

10 9 8 7 6 5 4 3 2 1

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: AISI 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 DATABSE, 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 RADII 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 RADII SHALL BE 0.13mm FOR ALL UNMARKED FILLETS AND RADII, 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.

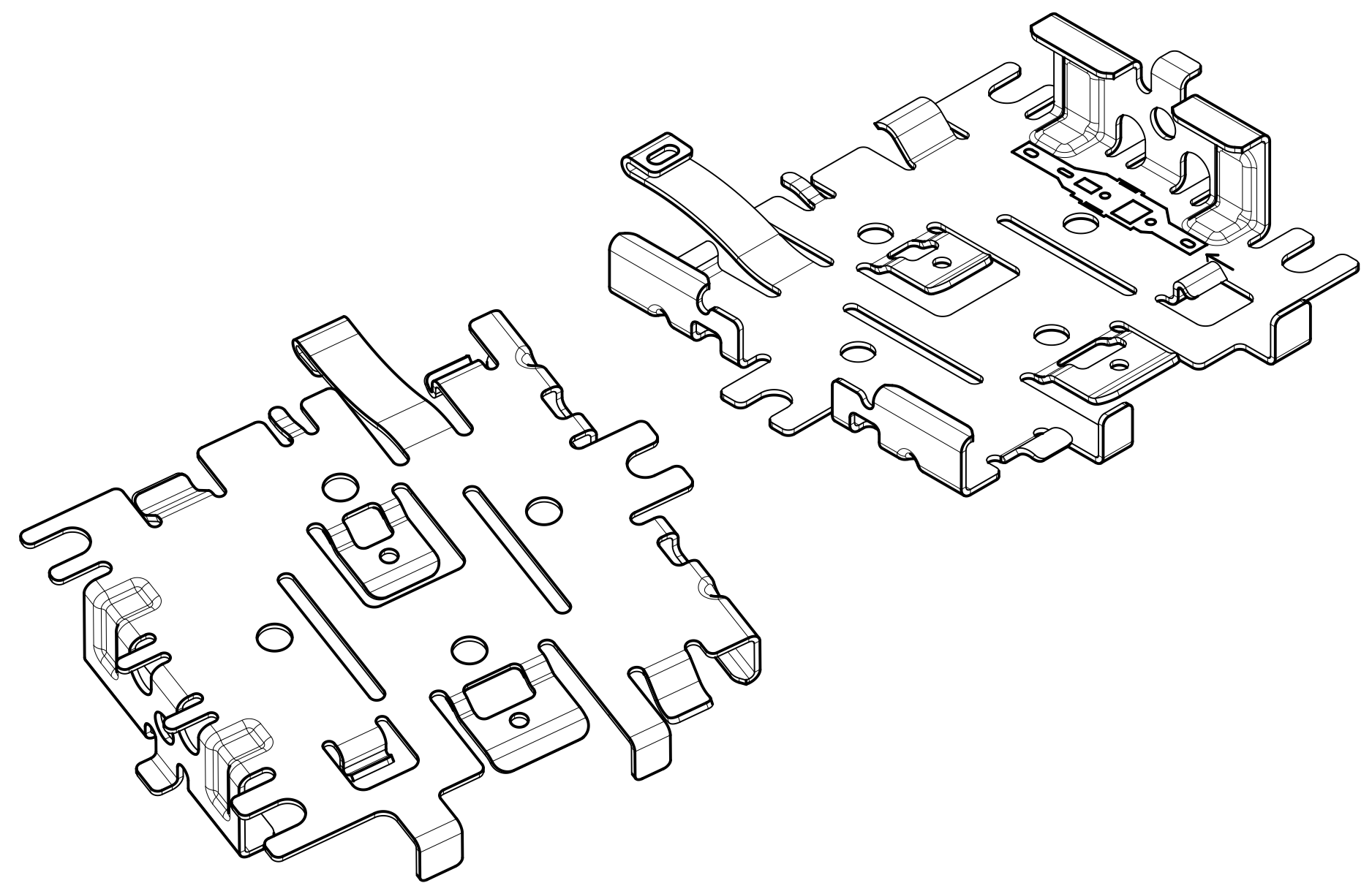
11 NOTES APPLICABLE TO CONTRACT MANUFACTURER

1. INCOMING INSPECTION DIMENSION MARKED BY XX.XX

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

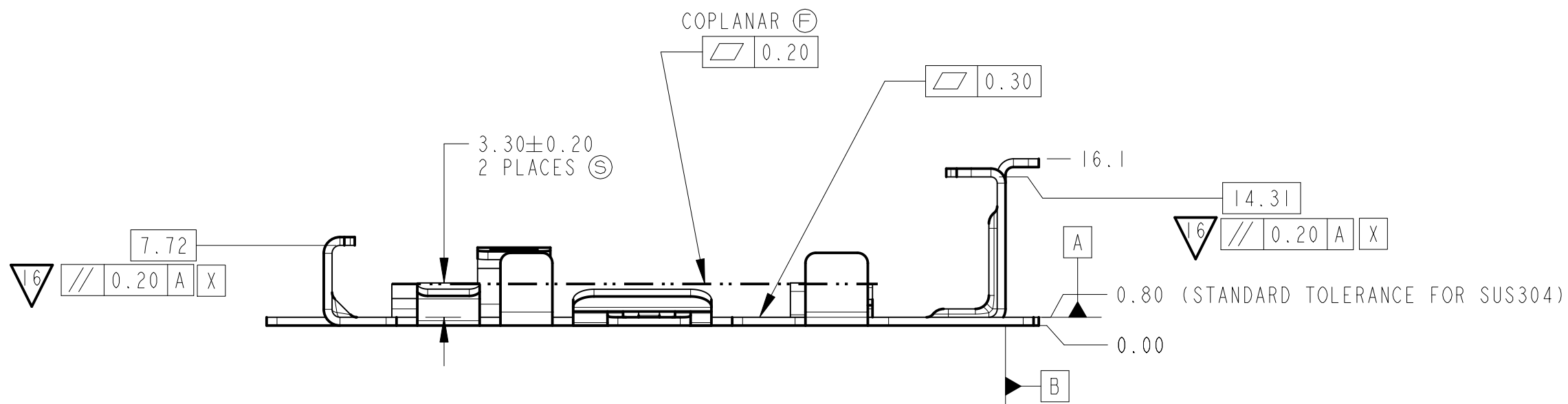
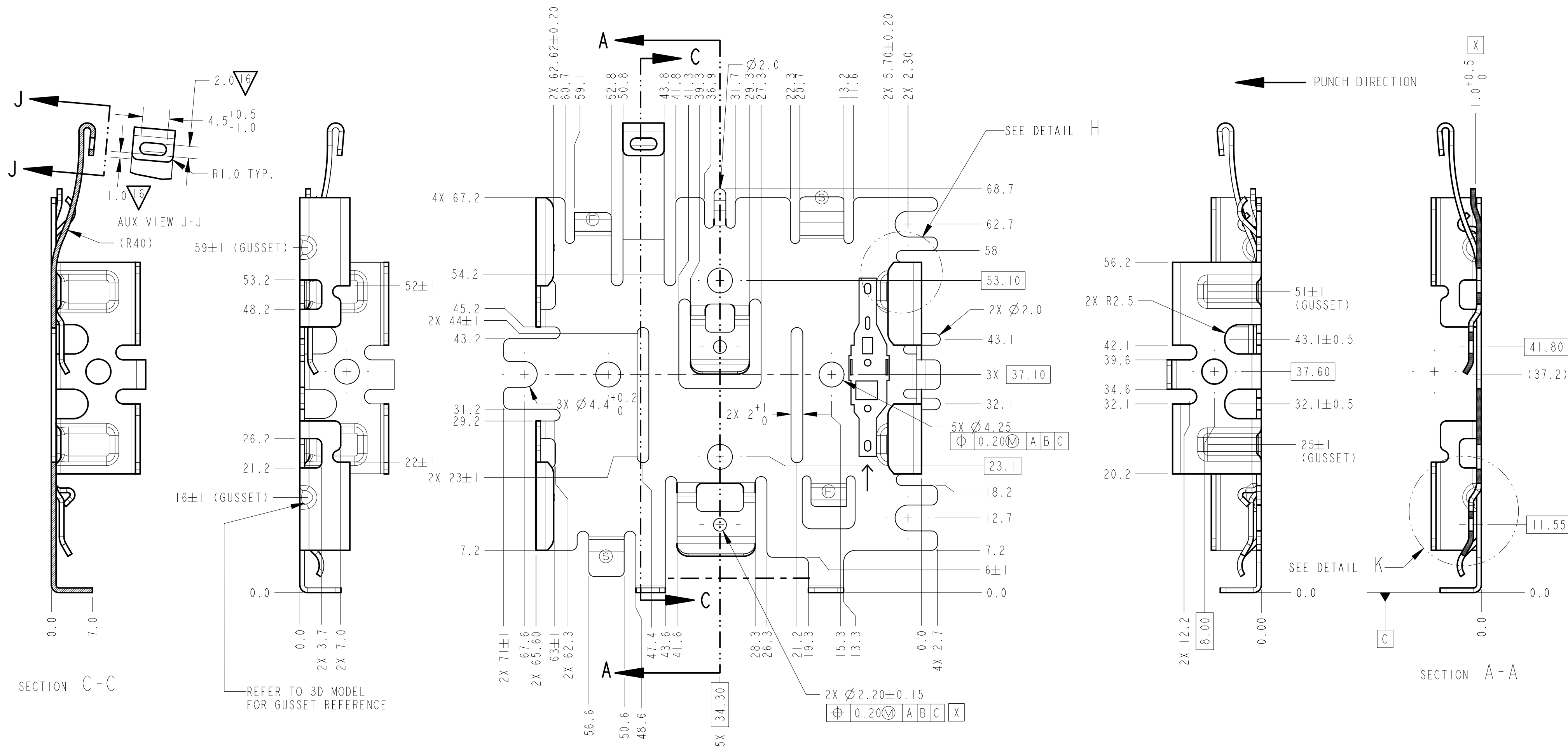
3. CONTRACT MANUFACTURER SHALL REQUIRE PART MANUFACTURER TO PROVIDE SPC DATA AND REVIEW WITH SIERRA WIRELESS MECHANICAL ENGINEERING GROUP

