

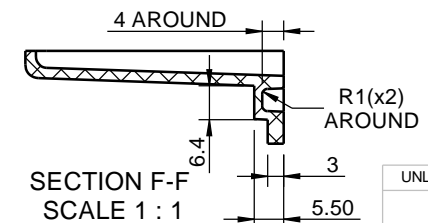
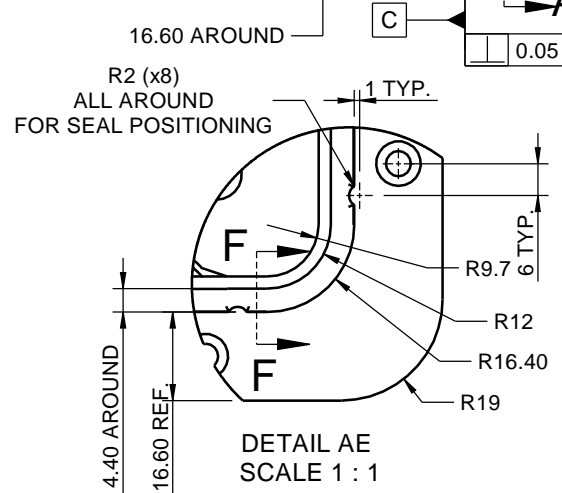
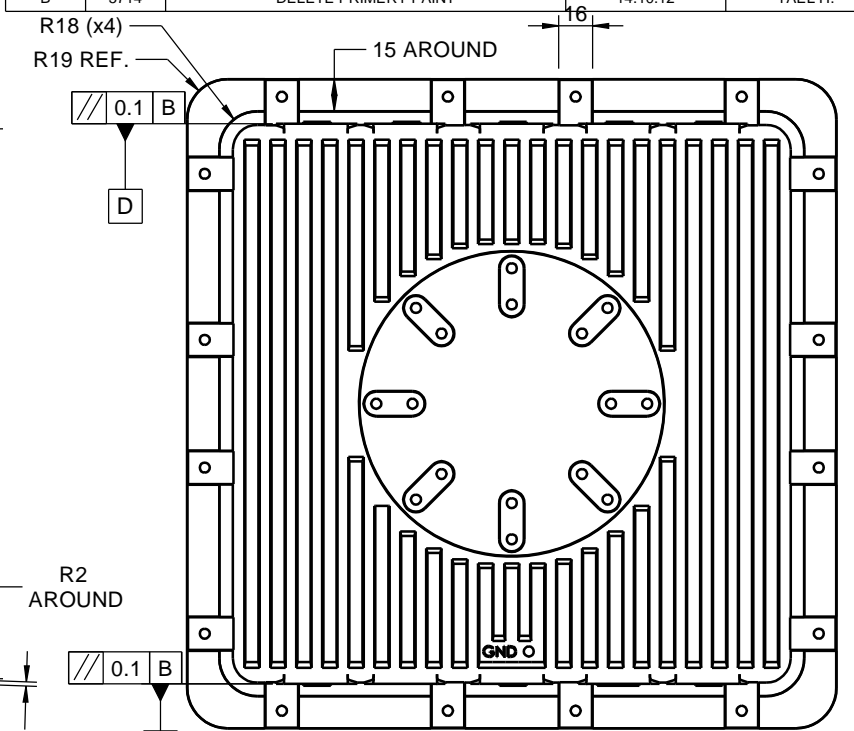
