

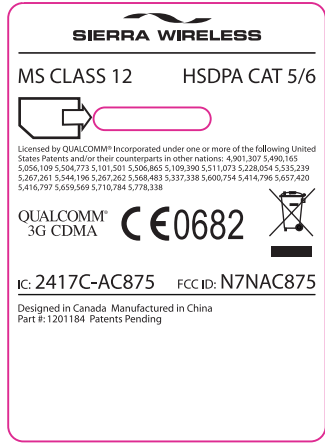
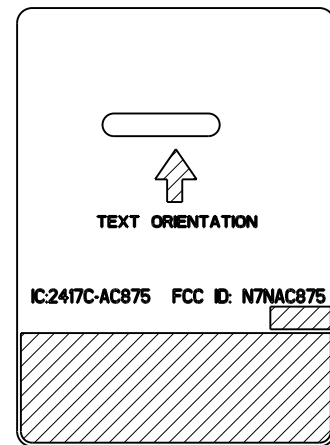
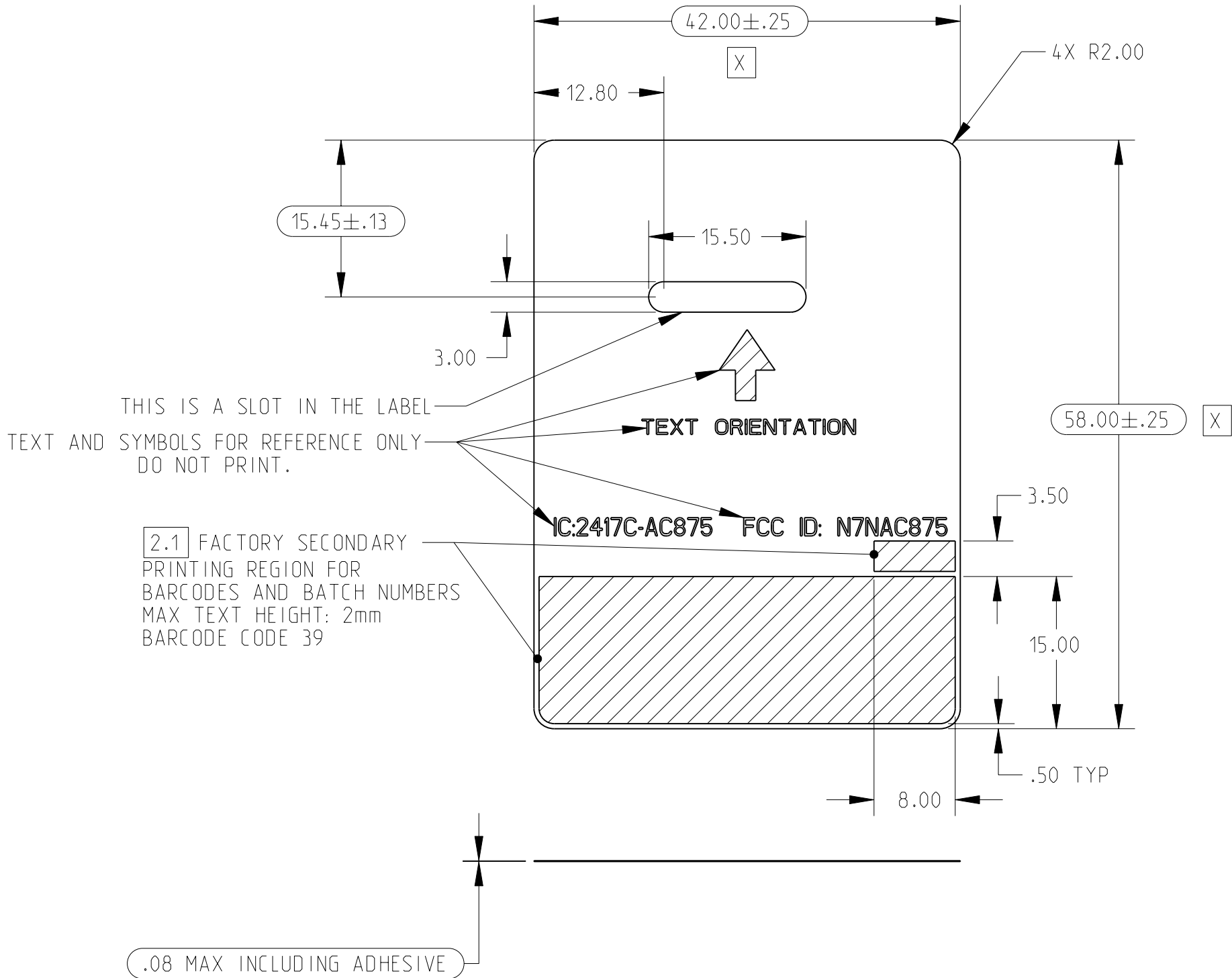
REV	DESCRIPTION	ECO	DATE	DRAWN	APPD
1.0	FIRST RELEASE	N/A	11- JUL -06	DF	BG