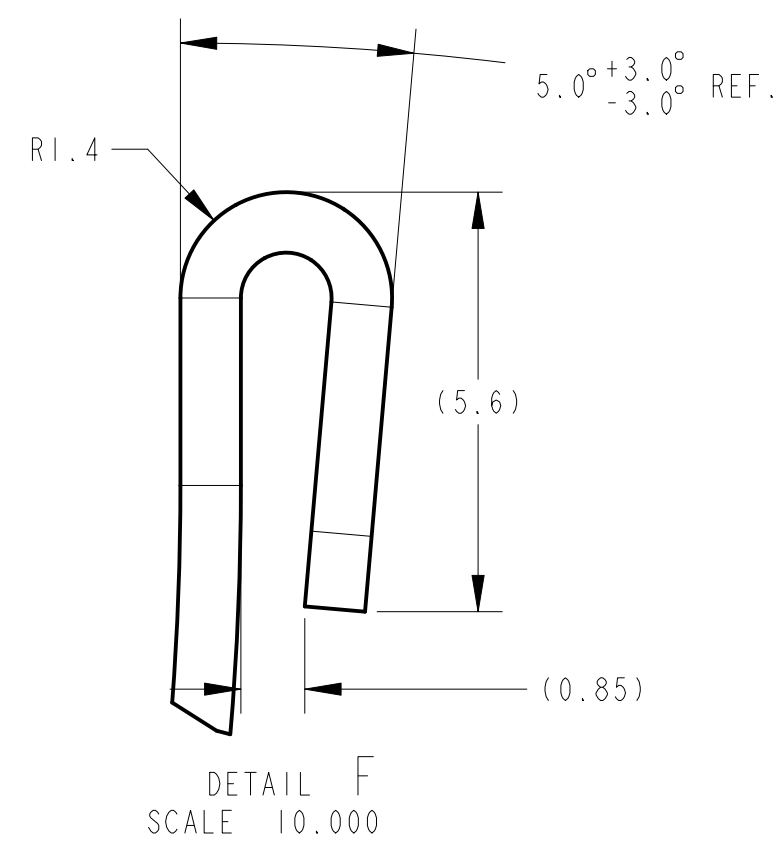
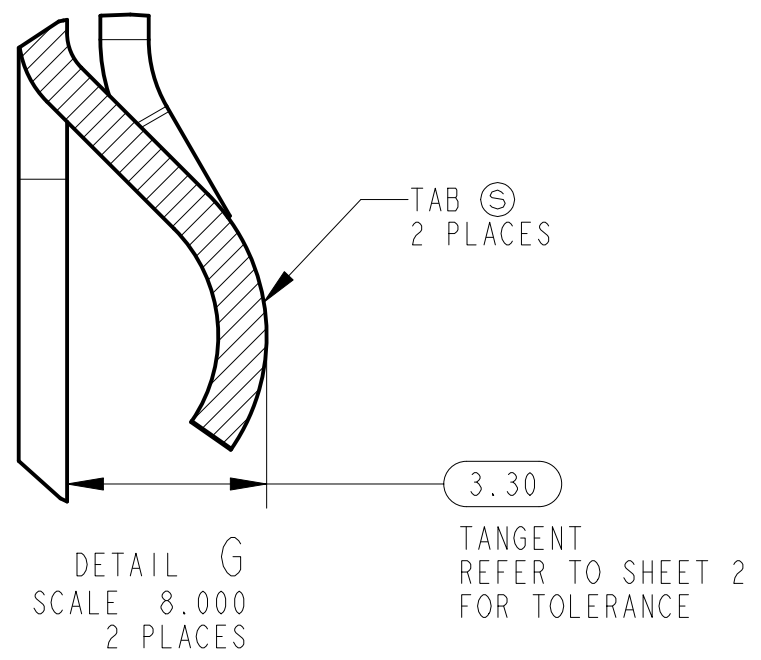
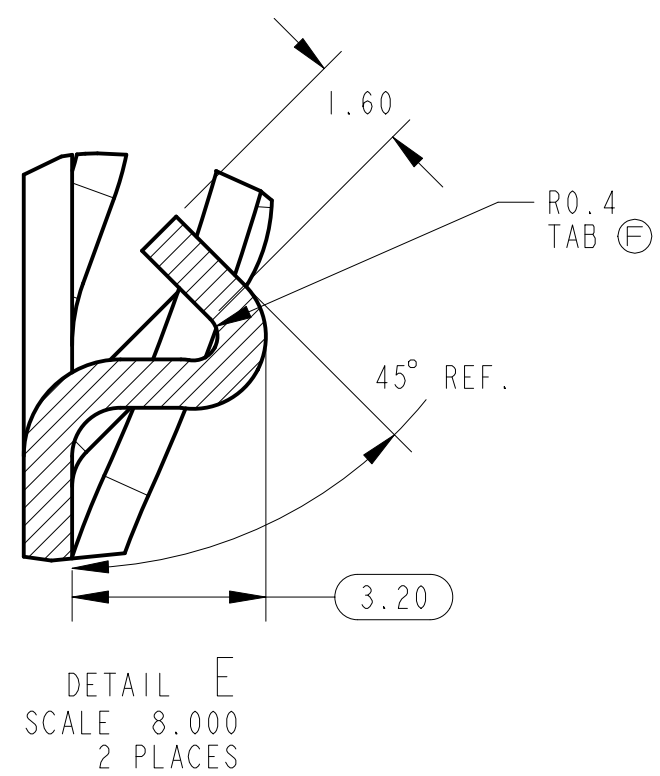
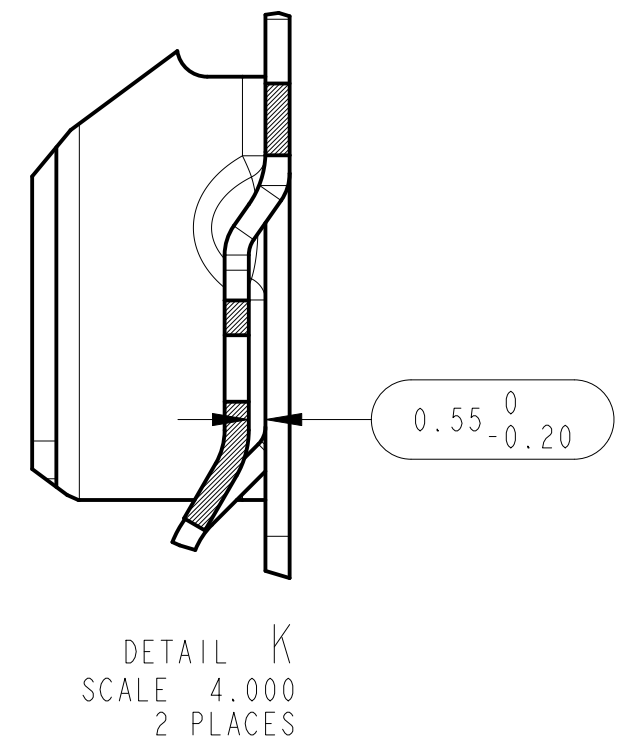
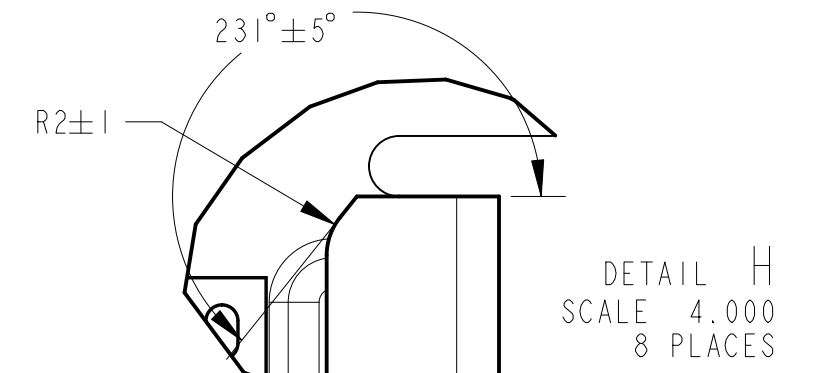
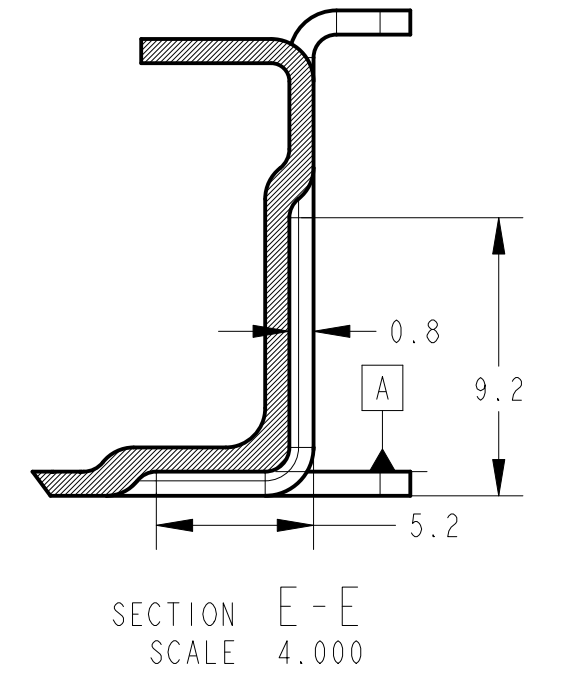
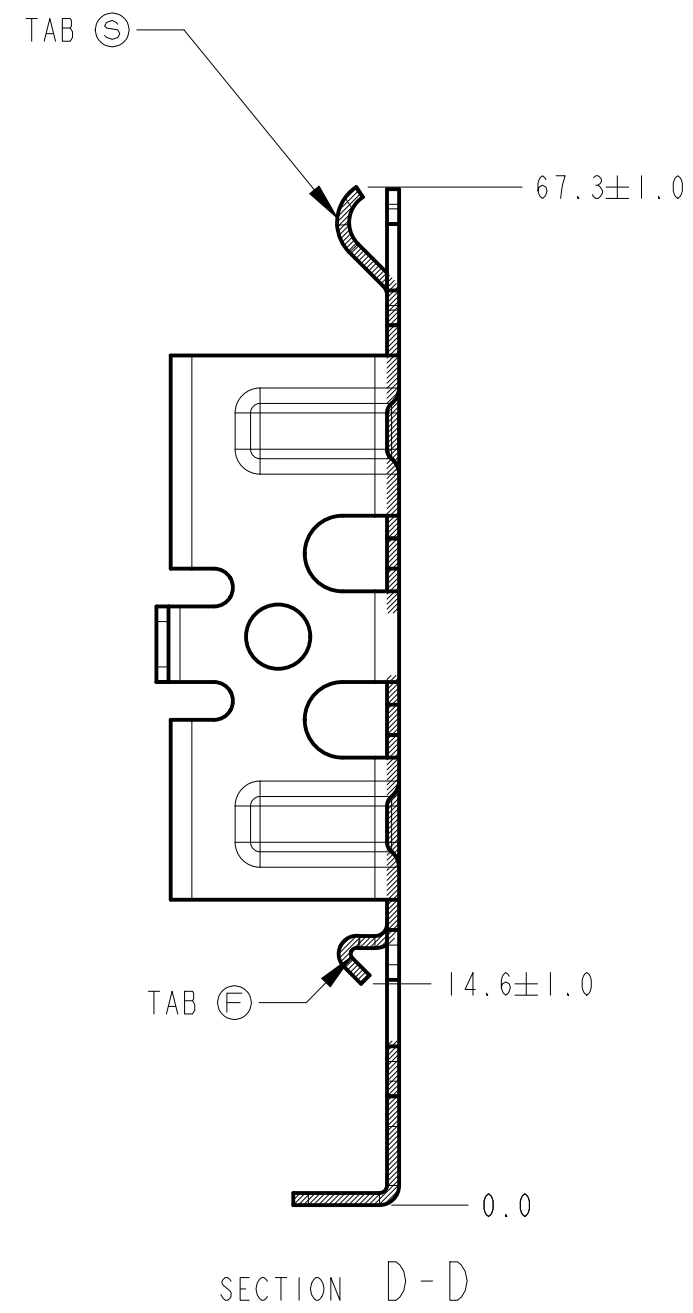
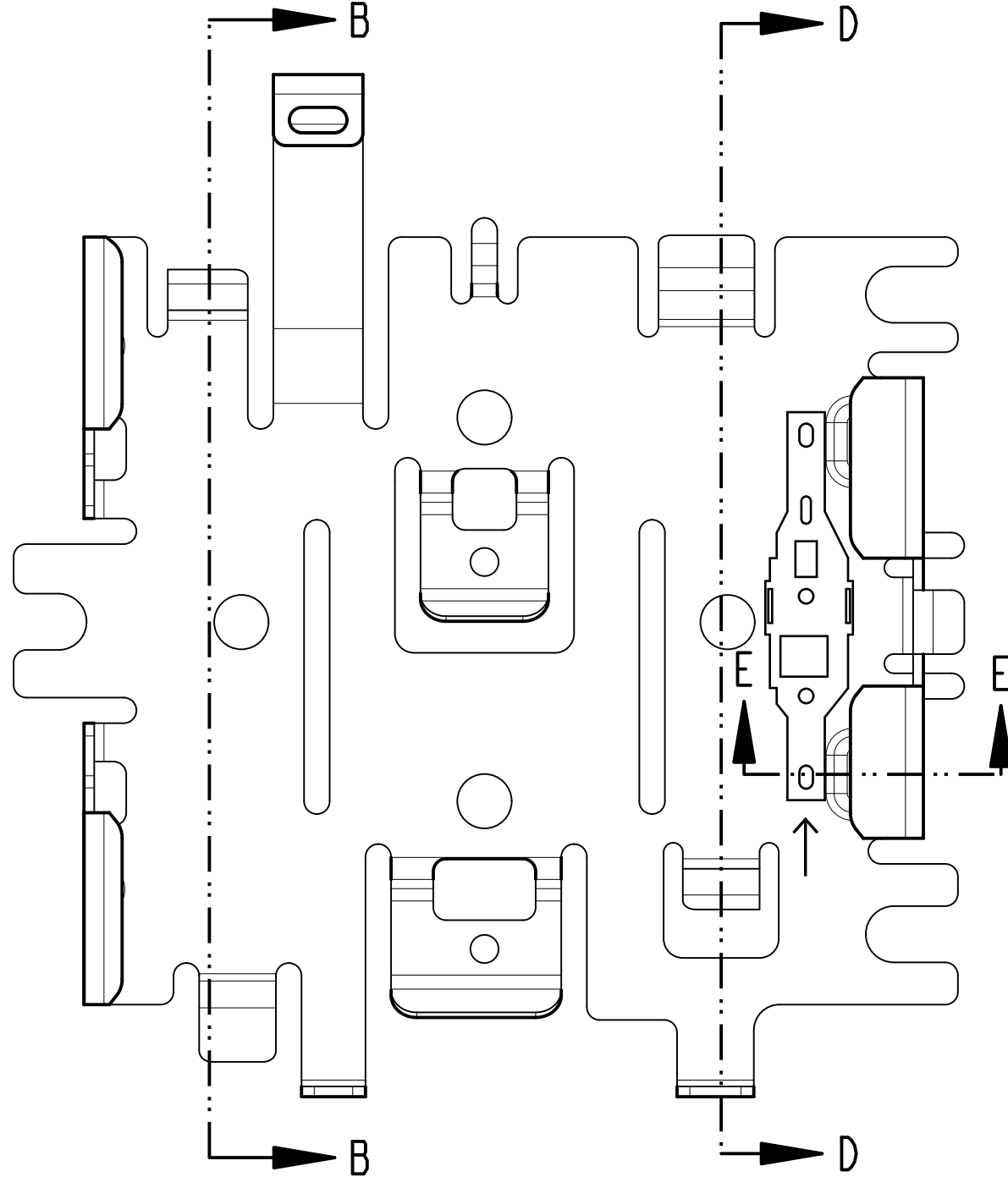
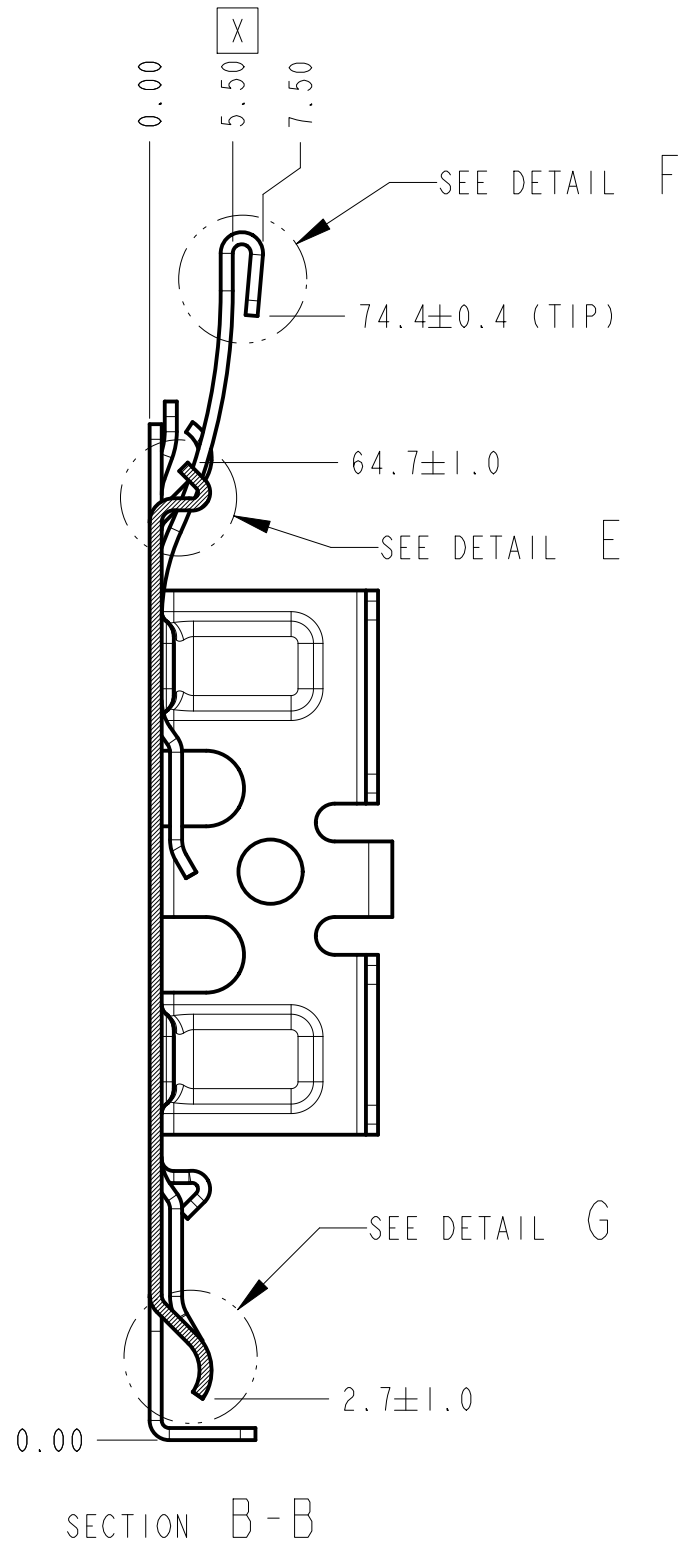
REV	DESCRIPTION	ECO	DATE	DRAWN	APPD
1	INITIAL RELEASE		JUL/29/2016	SM	
2	1. MATERIAL CHANGE FROM SUS301 TO SUS304-1/2H 2. DESIGN UPDATED TO AID MFG		2016/08/19	SM	
3	1. 4X DIMPLES REMOVED 2. DESIGN UPDATED		2016/08/23	SM	
4	UPDATED TO AID MFG (S2, C5 & C4)		2016/08/24	SM	
