

WALKIE ONE 20.2 / R8 ASTRA | Envelope and preserved placement



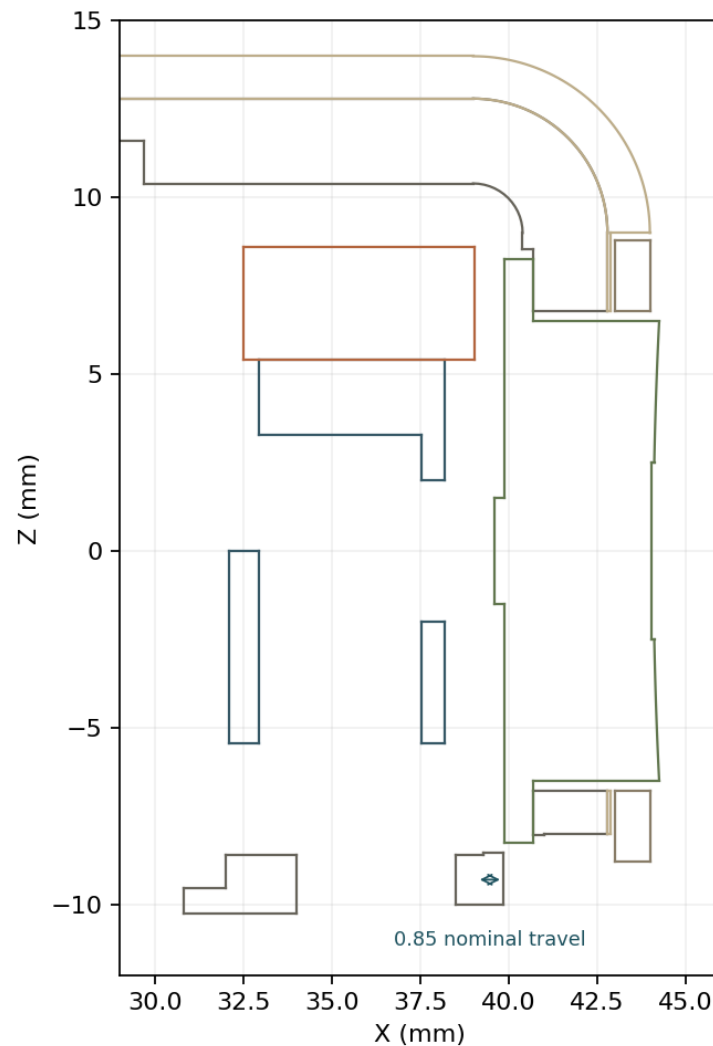
BODY: 88 x 136 x 27.2
Z rear -13.20; body front +14.00
PRIMARY LED tip +15.30
LED-inclusive depth 28.50

Action X0 / Y-46.50
Indicator X0 / Y-27.50
W width 34.00; centre X0 / Y24.00
PTT visible 69.60; centre Y10.00
Volume Y24.00 / Y0.00
Rear wordmark 44.00 at X0 / Y0
Origin line at X0 / Y-8

Closure screw relocated:
(-34,46) -> (-26,51)
Other three closure points unchanged.

O1 optical option is separate.
Primary retains the exposed dome.

