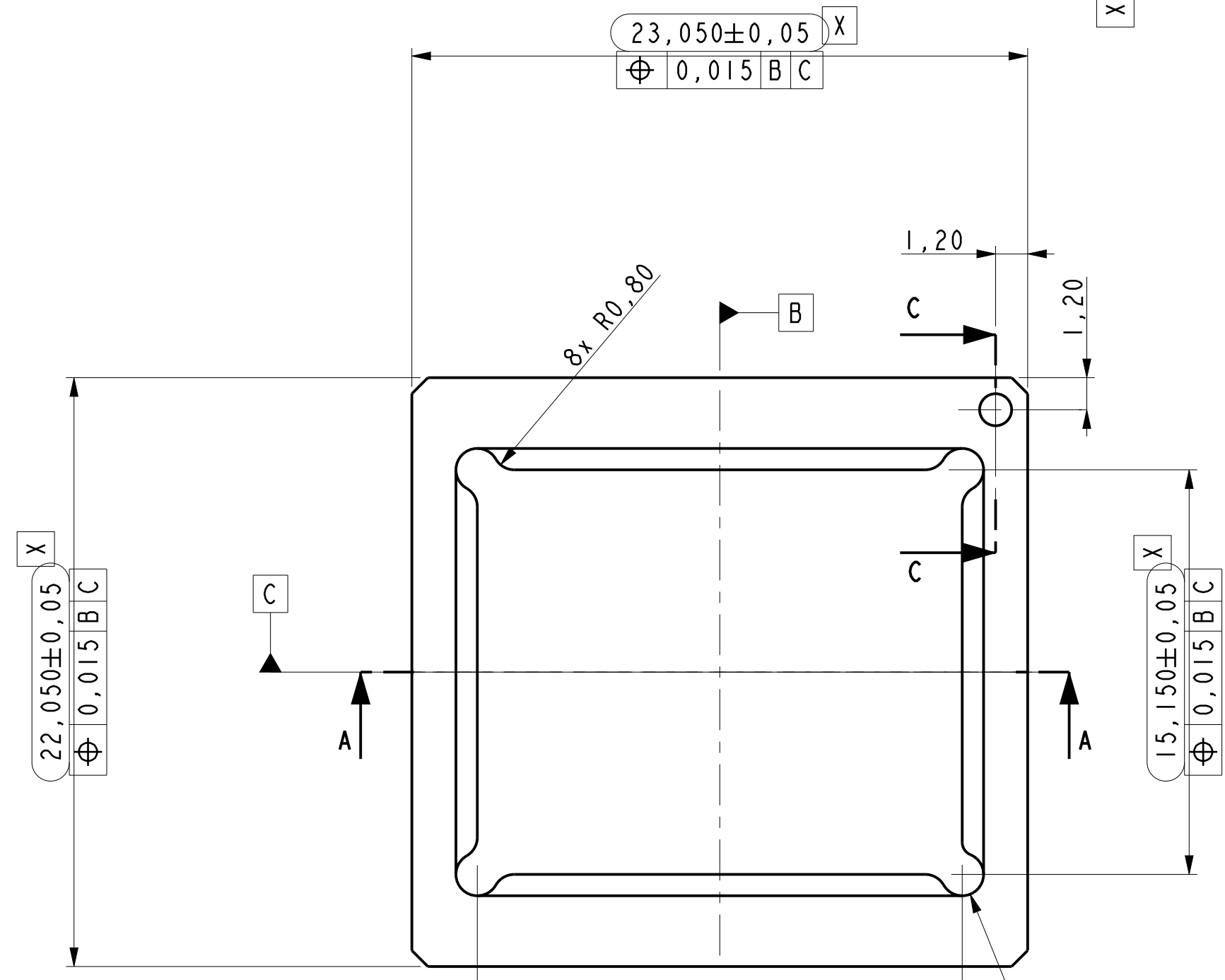
$2,60 \pm 0,10$

$23,050 \pm 0,05$
 $\oplus 0,015$ B C

DETAIL A
SCALE 10,000

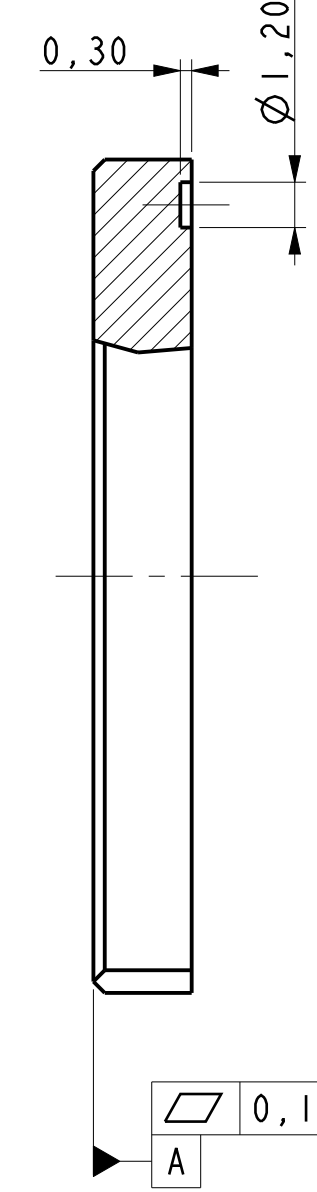


A

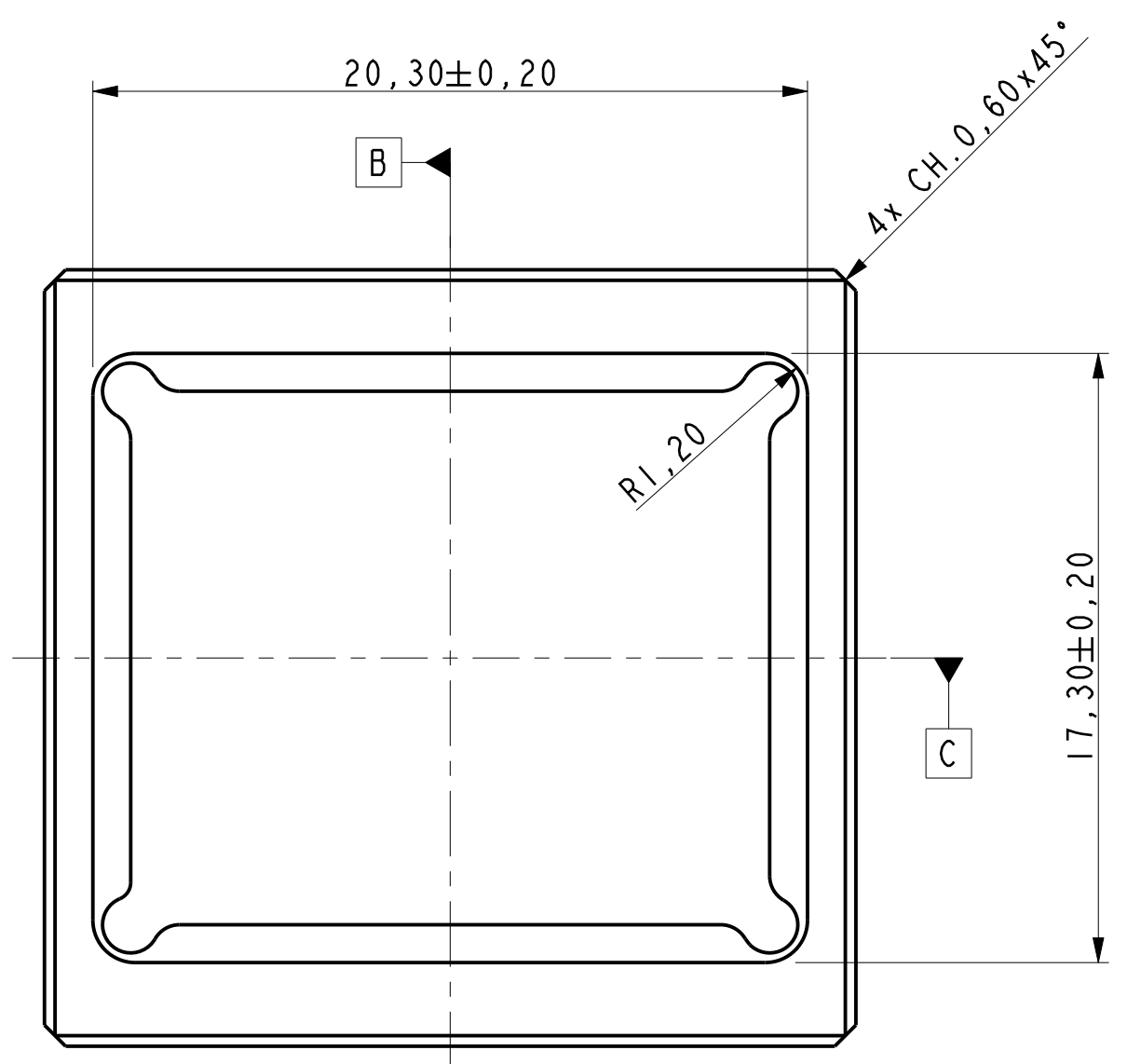


TOP VIEW
SCALE 5,000

SECTION C-C



$0,15$



BOTTOM VIEW

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UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE PER THE FOLLOWING TOLERANCES:

INCHES	MM	ANGLES
.X ± .05	.X ± .25	X ± 5°
.XX ± .01	.XX ± .13	X.X ± 1°
.XXX ± .005	.XXX ± .05	

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PROJECT NAME CF3-V2		PART DESCRIPTION	
DATE 17-10-12	DATE 17-10-12		13811 Wireless Way Richmond, British Columbia Canada, V6V 3A4 Tel: 604.231.1100 Fax: 604.231.1109
DESIGNER JPM	DATE 17-10-12		
CHK PYK	DATE 17-10-12	SIZE C	UNITS MM
PROJ FILENAME INTERPOSER_REV1_	PROJ FILENAME INTERPOSER_REV1_	DRAWING NO. 530xxxx	REV 01
RELEASE LEVEL PROJ_RELEASE	PROJ_VERSION	SCALE: 5,000	SHEET 1 OF 2

1 NOTES APPLICABLE TO PART MANUFACTURER

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

2. APPLICABLE DOCUMENTS:

ASME Y14.5M-1994 GEOMETRIC DIMENSIONING AND TOLERANCING
 EIA 432-2 16mm, 24mm, 32mm, 44mm & 56mm PUNCHED AND EMBOSSED CARRIER TAPING OF SURFACE
 MOUNT COMPONENTS FOR AUTOMATIC HANDLING

3. MATERIAL AND TOOLING REQUIREMENTS:

- 3.1 MATERIAL: TBD
- ~~3.2 THICKNESS: N/A~~
- ~~3.3 PLATING: NONE~~
- 3.4 COMPLETE TOOL DRAWINGS TO BE SUBMITTED TO SIERRA WIRELESS MECHANICAL ENGINEERING GROUP FOR APPROVAL.
- 3.5 PART/ASSEMBLY SHALL CONTAIN NO HAZARDOUS SUBSTANCES PER RoHS DIRECTIVE 2011/65/EU.
- 3.6 PART/ASSEMBLY SHALL CONFORM TO REACH REGULATION (EC) 1907/2006.
- 3.7 PART/ASSEMBLY WASTE DISPOSAL CONTROL SHALL CONFORM TO WASTE ELECTRICAL AND ELECTRONIC EQUIPMENT DIRECTIVE 2012/19/EU (WEEE).
- ~~3.8 PART SHOULD BE FREE OF ALL LUBRICATION OILS THAT MAY IMPIDE SOLDERABILITY~~
- ~~3.9 PART SHALL CONFORM TO THE FOLLOWING SOLDERABILITY REQUIREMENTS AS DELIVERED:
 J-STD-002A STEAM AGING CATEGORY 3 AND SOLDERABILITY TEST B.~~

4. MECHANICAL REQUIREMENTS:

- 4.1 CONTROLLING GEOMETRY IS DEFINED BY THE 3D PRO/ENGINEER DATABASE. ALL SURFACES TO BE WITHIN 0.13mm 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: 0.05mm ~~20% OF MATERIAL THICKNESS~~. NO LOOSE BURRS PERMITTED.
- 4.5 ALL INSIDE BEND RADII NOT SHOWN SHALL BE 0.05mm.
- ~~4.6 GRAIN DIRECTION SHALL BE AS SPECIFIED.~~