5	UPDATED TANG		2016/08/29	SM	
6	UPDATE PER DFM: SHEET 2, G-9 AUX. VIEW J-J ADDED, F-2, DIM.25 WAS 26 SHEET 3, G-9, DETAIL G ADDED		2016/09/26	WT	
7	1. UPDATED DESIGN (G7 & G5, S2) 2. SECTION E-E (S3) 3. ADDED PAGE 5		2016/09/30	SM	
8	1. UPDATED DESIGN WITH TOLERANCE (G7 & G5, S2) 2. UPDATED INSPECTION DIMENSION (G8,S4) 3. NOTE UPDATED (C5, S5)		2016/10/06	SM	
9	UPDATED CALL OUT FOR LASER ENGRAVING (SHEET 5) TO MATCH 1301051_REV6		2016/10/12	SM	
10	UPDATED DIMENSIONS REFER TO		2016/10/13	SM	
11	UPDATED DIMENSIONS REFER TO - SHEET 2		2016/10/14	SM	
12	REFER TO FOR UPDATES - (D10, H5, H7, G2, SHEET 2), (G9, B9, C3, SHEET 3), (E6, SHEET 4)		2016/10/19	SM	
13	1. REFER TO FOR UPDATES - SHEET 2 (S2) 2. DIMENSIONS DELETED: 3.92 (B7,S2), 2.40 - 2 PLACES (B7,S2), 10.51 (B5,S2)		2016/11/07	SM	
14	CUTOUT INCREASED FROM 1.9MM TO 3.75MM (H5, S5)		2016/11/30	SM	
15	1. UPDATED OVERALL TANG DESIGN (G9, F9, SHEET 2) + (G9, F9, SHEET 3) 2. DETAIL F (A4, SHEET 3) 3. OVERALL VERTICAL DIMENSION LIMITS (E6, SHEET 4)		2016/12/07	SM	
16	1. ACCEPTED DFM FROM VENDOR - TANG OBOUND CUTOUT UPDATED (G9, F9 & SHEET 2) 2. ACCEPTED DFM FROM VENDOR - GTOL UPDATED (B4, B8 & SHEET 2)		2016/12/19	SM	
17	TOLERANCE UPDATE PER DFM AT SHEET #4, ADD NOTE AND PICTURE		2017/04/21	WT	WM



