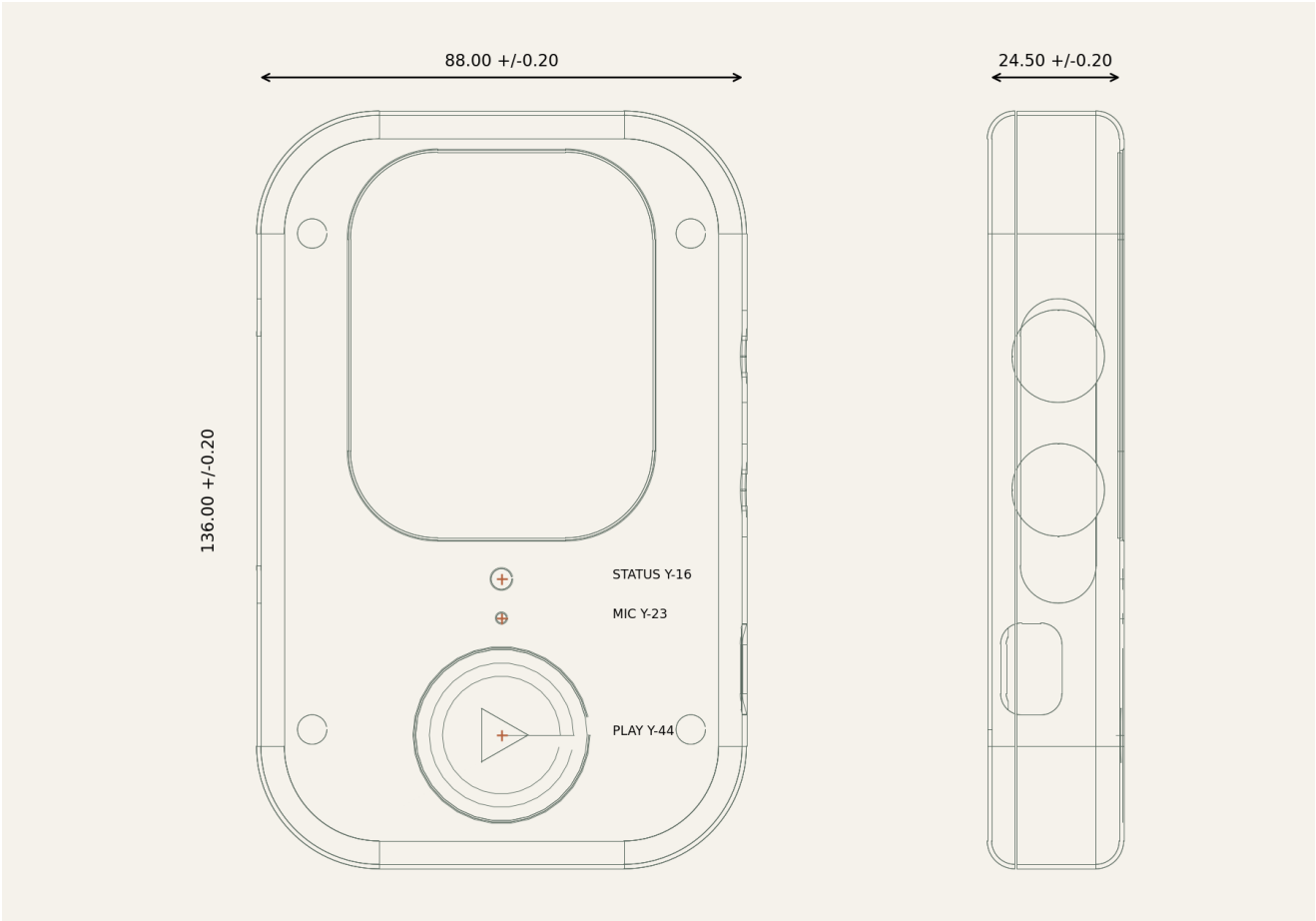


D01 | Overall and datums

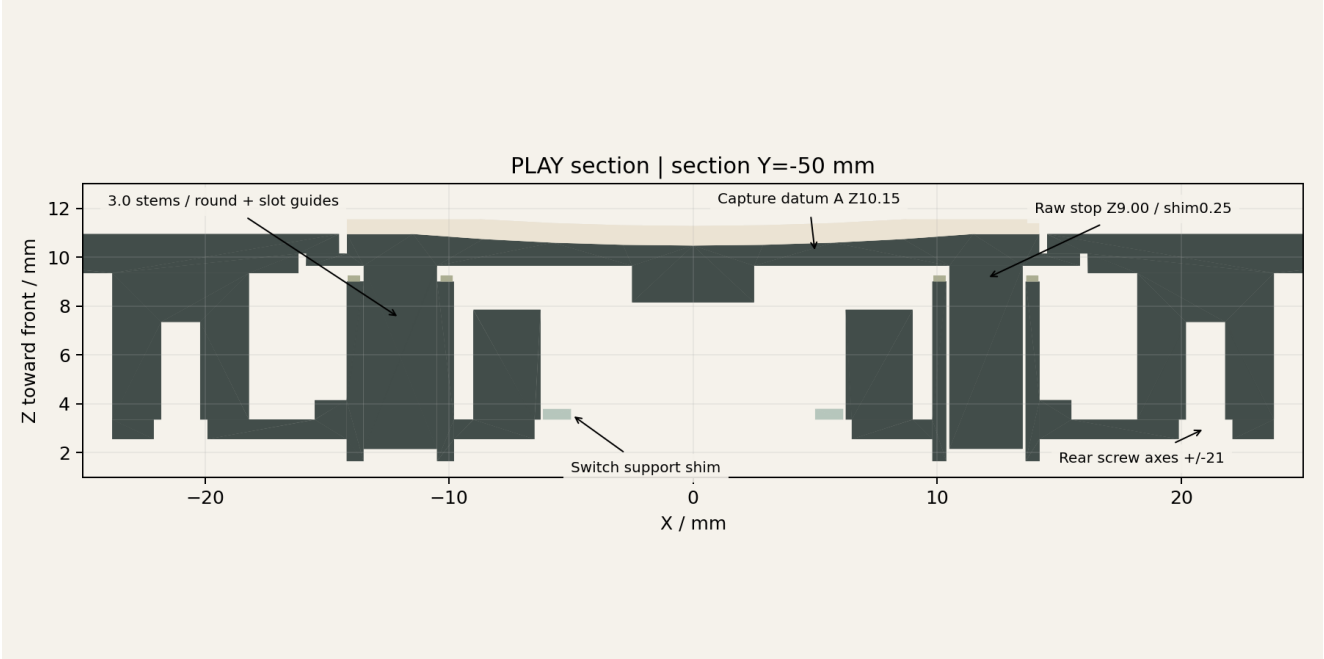
R8 finished-interface drawing | mm | do not scale printed images



Dimension / datum	Finished requirement
Body and axes	88.00 +/-0.20 W;136.00 +/-0.20 H;24.50 +/-0.20 D. X0/Y0 body center. Exterior rearZ-12.75, front Z11.75. Edge R5 / plan R22 retained.
Play / front marks	Face 30.80 +/-0.05 at X0/Y-44. Mic 1.80 +/-0.05 at X0/Y-23; status opening 3.70 at X0/Y-16. W26.6 x 23.24 at(0,26).