5. QUALITY ASSURANCE REQUIREMENTS:

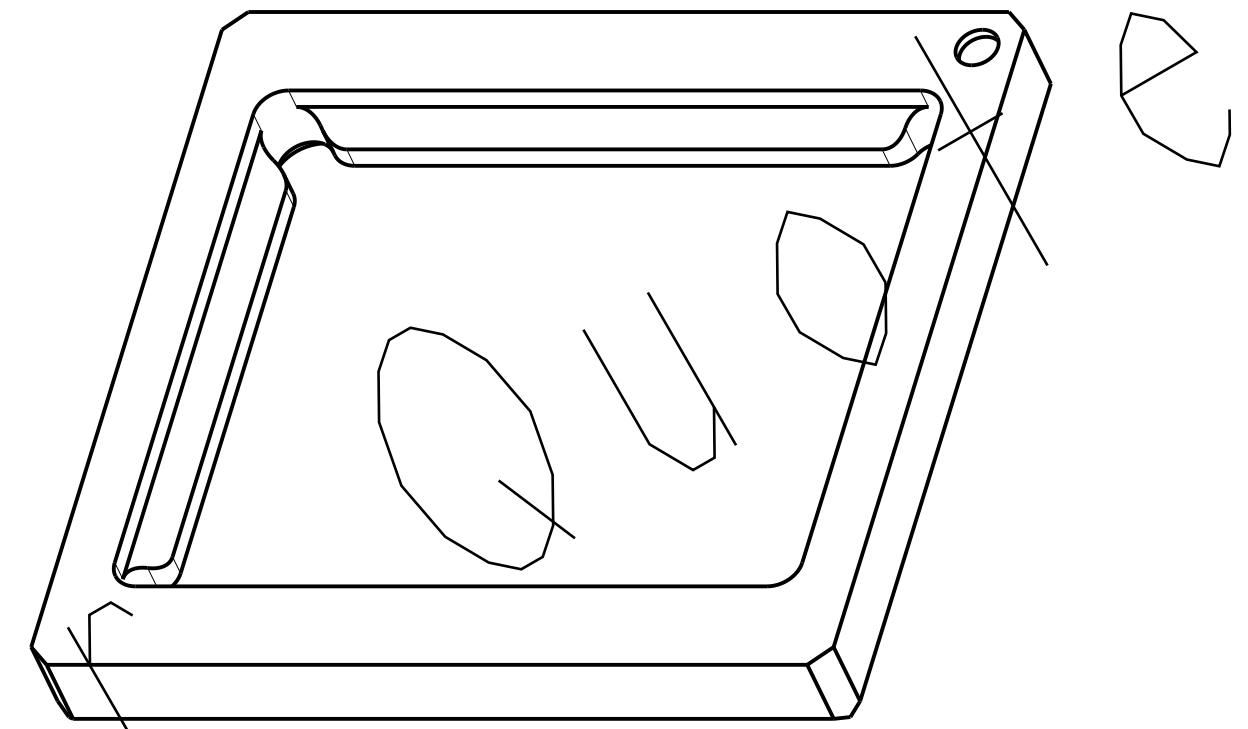
- 5.1 ALL DIMENSIONS INDICATED ON DRAWING ARE CRITICAL TO FORM, FIT, OR FUNCTION.
- 5.2 DIMENSIONS INDICATED WITH A [X] SYMBOL DENOTE QUALITY PROCESS CONTROL (QPC), DIMENSIONS.
- 5.3 QUALITY ASSURANCE PLAN:
 - 5.3.1 THE SUPPLIER MUST DEVELOP A QUALITY ASSURANCE PLAN TO ENSURE CRITICAL PARAMETER COMPLIANCE. 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 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 100 PIECES UNDER CONDITIONS REPRESENTATIVE OF PRODUCTION. A DIMENSIONAL REPORT MUST BE SUBMITTED TO SIERRA WIRELESS ALONG WITH THE MEASURED PARTS.
- 5.5 DIMENSIONAL REPORT:
 - 5.5.1 CRITICAL PARAMETER CONFORMANCE MUST BE DEMONSTRATED BY INSPECTION OF AT LEAST 30 PIECES FROM THE FIRST ARTICLE RUN. ALL DIMENSIONS MUST BE MEASURED ON AT LEAST 5 PARTS 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 TAPE & REEL PACKAGING PER EIA 432-1 OR 432-2.~~
- ~~6.2 ORIENTATION OF PART IN TAPE AND REEL TO BE AS SHOWN.~~

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.



UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE PER THE FOLLOWING TOLERANCES:		PROJECT NAME		PART DESCRIPTION																									
<table border="0"> <tr> <td>INCHES</td> <td>MM</td> <td>ANGLES</td> <td></td> <td></td> <td></td> </tr> <tr> <td>.X ± .05</td> <td>.X ± .25</td> <td>X ± 5°</td> <td></td> <td></td> <td></td> </tr> <tr> <td>.XX ± .01</td> <td>.XX ± .13</td> <td>X.X ± 1°</td> <td></td> <td></td> <td></td> </tr> <tr> <td>.XXX ± .005</td> <td>.XXX ± .05</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>		INCHES	MM	ANGLES				.X ± .05	.X ± .25	X ± 5°				.XX ± .01	.XX ± .13	X.X ± 1°				.XXX ± .005	.XXX ± .05					CF3-V2			
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MATERIAL		DATE	13811 Wireless Way																										
SEE NOTE		17-10-12	Richmond, British Columbia																										
FINISH		DATE	Canada, V6V 3A4																										
SEE NOTE		17-10-12	Tel: 604.231.1100																										
		DATE	Fax: 604.231.1109																										
		17-10-12	SIZE	UNITS	DRAWING NO.																								
			C	MM	530xxxx																								
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					SHEET 2 OF 2																								

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