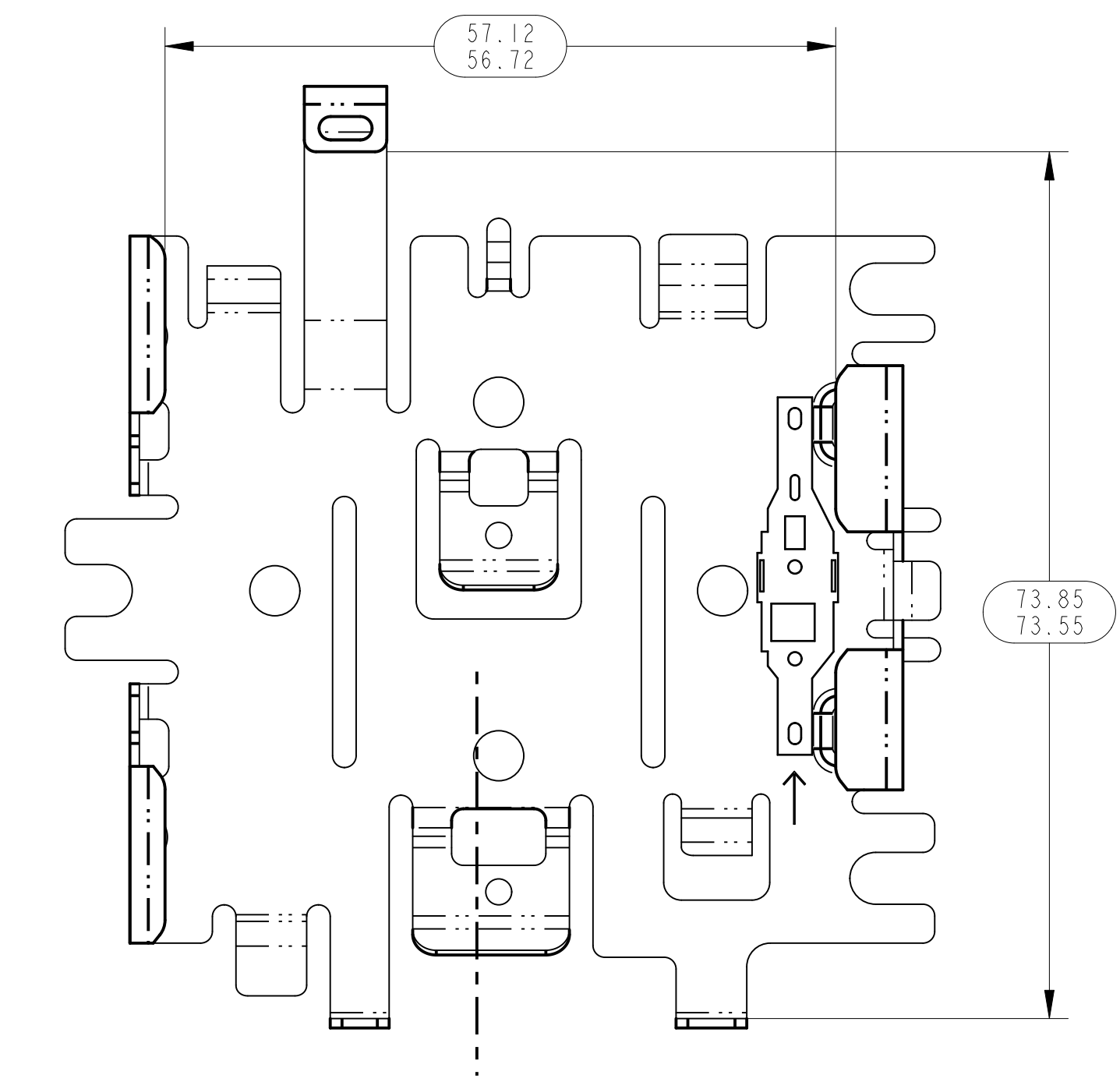
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UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE PER THE FOLLOWING TOLERANCES:			PROJECT NAME FX30		PART DESCRIPTION DIN & FLAT MOUNT BRACKET	
MM	ANGLES		DATE	DATE	13811 Wireless Way Richmond, British Columbia Canada, V6V 3A4 Tel: 604.231.1100 Fax: 604.231.1109	
.X ± .50	X ± 5°	S.MAR	JUL/29/2016	SIZE UNITS DRAWING NO. REV		
.XX ± .25	X.X ± 1°	S.MAR	JUL/29/2016	C MM 1301050	17	
.XXX ± .15		S.MAR	JUL/29/2016	SCALE: 1:000		SHEET 1 OF 5
MATERIAL: SEE NOTES		PRJ FILENAME: 1301050				
FINISH: SEE NOTES		DWG FILENAME: 1301050				
DO NOT SCALE PRINT		RELEASE LEVEL: Development				

