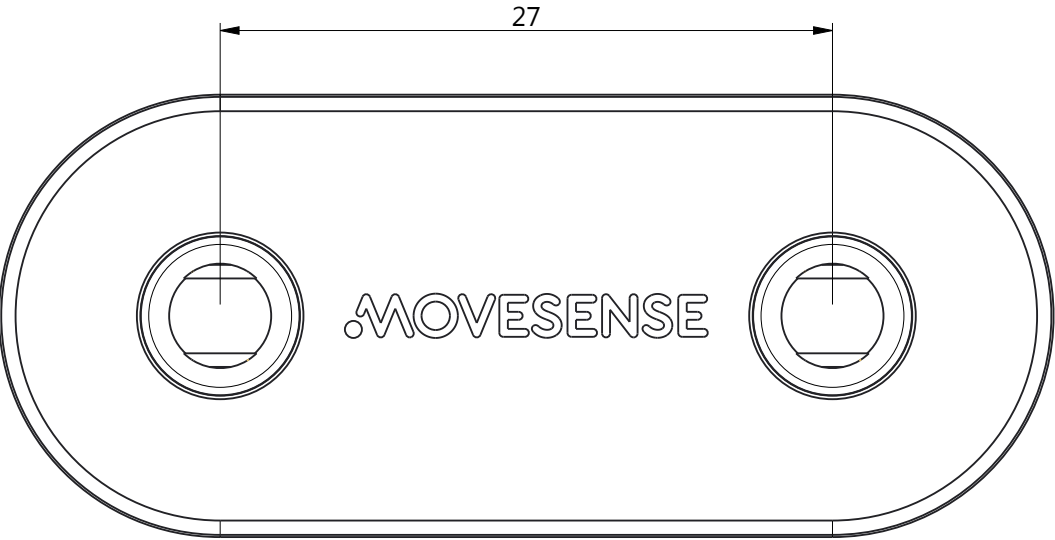
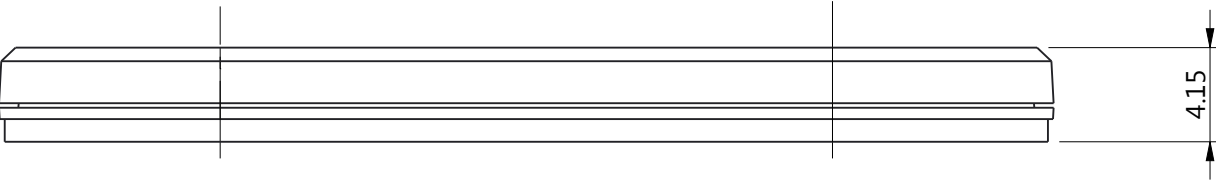