Closure	FacesZ-7.50/-7.80: gap 0.30 +/-0.10 after finish. ScrewsX+/-34,Y-43/+46. Preserve 2.8 clearance and 5.3 counterbore. No bond across joint.
Control clearances	Side cap/opening nominal 0.30 per side, inspect minimum 0.15 after finish and position error. Play face/opening nominal 0.30 per side; with +/-0.05 diameters and 0.05 eccentricity minimum 0.20 per side.

D02 | Play cassette

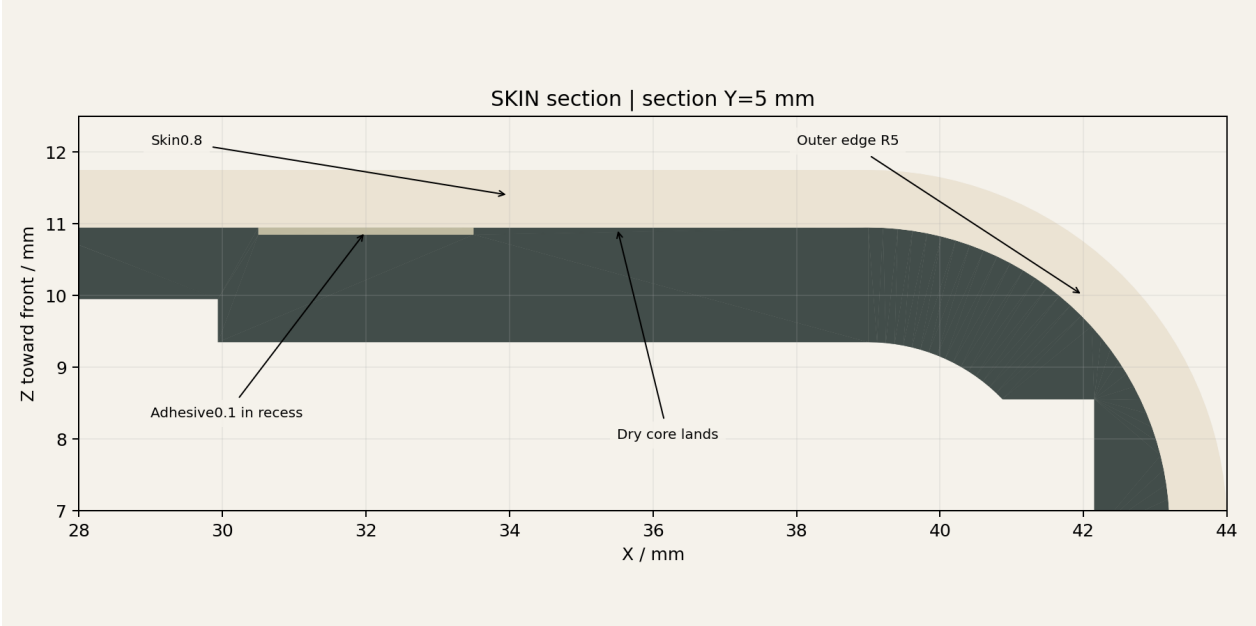
R8 finished-interface drawing | controlled datums and shim setting