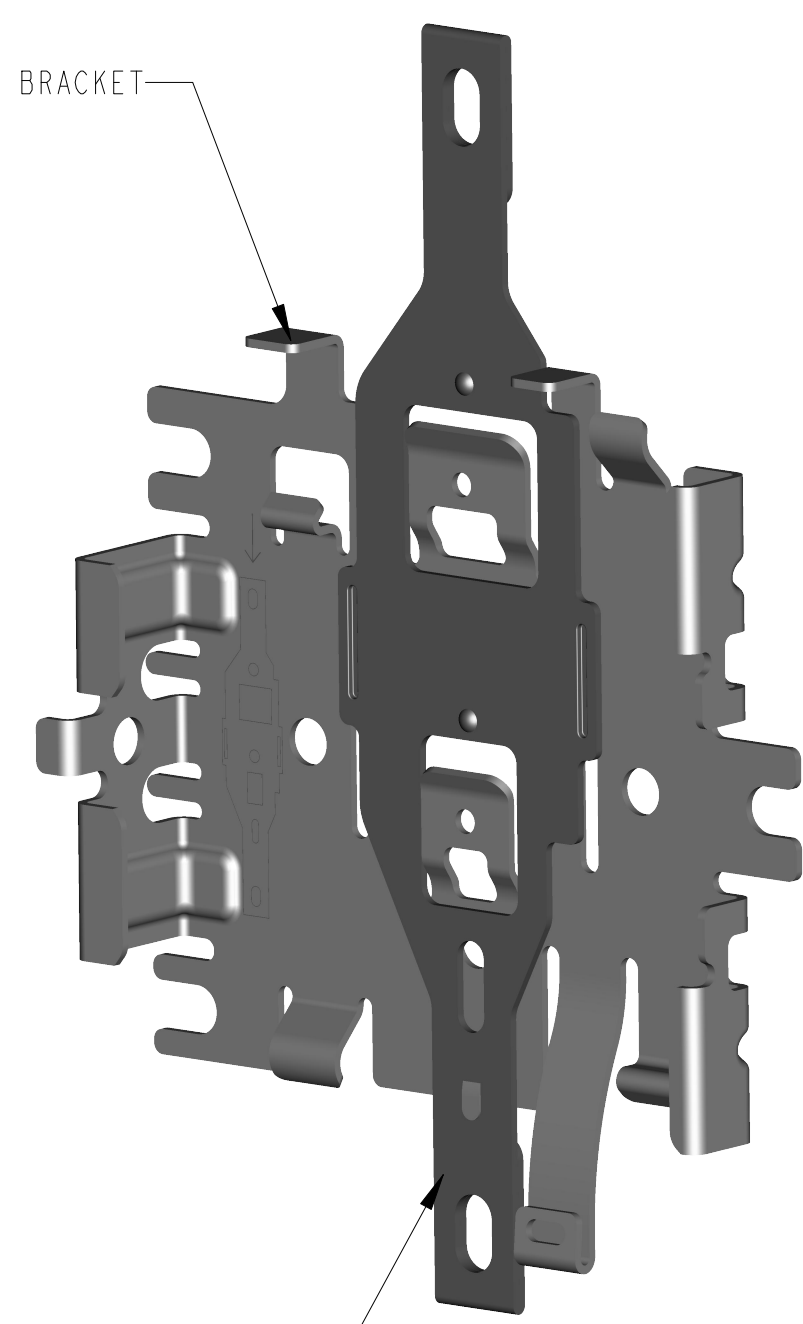




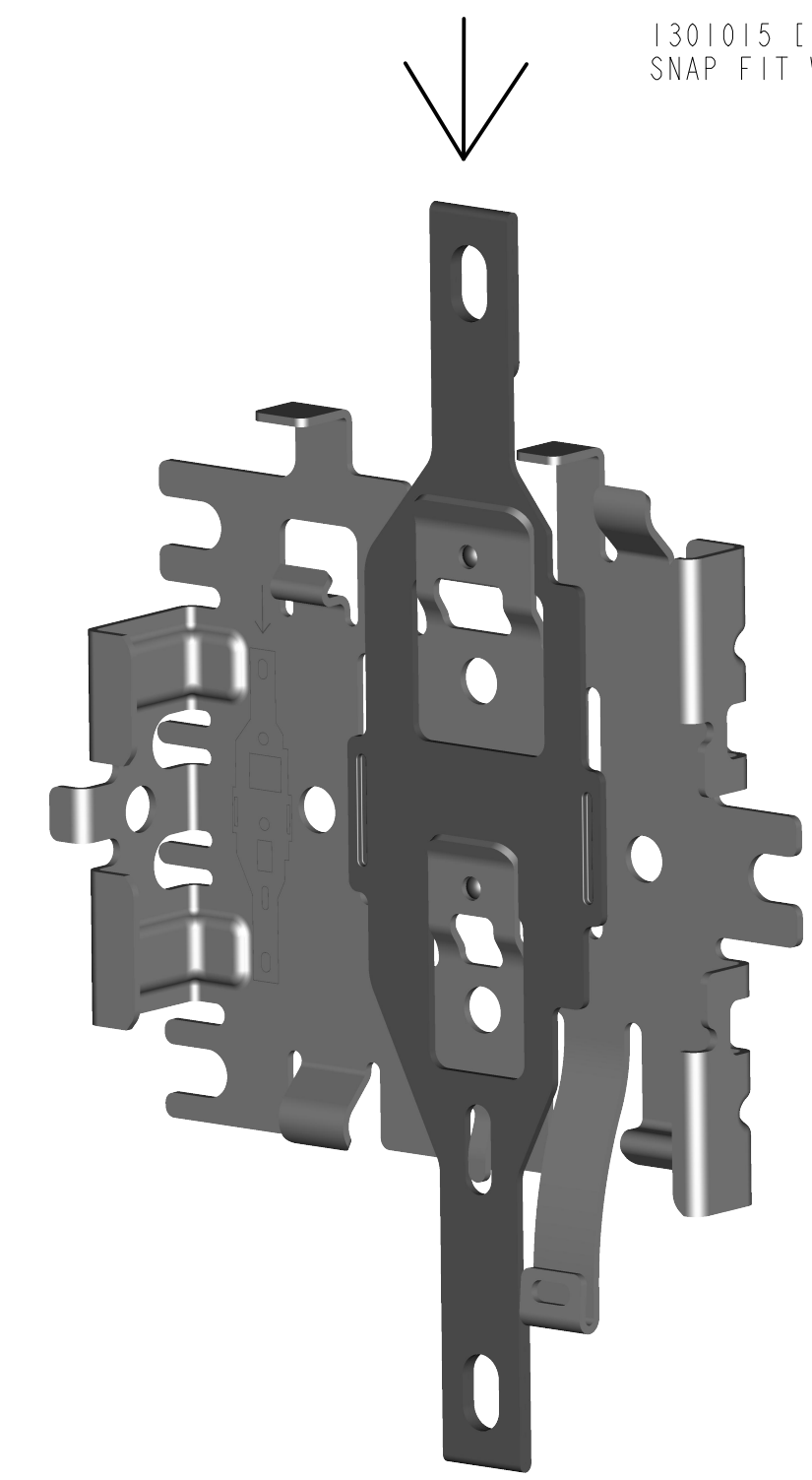
		13811 Wireless Way Richmond, British Columbia Canada - V6V 3A4 Tel: 604.231.1100 Fax: 604.231.1109	
		SIZE C DRAWING NO. 1301050 SCALE: 1.000	REV 17 SHEET 3 OF 5