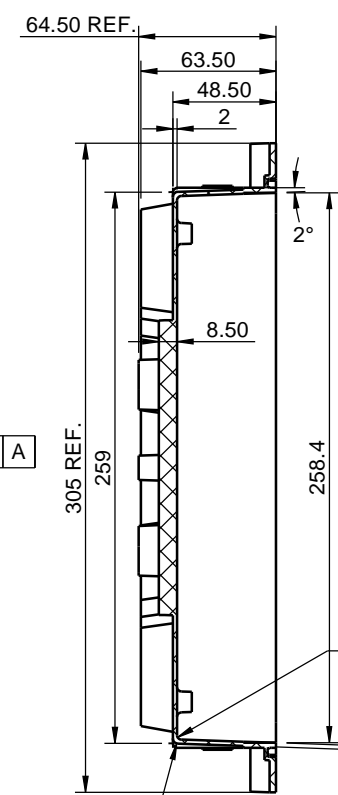
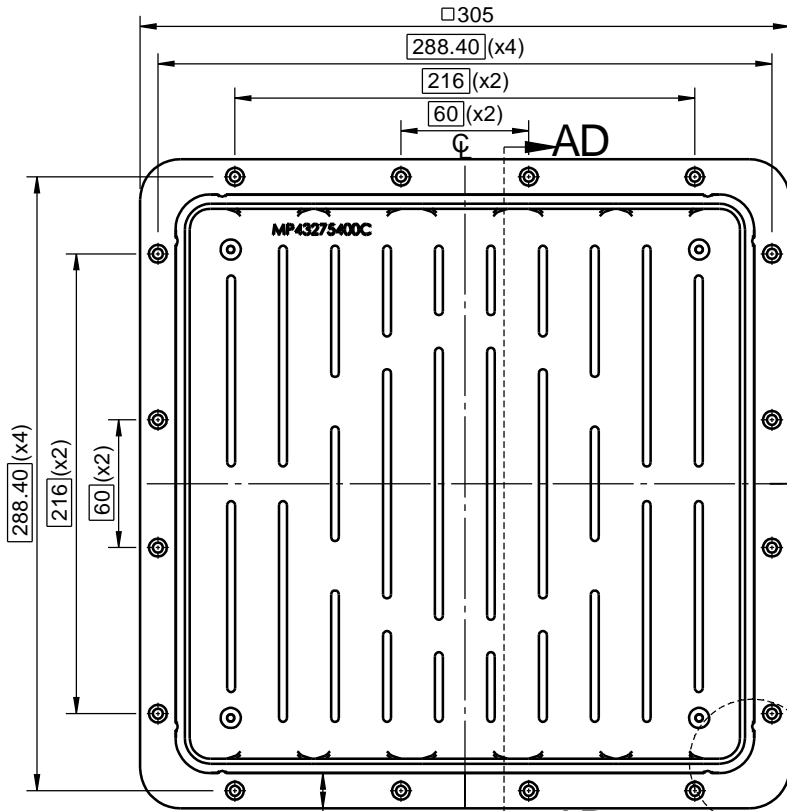
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SHEET REVISION STATUS