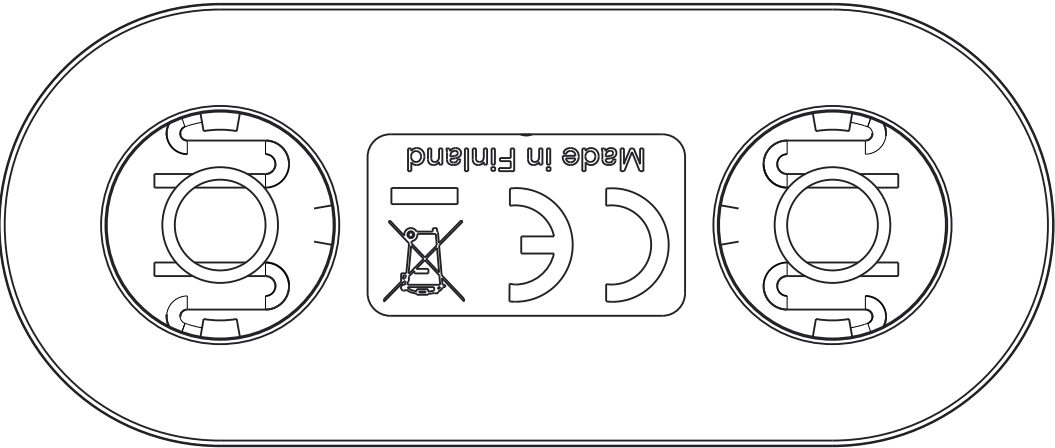
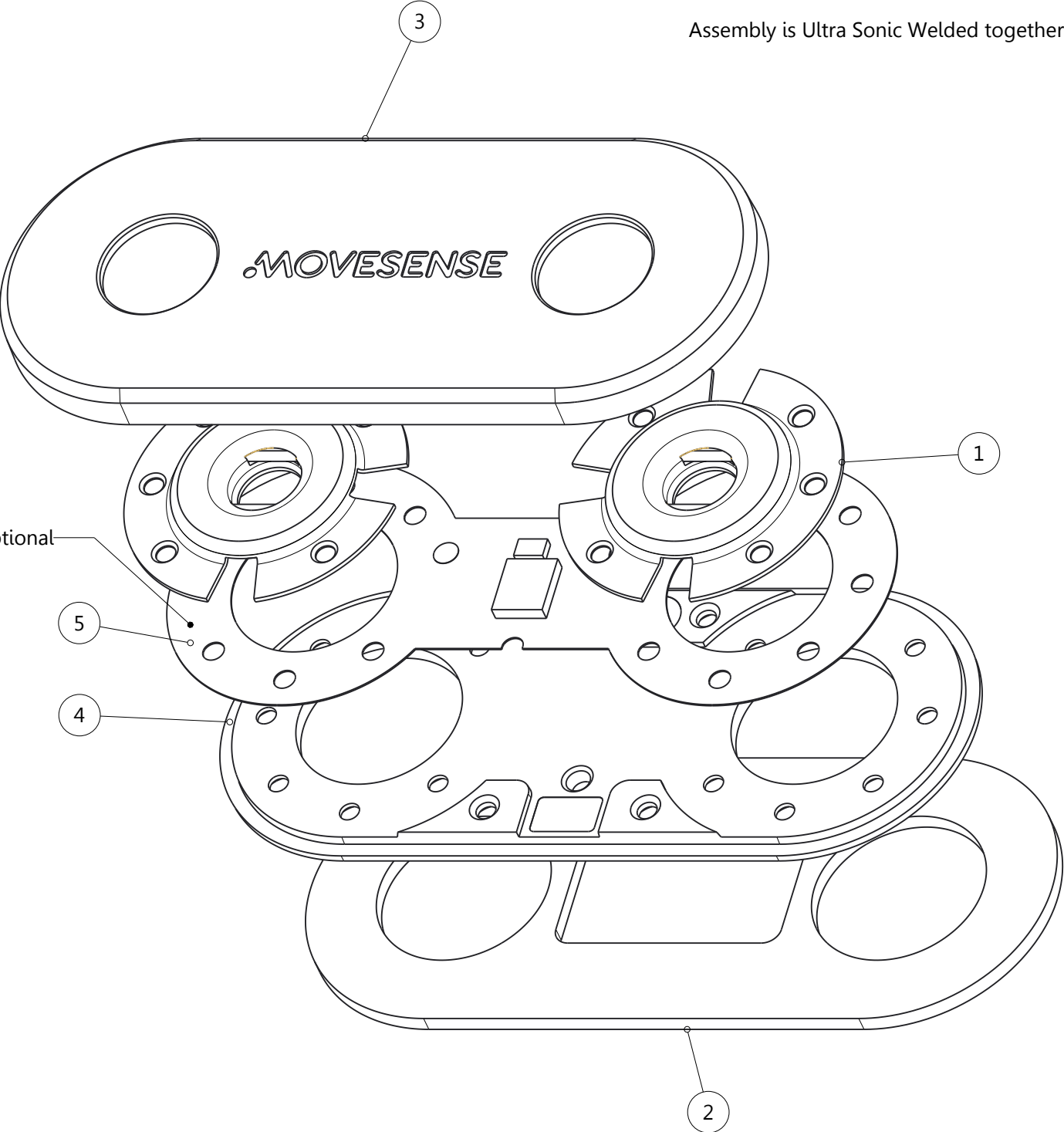