WALKIE ONE 20.2 / R8 ASTRA | Side key / cassette / carrier



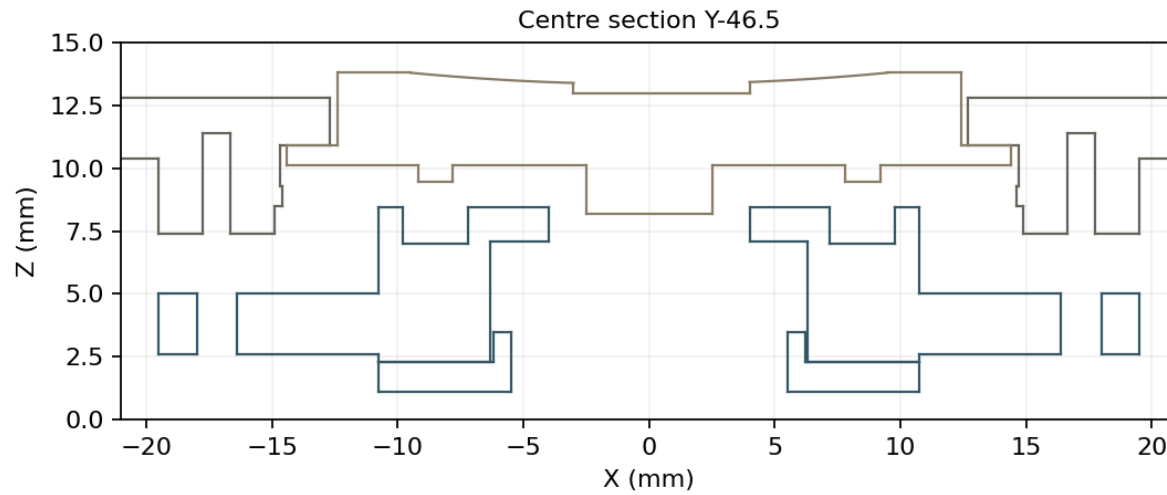
Section Y24; right-side volume key
Orange: removable stop cassette
Blue: adjustable switch carrier

Rest lip $|X|40.70$
Flange 0.80 ± 0.04 FINISHED
Stop $|X|39.05 \pm 0.03$ assembled
Lip-stop span 1.65 ± 0.06
 $S = 0.85 \pm 0.10$

Carrier face $|X|38.20$
Permitted delta $-0.52 / +0.58$
Slot 3.40×2.30 ; centre $|X|35.97$
Spring floor $|X|36.75$
Bore dia 2.60 ; peg dia 1.40×0.65

Cassette seat $Z8.60$
 $2 \times M1.6 \times 4$ at $|X|36, Y_c \pm 5$
Counterbore dia 3.60 to $Z6.80$
Pilot dia 1.25 to $Z11.80$
 $M2 \times 5$ clamp at $|X|36, Y_c + 9.2$
Machine/mask all contact datums.

WALKIE ONE 20.2 / R8 ASTRA | Front key / removable stops

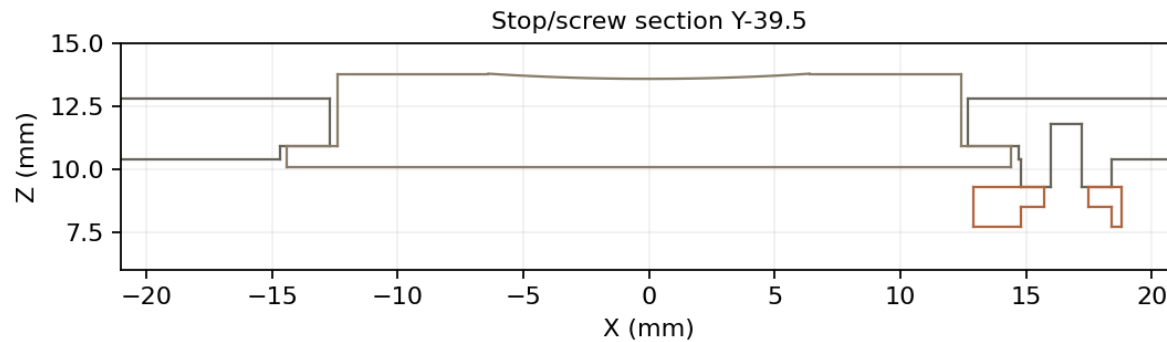


Ceiling Z10.90; flange 0.80 $\pm$ 0.03
Stop Z9.30; span 1.60 $\pm$ 0.04
S=0.80 $\pm$ 0.07 FINISHED