1301050 - DIN BRACKET



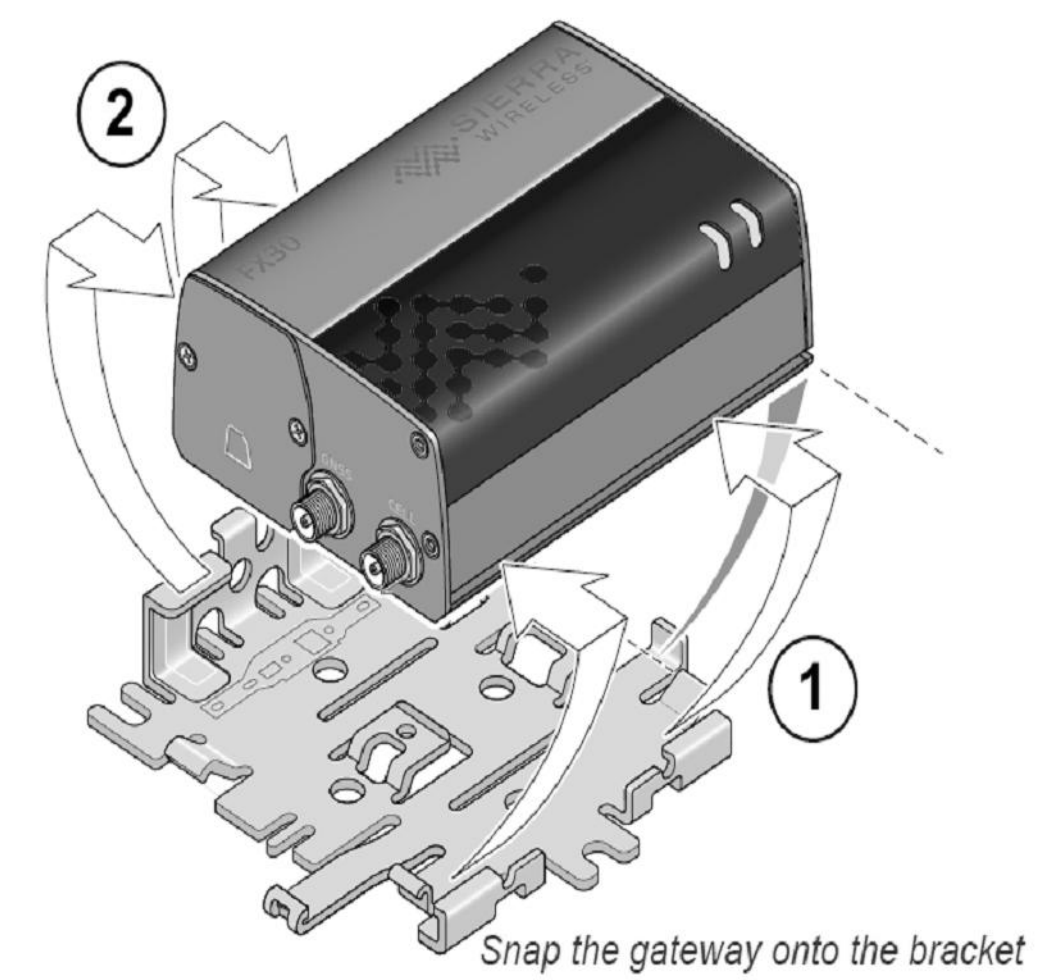
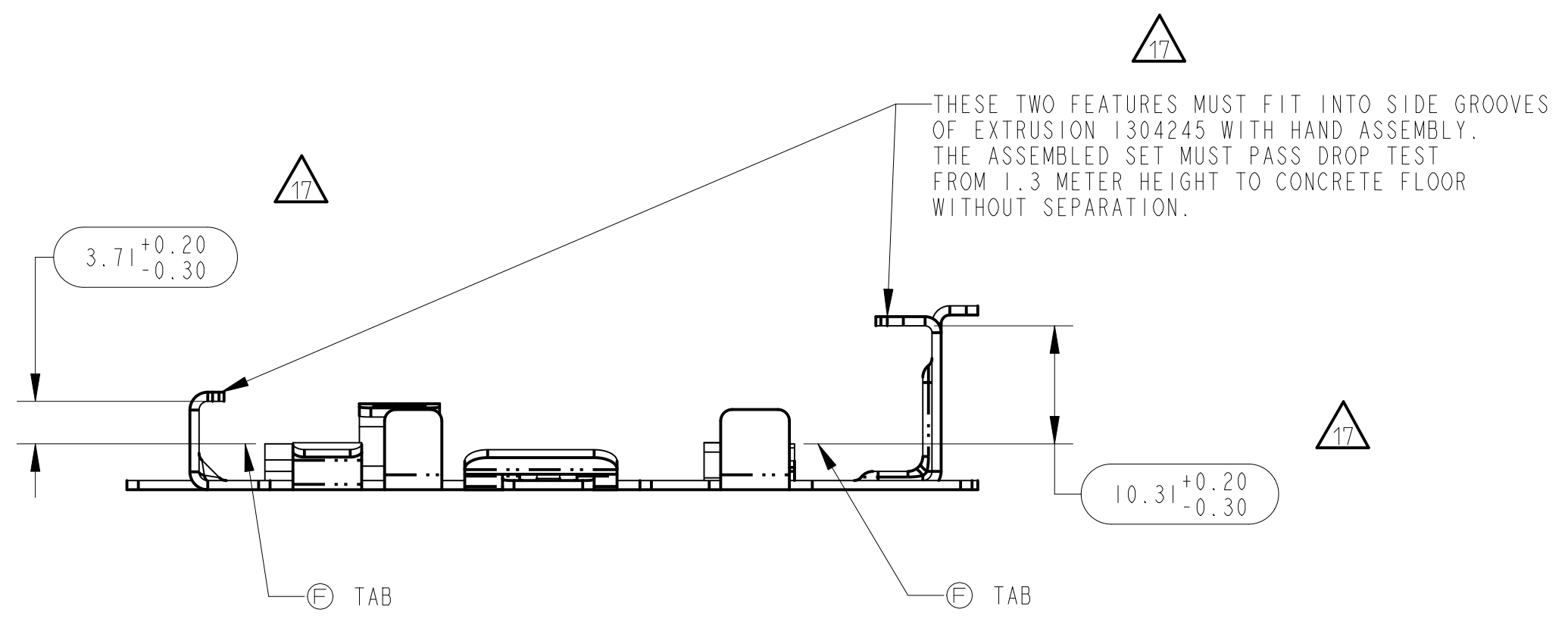
1301051 [FLAT MOUNT BRACKET]
SLIDE FLAT MOUNT BRACKET ONTO DIN BRACKET