SURFACE MOUNT ASSEMBLY / MOVESENSE CONNECTOR



Movesense connector PCB optional

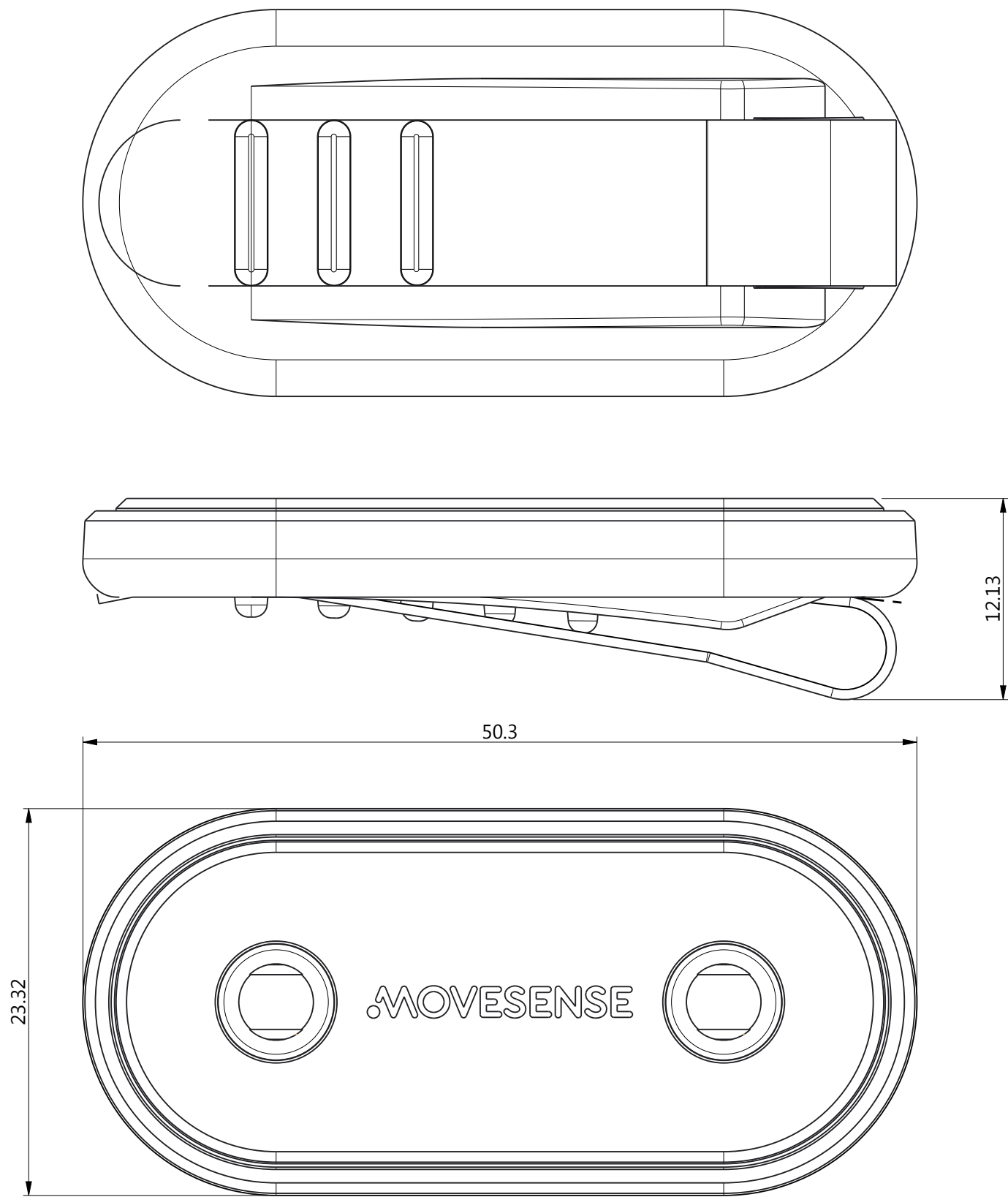


Assembly is Ultra Sonic Welded together

Name SURFACE-MOUNT-ASSEMBLY			Material		Tolerance Table		4	
Geometry number 74974A	Part revision 1	Drawing version 1.8	Surface finish		Dim. Range	Tolerance	3	
	Sheet 1/3	Project number Movesense Accessories	Surface Treatment				2	
	Scale 3:1	Approved for In Work	Other				1	Pull-out test to check USW and adhesive quality
	Size A3	Created by Date 8.5.2018	Weight 3.54g				Note Table	