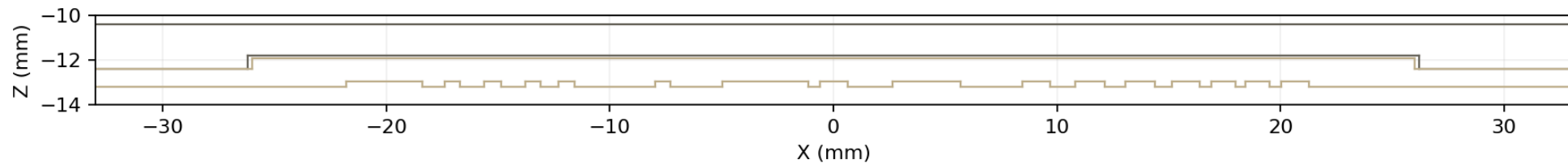
Four removable stop feet
3 screws: X $\pm$ 16.6, Yc $\pm$ 7
except upper-left: X-8 / Y-29.8
M1.6x3; underhead Z8.50
Tip Z11.50; pilot ends Z11.80
Front-wall floor $\geq$ 1.00

Carrier top Z8.45
Return floor Z7.00, dia 2.60
Jack screws M1.4x8, pitch 0.30
X $\pm$ 17.20, Y-46.50
Permitted carrier delta -0.52/+0.58
Two arm heights matched $\leq$ 0.03

Calibrate before PCB installation.
No post-make travel approval
is implied by the 0.08 test setting.

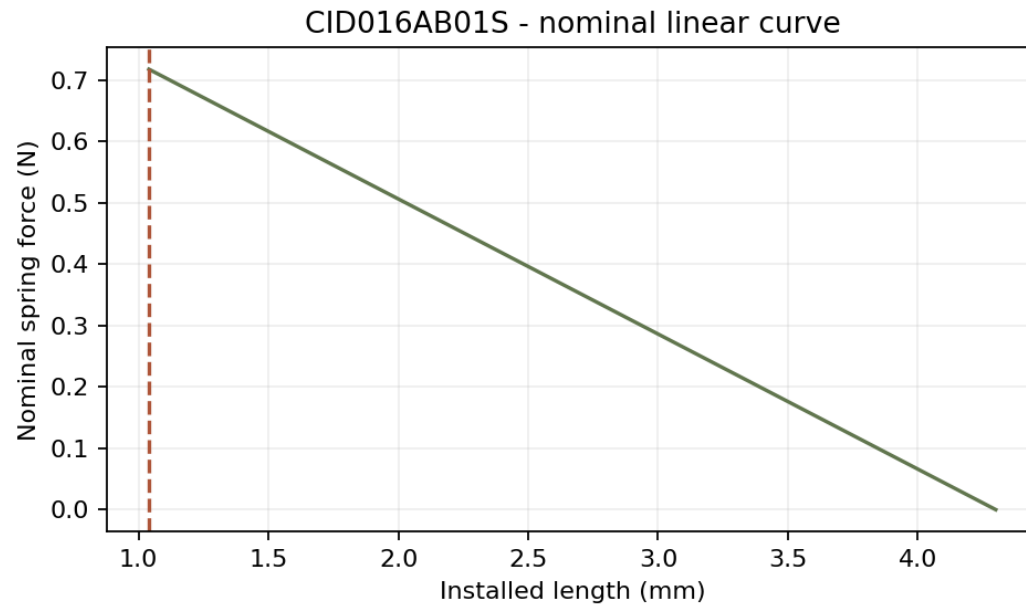


WALKIE ONE 20.2 / R8 ASTRA | Rear lettering and controlled bond



C04 representative actual-letter coupon: 64 x36 cut from the real rear assembly.
Outer rear face Z-13.20 retained. Perimeter skin0.80; local skin1.30 nominal.
0.25 deboss leaves1.05 nominal local floor (R7 control C05:0.55).
Inward pad52 x22 R2, centre X0/Y-3; pad face Z-11.90.
Cover pocket52.4 x22.4, floor Z-11.80; adhesive gap0.10 +/-0.03.
Residual cover wall1.40 to Z-10.40. No antenna-facing surface displacement.
Approve casting, demold, bond, grazing-light read-through and tonal fill on actual PU/PA12.