START ASSEMBLY

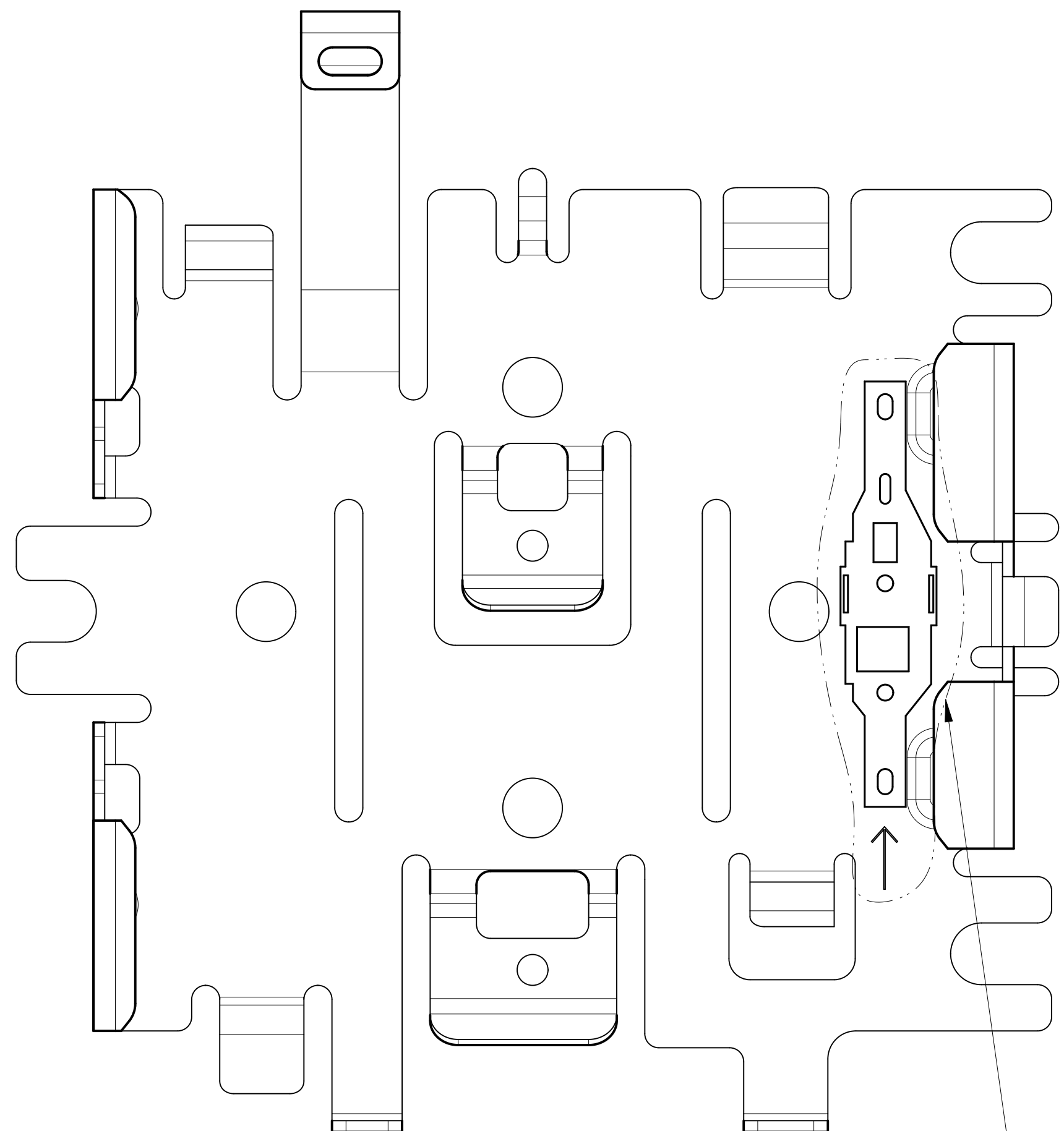
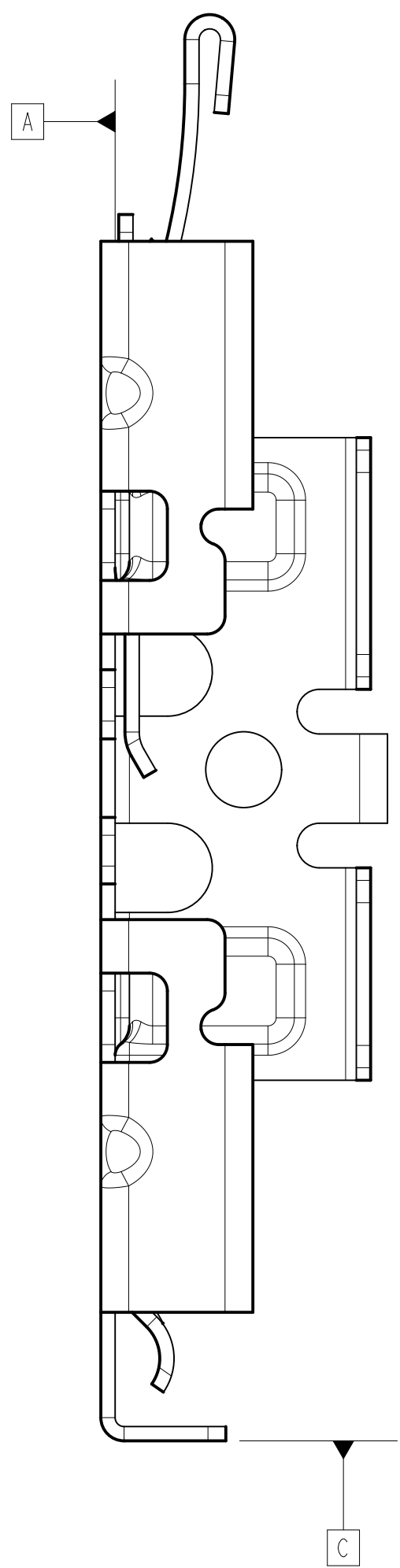
1301015 [FLAT MOUNT BRACKET] MUST SNAP FIT WITH 1301050 [DIN BRACKET]

FINISH ASSEMBLY

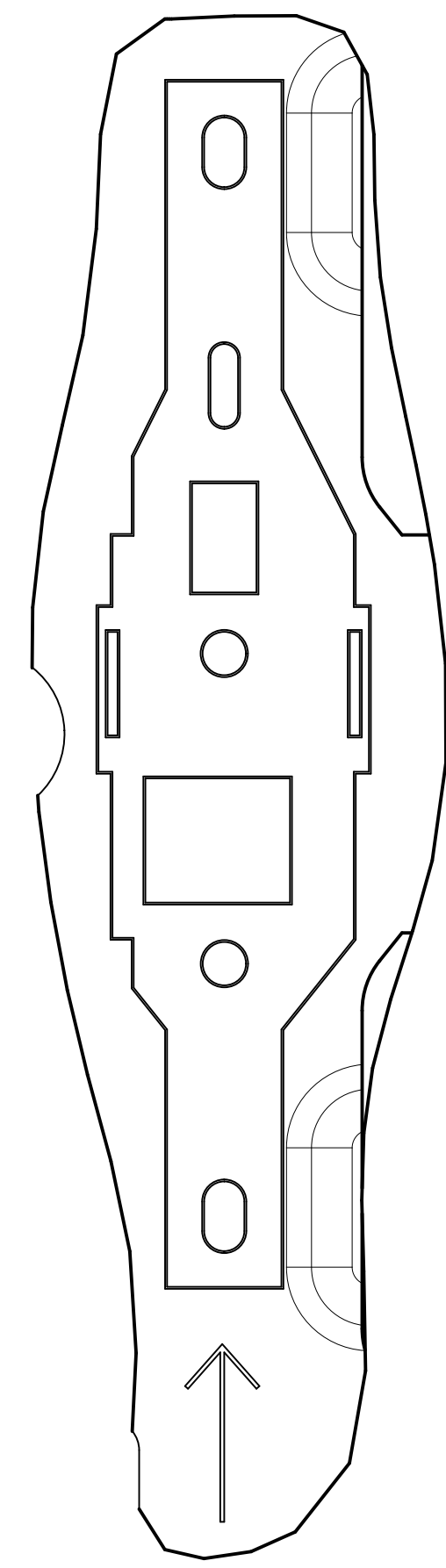


10 9 8 7 6 5 4 3 2 1

H
G
F
E
D
C
B
A



SCALE 3.000



DETAIL A
SCALE 6.000

SEE DETAIL A
 GRAPHIC: APPROX. LOCATION AS SHOWN (REFER TO 3D CAD FILE)
 MANUFACTURING METHOD: LASER ENGRAVING (NO STAINING, ANNEALING
 MARKING, RUSTING OR OXIDATION ALLOWED AFTER LASER ENGRAVING).

		13811 Wireless Way Richmond, British Columbia Canada - V6V 3A4 Tel: 604.231.1100 Fax: 604.231.1109
SIZE C	DRAWING NO. 1301050	REV 17
SCALE: 1.000		SHEET 5 OF 5

10 9 8 7 6 5 4 3 2 1

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