1	2	FLAT-SNAP-MOVESENSE		1.5	In Work
2	1	MOVESENSE-ACCESSORY-ADHESIVE-3		1.6	In Work
3	1	MOVESENSE-ACCESSORY-COVER		1.16	In Work
4	1	MOVESENSE-ACCESSORY-PLATE		1.21	In Work
5	1	MOVESENSE_CONNECTOR_PCB_02		1.1	In Work
No.	Qty.	Name	Item No.	Version	Approval State

CLOTHES CLAMP ASSEMBLY



Storage and Application guide lines for Pressure Sensitive Adhesives

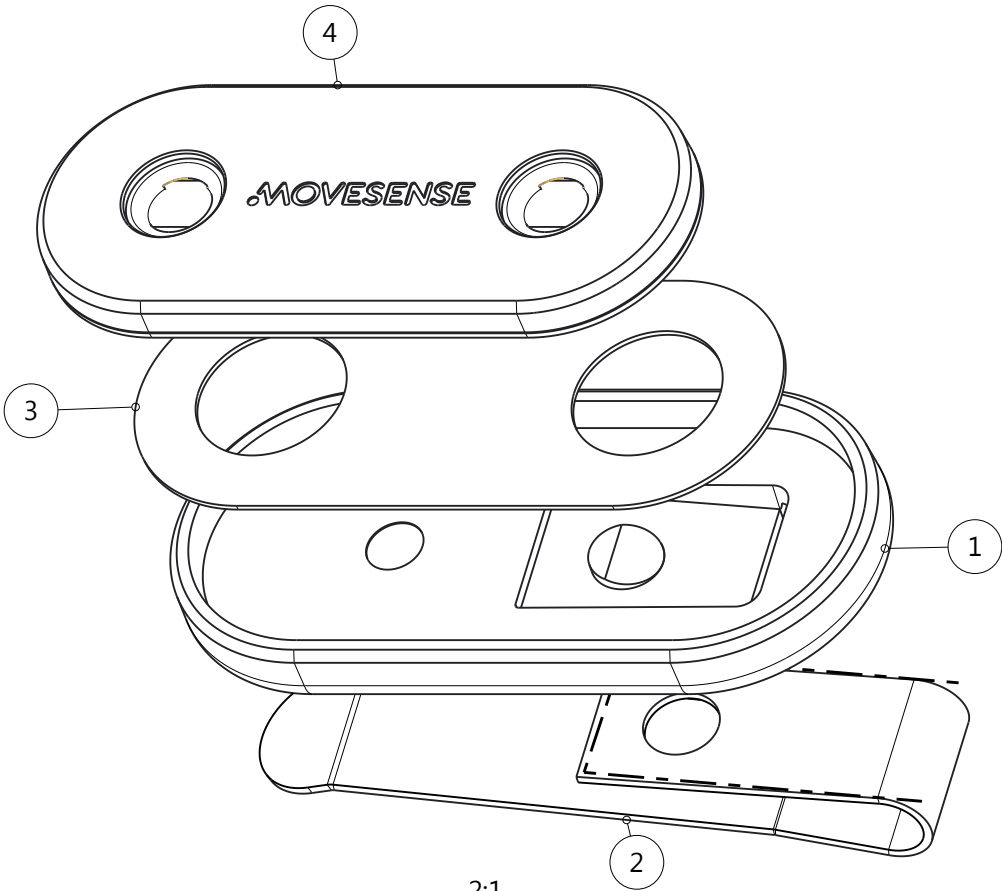
Storage:
- Pressure Sensitive Adhesives (PSA) should be protected against direct UV-light and extremes in temperature and humidity. Store the material between 18°C and 25°C in original packaging.
- When receiving the material allow it a minimum of 24 hours to acclimatize before use.

Surface preparation:
- All surfaces should be clean and free from dust, grease and other contaminations.

Application temperature:
- Ideal temperature for bonding is between 20° C and 35° C, lower temperature will give lower direct adhesion and higher temperature will generally give more direct adhesion.

Application pressure:
- Pressure Sensitive Tape need surface contact, for this an minimum application pressure is needed of 1 kg/cm² for a time of 1 to 3 seconds for shiny and flexible surfaces and 2 kg/cm² for a time of 3 to 5 seconds for smooth and rough surfaces, this can be done by a pressure roller or pressure plates (more pressure and longer time will result in higher direct adhesion).
- After application pressure the adhesive will flow onto the surface and the bond strength will increase in time, general guide lines to achieve ultimate bond strength:
50 % after 30 min
90 % after 24 hrs
100% after 72 hrs
(depending on temperature and surface conditions)

NOTE: In this application tape shall be pressed with 120 - 150 N for 5 seconds.



