

Engineering revision handoff

Engineering file ID 5.2 | SR1 builds on R6

5.2 SR1 adds mechanical switch retention following version 26's split-cage and removable-clamp principle. Version 26 itself is unchanged and was not requalified.

Partial internal rebuild. Review the represented geometry and listed changes. Remaining CAD and physical qualification are explicit below.

Modeled size: 88 x 136 x 27.2 mm.



Use these files first

00_Handoff.pdf explains scope and assembly. 01_Current_CAD contains the SR1 STEP assemblies and individual parts. BOM_Represented_Parts.csv identifies the represented part files; Rapid_Open_Items.csv lists unresolved work.

The primary package supersedes earlier files only for the SR1 represented geometry. Earlier documents and appearance films remain historical references.

Changes and evidence

CAD checks apply to the revised interfaces and their represented neighbours

What changed

- Replaced three open bonded side-switch cradles with cages integrated into the front tub and removable screwed rear keepers.
- Added two front-switch corner retainers and a screwed cassette mounting, preserving calibrated seat and stop shims.
- Relieved the battery-tray ear and added rear-loading and screw-head access clearances.

What was checked

- 24 of 24 switch-body translation probes meet opposed retaining surfaces: four switches, six directions, 0.35 mm displacement.
- 18 side-button positions from 0 to 0.65 mm, 21 rear-loading positions, and six side-keeper screw-head envelopes checked.
- No unwanted static intersections above 0.0001 mm³ in the screened parts/hardware. STEP solids are valid; changed-part meshes are watertight.

Static or sampled rigid-body checks do not prove force, allowable switch overtravel, rocking, spring return, tolerance extremes, fatigue, electrical function or production readiness.

Assembly and service

Sequence for the changed interface; complete device assembly remains open

1. With rear cover, rear grip/lip, battery and PCB removed, fit side caps and pushers into the front structure. On 23.2 the relieved diaphragms and rigid pushers form a matched set.
2. Load each side switch rear-to-front, actuator outward. Keep terminals and wires in the relief slots. Fit its rear keeper using two M2 × 6 screws.
3. For 5.2, retain the front switch and calibrated shims in its cassette using the two corner bars and M2 × 5 low-head screws (head envelope Ø3.5 × 1.0 mm). Screw the cassette to its housing bosses. For 21.2B and 23.2 retain the existing screwed front reaction plate.
4. Install PCB, battery and harness without trapping wires; close the rear. Verify actual actuation, free return, end presses, screw access and switch limits before endurance testing.

Material and fastener assumptions

Confirm polymer and elastomer grades, manufacturing process, finished tolerances and surface treatment with the supplier. Modeled screw envelopes do not specify a purchased drive or thread profile. A 1.7 mm pilot, where used for M2, is a prototype assumption requiring process and torque qualification.

No adhesive or flexible gasket envelope is permission to print that layer as a rigid solid. Review the material role of every part. Nominal switch case bearing faces require actual dimensional and clamping checks.

Remaining work before release

These items are not marked passed by the new CAD or website publication

1. Measure actual switch free play, gap, travel, return and long-PTT centre/end actuation across manufacturing tolerances. The nominal 0.65 mm stop is not a certified switch overtravel limit.
2. Qualify M2 pilot preparation, thread engagement, torque, driver access, screw pull-out and keeper strength in the selected material.
3. Complete physical assembly with the actual harness; qualify electrical, acoustic, optical, RF, thermal, sealing and durability performance.
4. Complete inherited system work: 21.2B has no fully verified PCB/battery/harness layout; 23.2 retains unqualified diaphragm, PCB support, closure and USB assumptions; 5.2 retains its calibration and broader qualification requirements.

Manufacturing decision

Review and quote the current engineering work with these limitations. Select and verify the affected process and hardware before making functional parts. Complete the missing mechanical work, full assembly checks and physical fit prototype before approving a working device or production batch.