5	4	3	2	1	SHEET NO
				B	LATEST REV

REVISIONS

REV.	ECO	DESCRIPTION	DATE	APPROVED
03		CHANGED HOLES DIMENSIONS SHEET 2 & SHEET 3	04/09/2011	Laria M.
04		UPDATED MODEL	05/12/2011	Larisa M.
05		Added Detail AN	15/12/2011	Larisa M.
A	DE74	RELEASED	30.8.12	Yael H.
B	5714	DELETE PRIMERY PAINT	14.10.12	Yael H.



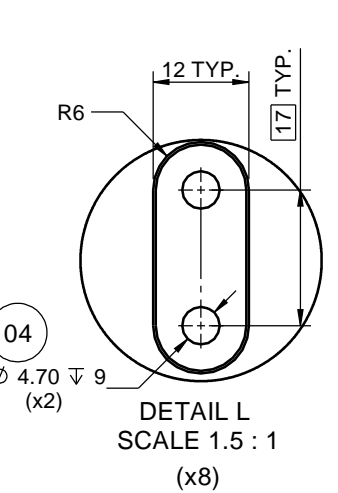
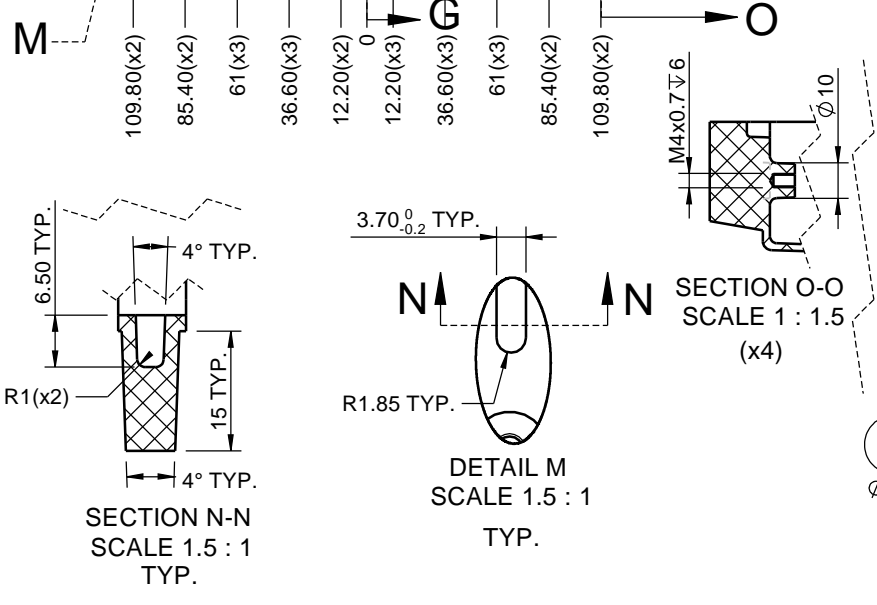
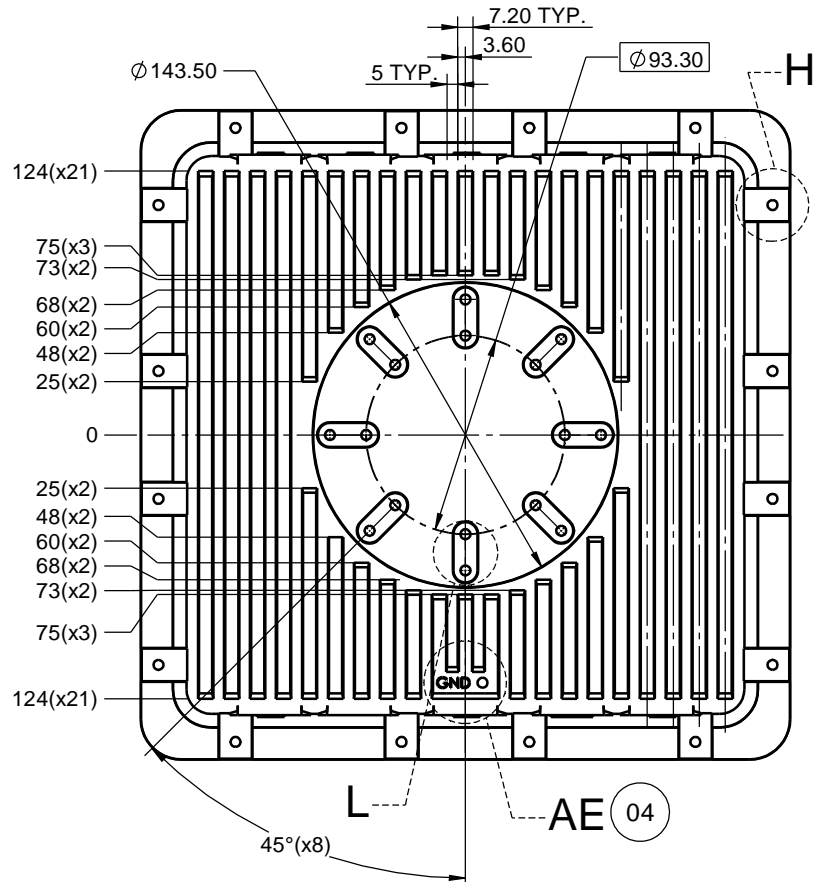
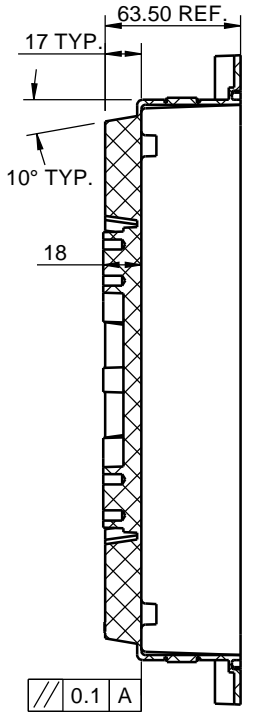
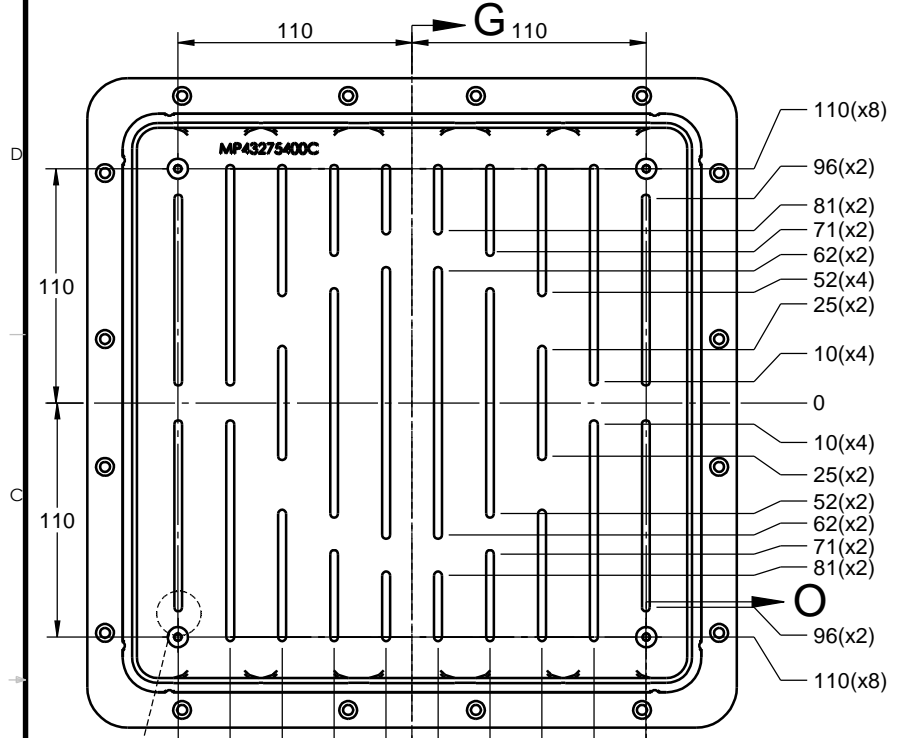
SECTION AD-AD