I. NOTES APPLICABLE TO PART MANUFACTURER:

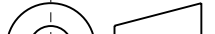

1. APPLICABLE DOCUMENTS:
ASME Y14.5M-1994 GEOMETRIC DIMENSIONING AND TOLERANCING
2. MATERIAL:
 - 2.1 LABELS PRINTED ON WHITE THERMAL TRANSFER MATERIAL FLEXMARK FLEXCON OR APPROVED EQUIVALENT, .002" THK WITH .001" MAX THK #400 ACRYLIC ADHESIVE.
 - 2.2 USE UV INKS
 - 2.3 .0032" 55# DENSIFIED KRAFT RELEASE LINER; RELEASE LINER ON ROLL SIDE.
3. GENERAL REQUIREMENTS:
 - 3.1 PARTS SHALL BE CLEAN AND FREE OF ALL FOREIGN MATTER.
 - 3.2 REFERENCE LABEL ARTWORK P/N 2100864.
 - 3.3 SUPPLY LABELS ON KISS CUT ROLLS 8" MAX. OD WITH A Ø3" CORE, UP TO 2000PCS PER ROLL, WITH THE EXCESS REMOVED AND CLEAN EDGES AFTER DIECUTTING.
 - 3.4 THE DIE-LINE IS FOR REFERENCE ONLY, AND IS NOT TO BE PRINTED.
4. CONTROLLING GEOMETRY IS DEFINED BY PRO/ENGINEERING DATABASE.
ALL SURFACE TO BE WITHIN 0.25 OF DATABASE 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, INC. 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 THE 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 100 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, INC. ALONG WITH THE MEASURED PARTS.
6. PACKAGING REQUIREMENTS: PARTS SHALL BE PACKAGED ON KISS CUT ROLLS, 8" MAX. OD WITH A Ø3" CORE, UP TO 2000PCS PER ROLL, WITH THE EXCESS REMOVED AND CLEAN EDGES AFTER DIECUTTING.
7. EXCEPTIONS: NO CHANGE SHALL BE ALLOWED ON PRODUCTION MATERIAL, REGARDLESS OF WHETHER SUCH CHANGE AFFECTS REQUIREMENTS SPECIFIED, WITHOUT PRIOR EXPLICIT WRITTEN APPROVAL BY SIERRA WIRELESS, INC. MECHANICAL ENGINEERING GROUP.

II NOTES APPLICABLE TO CONTRACT MANUFACTURER:

1. INCOMING INSPECTION DIMENSION MARKED BY (XX.XX) .
2. SAMPLE INSPECTION PER QEI-II-0000-18
3. CONTRACT MANUFACTURER SHALL REQUIRE PART MANUFACTURER TO PROVIDE SPC DATA AND REVIEW WITH SIERRA WIRELESS MECHANICAL ENGINEERING GROUP.



SCALE 1/1

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE PER THE FOLLOWING TOLERANCES:					PROJECT NAME		PART DESCRIPTION			
INCHES MM .X ± .05 .X ± .25 ANGLES .XX ± .01 .XX ± .13 X ± 5° .XXX ± .005 .XXX ± .05 X.X ± 1°					AC875		LABEL, BACK, AC875, C INGLAR			
MATERIAL SEE NOTES FINISH SEE NOTES <div style="border: 1px solid black; padding: 5px; text-align: center; font-size: 1.2em;">DO NOT SCALE PRINT</div>			DRAWN D. FLORESCU		DATE 11-JUL-06		 SIERRA WIRELESS <small>HEART OF THE WIRELESS MACHINE™</small>		13811 Wireless Way Richmond, British Columbia Canada, V6V 3A4 Tel: 604.231.1100 Fax: 604.231.1109	
			DES ENGR D. FLORESCU		DATE 11-JUL-06					
			ENR B. GILBERT		DATE 11-JUL-06					
			PRT FILENAME 2100823							
			DRAW FILENAME 2100864							
			RELEASE LEVEL Development		0+		SIZE UNITS DRAWING NO. <div style="display: flex; align-items: center; justify-content: space-around;"> C MM 2100864 </div>		REV 1.0	
					SCALE: 2/1		SHEET 1 OF 1			

UNLESS OTHERWISE NOTED, THIS DOCUMENT CONTAINS SIERRA WIRELESS CONFIDENTIAL INFORMATION. REPRODUCTION, USE, DISCLOSURE OR TRANSMITTAL OF ALL OR ANY PORTION OF THIS DOCUMENT IS PROHIBITED, EXCEPT TO THE EXTENT APPROVED BY SIERRA WIRELESS. SIERRA WIRELESS EXPRESSLY RESERVES ALL RIGHTS UNDER PATENTS, TRADEMARKS, COPYRIGHTS AND TRADE SECRETS. COPYRIGHT (C) 2006, SIERRA WIRELESS.