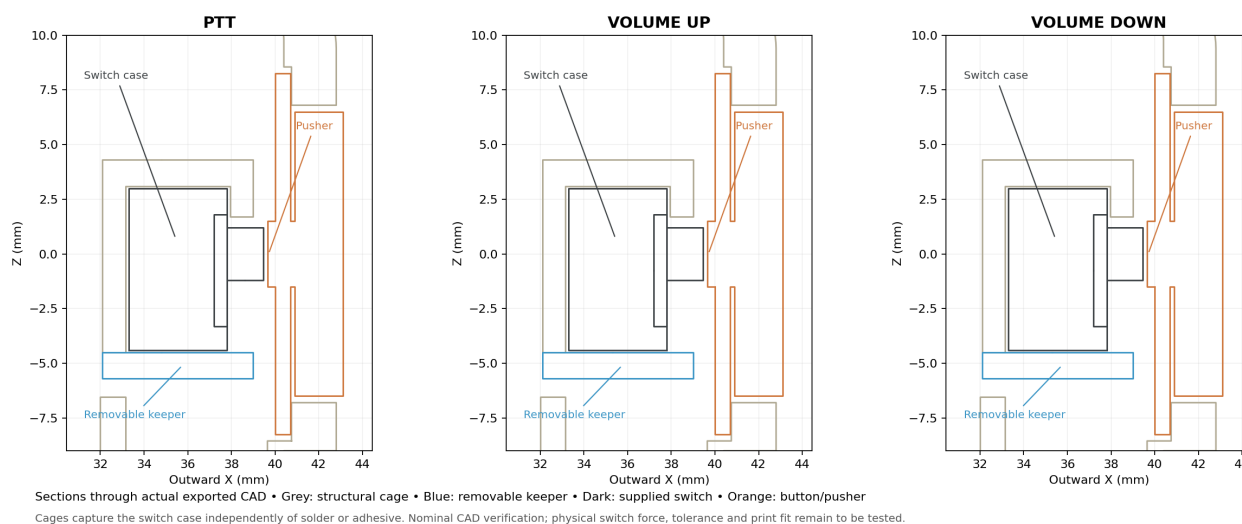
Version control

Use SR1 together with this handoff and its file inventory. Do not mix SR1 replacement components with earlier carriers, switches or untrimmed layers. The website preserves historical download URLs; those files are not the current engineering instruction.

Engineering sections

Appendix A | Sections generated from the actual revised CAD

Walkie One 5.2 | SR1 mechanical switch capture



Dimensions in the section image are millimetres in the design coordinate system. The displayed section is a geometric inspection aid, not a fully tolerated manufacturing drawing.

Side-button gaps are nominally 0.14 mm, with modeled stops at 0.65 mm. Check actual switch limits and tolerances; these values do not certify allowable overtravel. See the front-switch sections in the package for the retained front interfaces.

File authority and check limits

Appendix B | Reproducible inputs and remaining qualification

Current geometry

The SR1 reference STEP is the assembly authority for represented geometry. STEP contains editable solids; a native Fusion feature timeline is not provided.

Individual parts

The parts directory follows the represented assembly. Component groups may contain multiple solids. Treat this as a represented-parts inventory, not a complete procurement BOM.

Fit meshes

Changed-part STL files are installed-coordinate fit-study candidates; they include different material roles and are not automatically bed oriented. A full device STL or 3MF fabrication kit is not released.

Source and evidence

03_Verification contains the checks listed below. 05_Editable_Source contains the builders; the separately linked combined SR1 archive includes their immutable inputs.

Reports: retention_verification.json, build.json

Assembly SHA256: 577c3a8a0d0f4c0f17ce994933731bcabc86356d51fb2220353b324d721b634a

Missing harness and process details affect their final interfaces and qualification. They do not prevent independent CAD corrections; unfinished mechanical work remains listed on page 4.