SECTION F-F
SCALE 1 : 1

FOR MANUFACTURING, PAINTING, QUALITY ASSURANCE AND PACKING INSTRUCTIONS SEE LAST PAGE

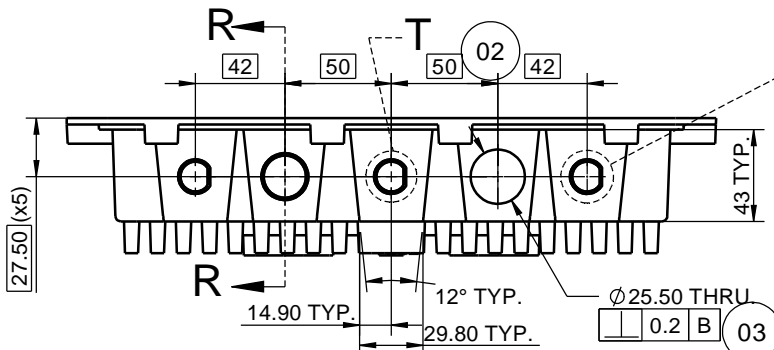
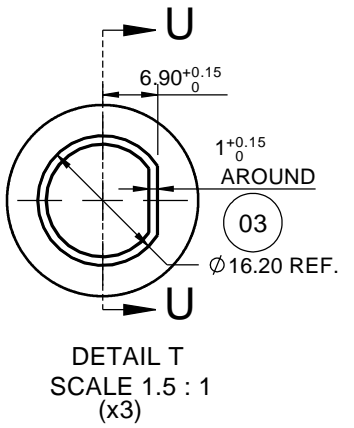
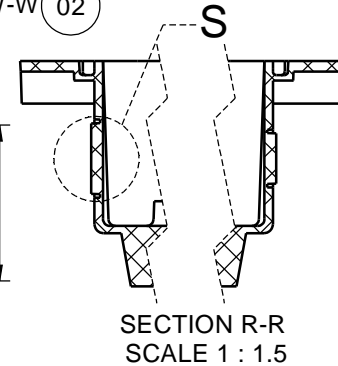
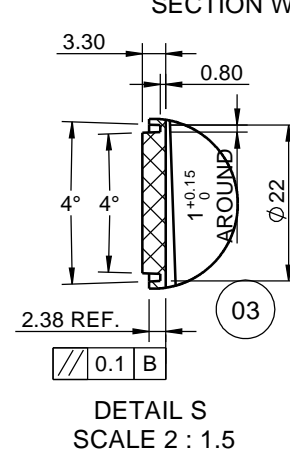
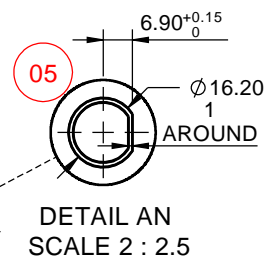
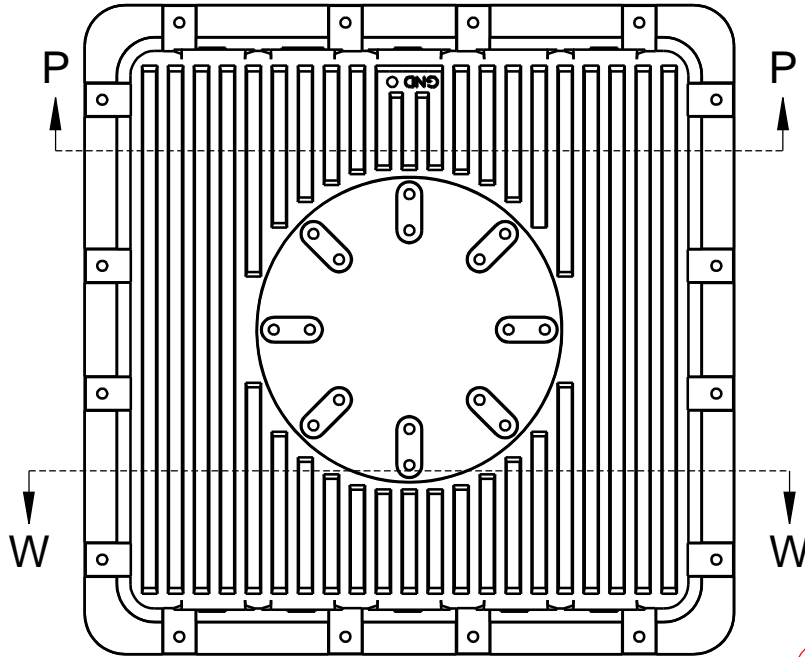
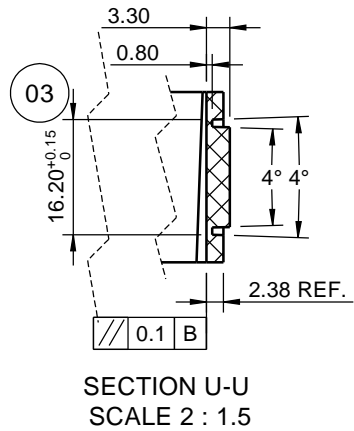
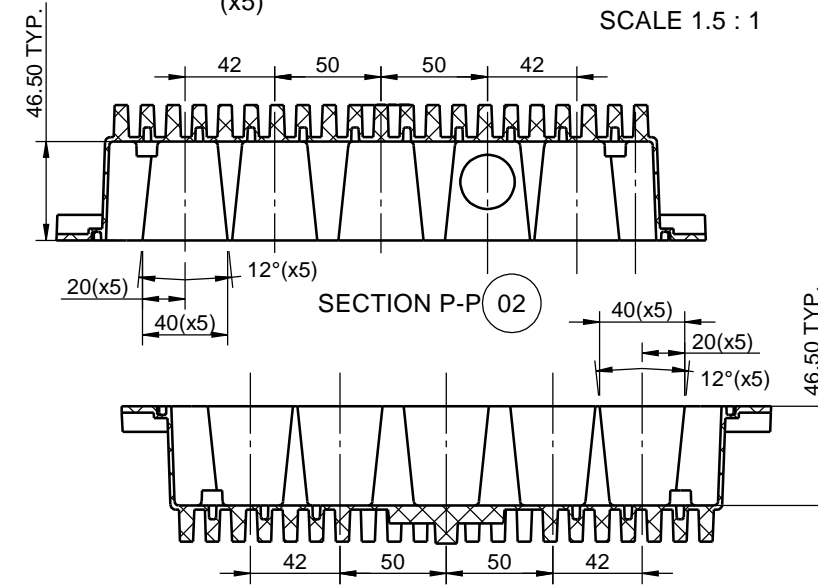
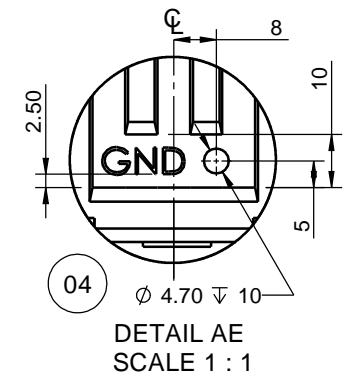