WALKIE ONE 20.2 / R8 ASTRA | Springs, finish and calibration limits

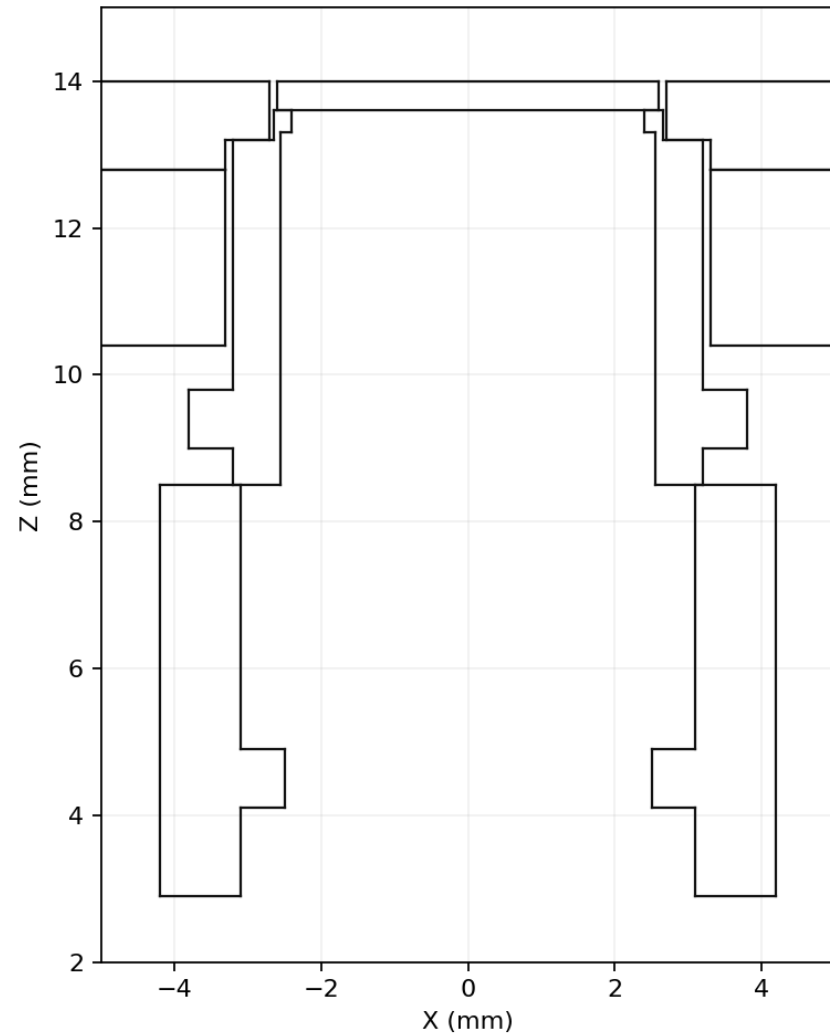


Lee CID016AB01S candidate
OD2.16 / ID1.84 / wire0.16
 $L_0 = 4.30 \pm 0.38$; $k = 0.22$ N/mm
Solid1.04; hole ≥ 2.50
Guide rod ≤ 1.50 (M1.4 selected)
8 returns +2 jack springs

Nominal returns: $L = 3.15/3.10$ rest
 $L = 2.30$ at stop, $F \approx 0.44$ N
No force/fatigue qualification implied.

Finished smaller-side gap: side ≥ 0.142 ; front ≥ 0.194 (specified process stack).
Rim face flushness $-0.05/+0.10$ relative to uncompressed adjacent skin.
Record rest freeplay, make, release, stop, force and carrier position on every control.
Computed freeplay side $0.20..0.74$; front $0.13..0.61$ (conditional on finished limits).
Acceptance: freeplay reading minus uncertainty ≥ 0.15 side / 0.10 front.
Provisional make-to-stop margin $0.06..0.10$; manufacturer loading approval remains OPEN.
Carrier demand $-0.46/+0.52$; permitted $-0.52/+0.58$ from R7 neutral.
Machine, measure and mask datums. Do not rely on raw SLS capability.