Dimension / callout	Finished requirement
A / B / C	A: flange capture underside Z10.15. B: guide axesX $\pm$ 0.12/Y-50. C: cassette stop tops Z9.00. Flange underside Z9.65; raw stroke 0.65 $\pm$ 0.01.
Guidance	Stem diameter 3.000-3.002; bore diameter 3.010-3.012; minimum overlap 6.85 at rest. Left round, right slotX $\pm$ 0.12. Inspect common guide alignment/coplanarity 0.005; match-machine and measure, not raw SLS.
Switch / shim	Tip key Z8.15; switch tip nominal 8.09. Gap 0.060 $\pm$ 0.010. Support shim 0.05-0.85 total, CAD0.44. Stop shims 0-0.40 total, CAD0.25 $\rightarrow$ 0.40 nominal stroke. Clear locator feet and terminal tails using the supplied shim cutouts. Include PSA and coating in finished measurement.
Mount and return	Two M2 x 5 screw axesX $\pm$ 21/Y-50, clearance 2.2 through 0.8 ears. Blind tapped pilot 1.6, depth 4.2. CushionsX $\pm$ 15/Y-45, diameter 3, free 2.0/installed 1.8. Verify force and thread engagement before use.

D03 | Skin, cloth and port

R8 finished-interface drawing | U1 remains separate



Interface	Section / acceptance
Broad-face structure	Front main core Z9.35..10.95, skin 10.95..11.75. Reservoir bottom 10.85; finished 0.10 adhesive to dry lands 10.95. At pocket:1.50 residual PA12,0.10 adhesive,0.80 silicone =2.40 total.
Textile section	Backing top 10.65; perimeter reservoir 10.55..10.65,2 mm wide. Cloth 10.65..11.25,0.60 +/-0.05 installed. Do not add another adhesive layer on top. Opening 55 x 70; textile 54.2 x 69.2, nominal 0.40 per side.
Cloth tolerance	Finished opening+/-0.10; cloth cut+/-0.10; registration+/-0.10 -> minimum 0.20 gap on tighter side before cloth distortion. Inspect installed condition and corner smoothness.
U1 mouth / passage	Y center-32.1393. Mouth 17.5Y x 17Z, center Z0, starts X39. Passage 14.5Y x 9Z, centerZ-4.8396, starts X29.5. These are U1 proposal dimensions; main R8 port remains R7.
Mic / optical	Mic sealOD6.2/ID1.8,0.60 installed/0.80 free. PMMA sheet 0.60 +/-0.05; post 3.10,9.65..11.55. Qualified cement <=0.02 included in lapped assembled height.

D04 | Inspection and release

R8 finished-interface drawing | measurements to record per article

Record	Method / limit
Body W / H / D	Calipers or CMM on defined broad-face lands;88/136/24.5 with requested+/-0.20. Exclude separate button projection and 0.02 ink reference.
A / C / key flange	CMM or height fixture, finished and cleaned. Measured raw travel 0.650 +/-0.010. Do not infer from raw print dimensional tolerance.
Rest/contact/stop	Indicator resolution 0.005 or finer plus continuity logger. Positive rest 0.050-0.070. Record first contact and all 3 stop readings; approve contact-to-stop load before repetitive operation.
Guide / tilt / return	Pin gauges/micrometer, matched fixture, rim indicator. Confirm diameters and alignment; no rocking beyond 0.10-degree design bound, no rubbing, positive return in 6 orientations.
Wall / bond / textile	Coupon cross section or suitable nondestructive measurement. Main PA121.60, localpocket 1.50, skin 0.80; pocket adhesive 0.10 +/-0.03. Cloth installed 0.60 +/-0.05. Inspect adhesive keepouts and actual weave.
Thin tray / mic	Floor 0.90, underside-1.88, top-0.98. Confirm measured PCB gap with installed populated board. Mic lead height within 0.50 allocation; electrical owner records actual cell maximum/aging allowance.
Cure and service	Record material lots, cure/primer process, bond sample IDs, torque determined on PA12 pilot coupon, plug seating and repeated service result. No default torque without thread test.
Disposition	Blank results, missing component travel approval, unqualified cable seating, failed return or missing material master prevent release to finished functional article. Fit coupons may proceed to resolve these items.

Drawing tolerances are requested finished targets, not a claim of supplier capability. Supplier must identify process changes needed to achieve them before manufacture. If an adjustment cannot meet the stated range, record a nonconformance and revise CAD; do not grind through the wall or preload the switch.