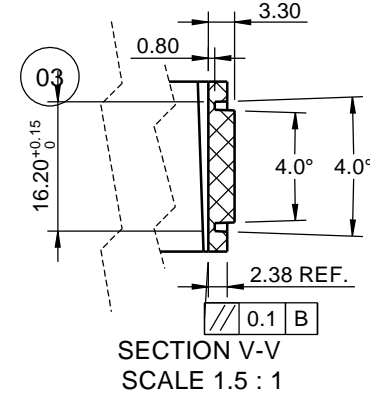
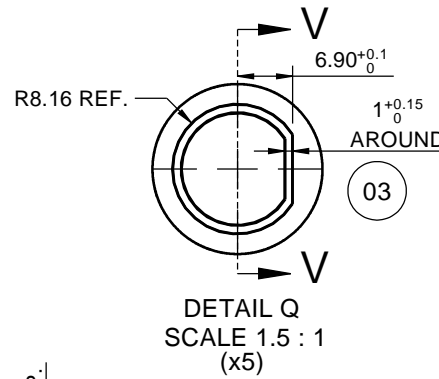
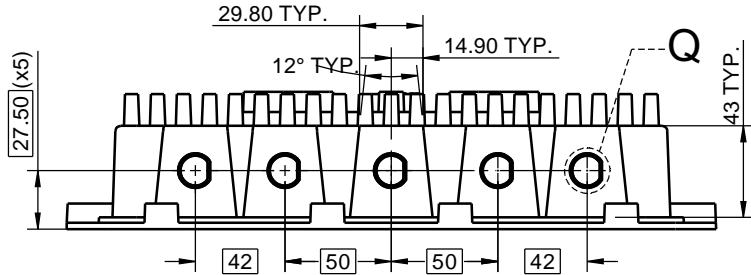
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN mm PER ANSI Y14.5M-1982	CONTRACT TO				
	DWG	Yael	Yael		26.8.12
TOLERANCE	CHKD				
LINEAR	ILAN V.	I.V.	26.8.12	TITLE Radio Enclosure 1ft (AZ91D 305x305mm)	
ANGULAR	PROJ	ILAN V.	I.V.		26.8.12
±0.2	±2 °			SIZE A3	
MT-900042	QA	SHLOMO A.	S.A	26.8.12	DWG NO MP43275400C
NEXT ASSY	SURFACE TEXTURE IN MICRO IN.			SCALE- 1:2.5	SHEET 1 OF 4