WALKIE ONE 20.2 / R8 ASTRA | O1 flush optical option - separate build



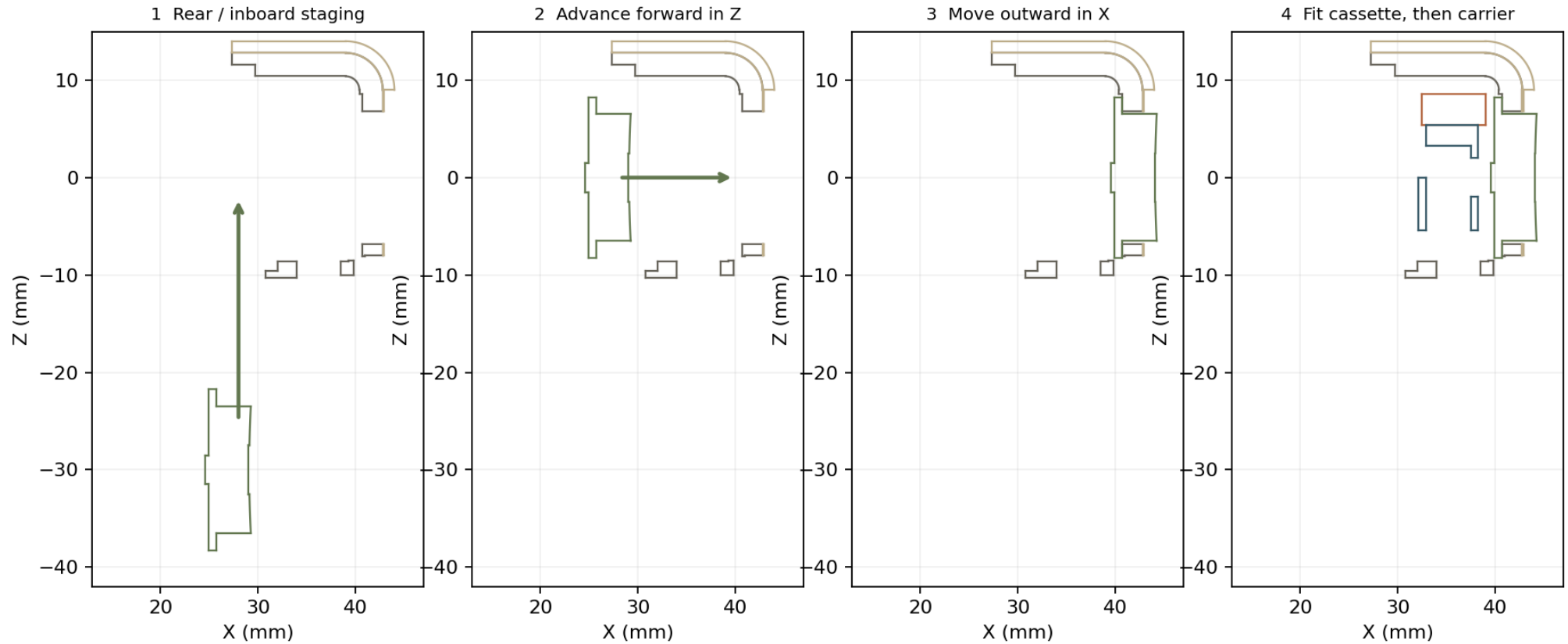
Visible centre X0/Y-27.50 retained
Unscaled LED translated -1.80 Z
LED tip Z13.50; window Z13.60..14
Disc dia5.20 x0.40 PMMA
Nominal air gap0.10; accept ≥ 0.05

POM lightwell OD6.40, ID5.10
Hidden dia6.60 counterbore
Z8.90..13.20 in tub/skin option
Visible aperture stays dia5.40
Upper shoulder bore dia4.80
Black nonconductive finish

Primary depth28.50 remains.
Option nominal overall depth27.20.

Test all RGB states, leakage,
brightness, retention and cleaning.
Actual lead/harness and bond
clearance require a physical sample.

WALKIE ONE 20.2 / R8 ASTRA | Ordered insertion - volume example



Actual Y24 CAD sections. Cover, electronics, mic, tray, stops and carriers absent for key insertion.

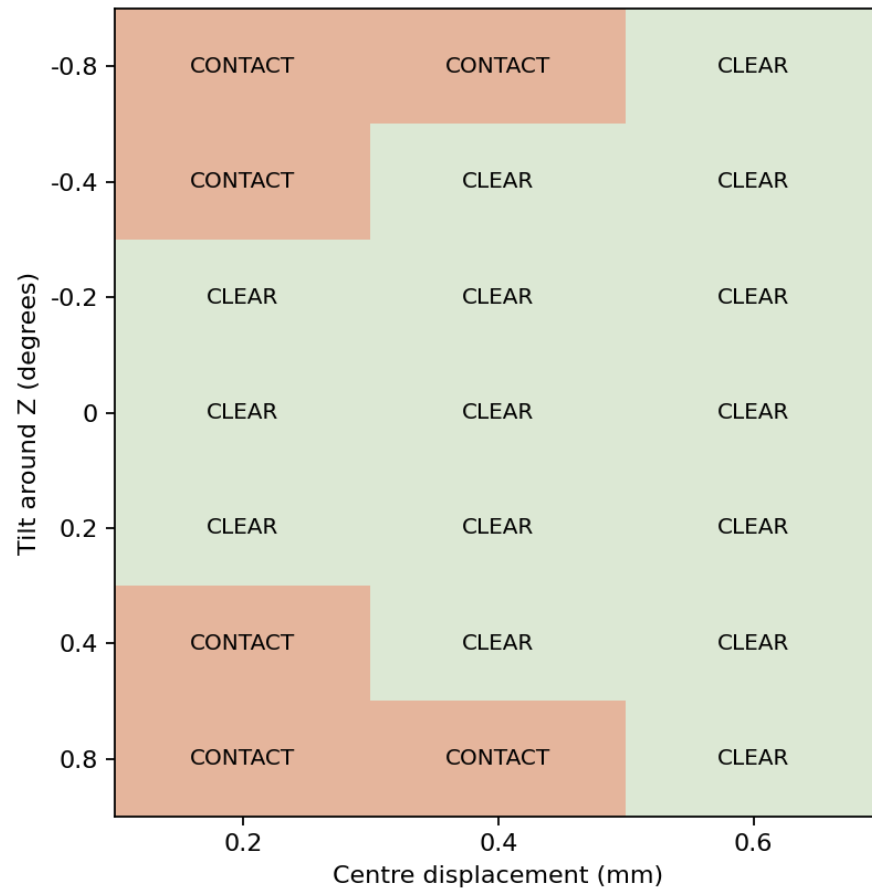
Mirror X staging for the left PTT; keep complete keys at fixed Y/orientation.

Cassette/carrier: stage 10 mm inboard and 30 mm rearward, advance Z, then move outward.

Front key enters directly from rear with four stops removed. Screw stops on afterward.

Reverse the sequence for service. Sampled nonintersection requires physical C01-C03 confirmation.

WALKIE ONE 20.2 / R8 ASTRA | PTT tilt screen and physical press locations



21 rigid PTT poses: 15 clear, 6 contact.
Contacts are against the tub/rest lip.
At 0.8 deg, end-centre offset is 0.486 mm.
A 0.2 mm centre press cannot permit that tilt without the opposite end trying to pass the retaining lip.

Physical 8 mm finger surrogate:
BOTTOM Y-19.8 / CENTRE Y10
TOP Y39.8; also test Z +/-4 edges.

Record applied-point and centre travel,
force, first make, release, hard stop,
rubbing and residual set.
Require make before stop at every point
and full return in all stated orientations.

Rigid-pose checks do not predict
friction, elastic tilt or tactile feel.