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SIZE A3	Rev 05	DWG NO	
SCALE- 1:2.5		SHEET 2 OF 4	

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PART PRODUCTION INSTRUCTIONS

1. PRODUCTION INSTRUCTIONS:

- 1.1 MATERIAL: MAGNESIUM ALLOY AZ-91D.
PER ISO 10049, POROSITY LEVEL 4
- 1.2 ALL RADIUS NOT SHOWN ARE R1mm
- 1.3 REMOVE SHARP EDGES.
- 1.4 PART SURFACE ROUGHNESS: 63 micro -inch
- 1.5 PLATING: CHEMICAL CONVERSION COATING (Alodine) per MIL-C-5541 CLASS III. RoHS Compliance. 96 hours salt test.
- 1.6 MARK THE PART WITH THE FOLLOWING:

PART No.
'GND' NOTE
MANUFACTURE DATE
REVISION CODE (letters)

PROTRUSION OF LETTERS AND NUMBERS: 0.3mm

2. PAINTING INSTRUCTION:

- 2.1 PAINT: POLYURETHANE, POWDER PAINTED, COLOR RAL9002, 50-60microMeter, TEXTURE FINISH

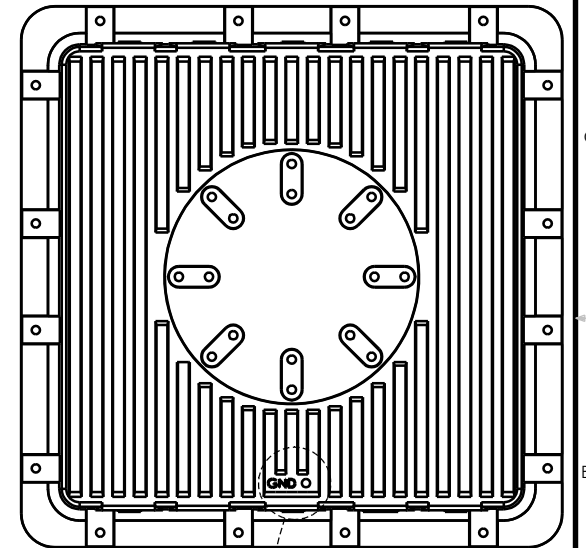
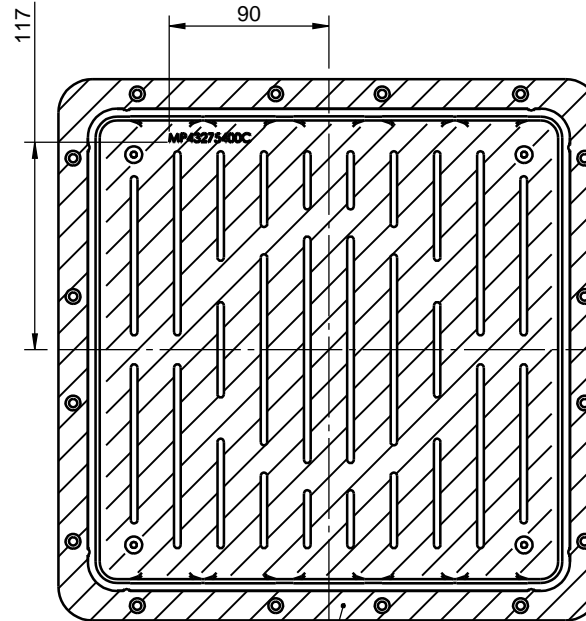
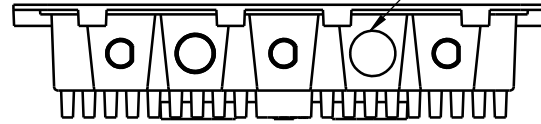
3. QUALITY ASSURANCE

- 3.1 THE PART SHALL BE WITHOUT ANY DEFECTS (DIMENSIONS, SPECIALLY WALL THICKNESS, SCRATCHES, CAVITIES AND SURFACE DISTORTIONS)
- 3.2 THE PAINT ADHESION SHALL BE CHECKED, IN EACH BATCH, BY SCRATCHING .
- 3.3 ALL HOLES , GND HOLE AND INTERNAL SURFACE SHALL BE FREE OF PAINTING.
- 3.4 WITH EACH SHIPMENT THE MANUFACTURER WILL PROVIDE: RAW MATERIAL REPORT, COATING REPORT, MEASURE REPORT, SALT & SPRAY REPORT, SEALING TESTING REPORT.
- 3.5 ON EACH SHIPMENT - 5 OUT OF 100 WILL BE TESTED FOR SEALING (0.2 BAR FOR 10 MIN).

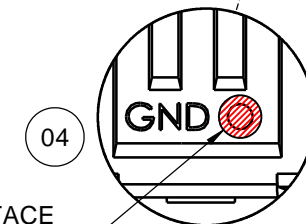
4. PACKING INSTRUCTION:

- 4.1 EACH PART SHALL BE PACKED IN A NYLON BAG.
- 4.2 5 UNITS SHALL BE PACKED IN A 3 PLIES CARTON BOX, WITH A SEPARATION BOARD BETWEEN THEM.
- 4.3 PACKAGE MARKING. THE PARTS BOX WILL BE FREE OF ANY MARKS THE BOXED PARTS WILL BE SHIPPED IN A CASE WITH ALL THE MARKED REQUIRED.

MASK THE HOLES FROM PAINT



MASK THE SURFACE FROM PAINT



Ø8
MASK THE SURFACE FROM PAINT

DETAIL AM
SCALE 1 : 1

SIZE A3	Rev 05	DWG NO	
SCALE- 1:2.5		SHEET 4 OF 4	