Name CLOTHES-CLAMP-ASSEMBLY			Material		Tolerance Table: Class fine		4	
Geometry number 74974A	Part revision 1	Drawing version 1.8	Surface finish		Dim. Range	Tolerance	3	
	Sheet 2/3	Project number Movesense Accessories	Surface Treatment		> 0,5 - 3	±0,05	2	
SUUNTO	Scale 3:1	Approved for In Work	Other		> 3 - 6	±0,05	1	Pull-out test to check USW and adhesive quality
	Size A3	Created by Date 8.5.2018	Weight 3.54g		> 6 - 30	±0,1		
					> 30 - 120	±0,15	Note Table	

1	1	HOUSING-CLOTHES-CLAMP		In Work
2	1	MA-CLOTHING-CLAMP-SPRING		In Work
3	1	MOVESENSE-ACCESSORY-ADHESIVE-2		In Work
4	1	MOVESENSE-CONNECTOR		In Work
No.	Qty.	Name	Item No.	Approval State

Storage and Application guide lines for Pressure Sensitive Adhesives

Storage:

- Pressure Sensitive Adhesives (PSA) should be protected against direct UV-light and extremes in temperature and humidity. Store the material between 18°C and 25°C in original packaging.
- When receiving the material allow it a minimum of 24 hours to acclimatize before use.

Surface preparation:

- All surfaces should be clean and free from dust, grease and other contaminations.

Application temperature:

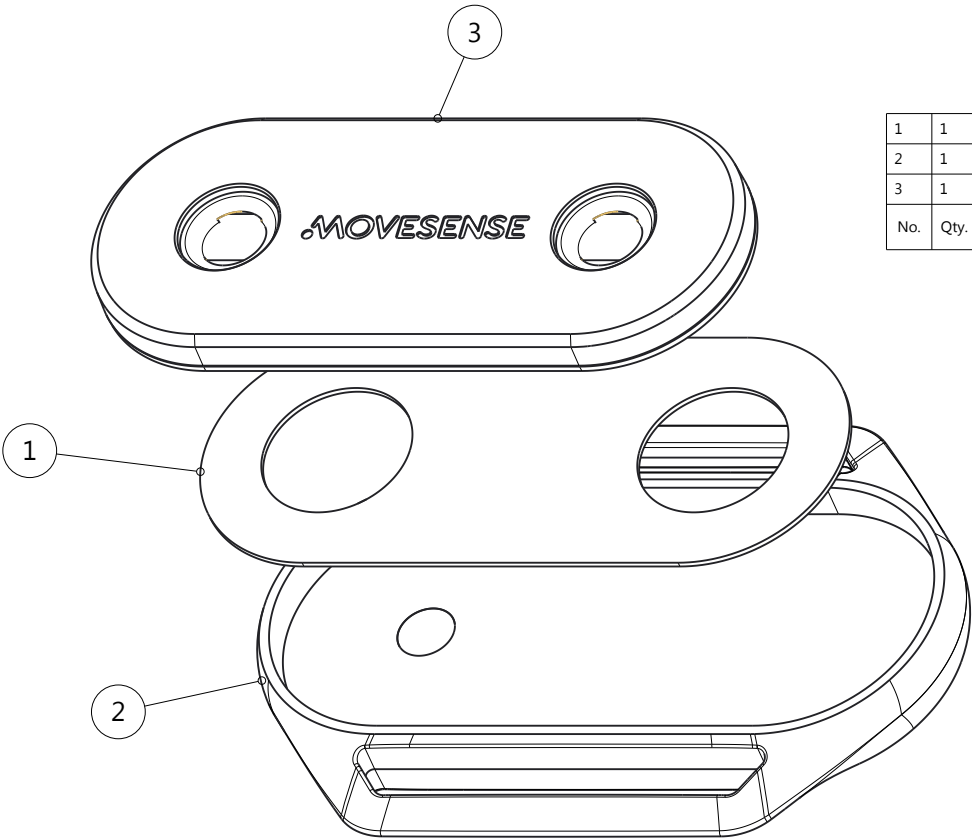
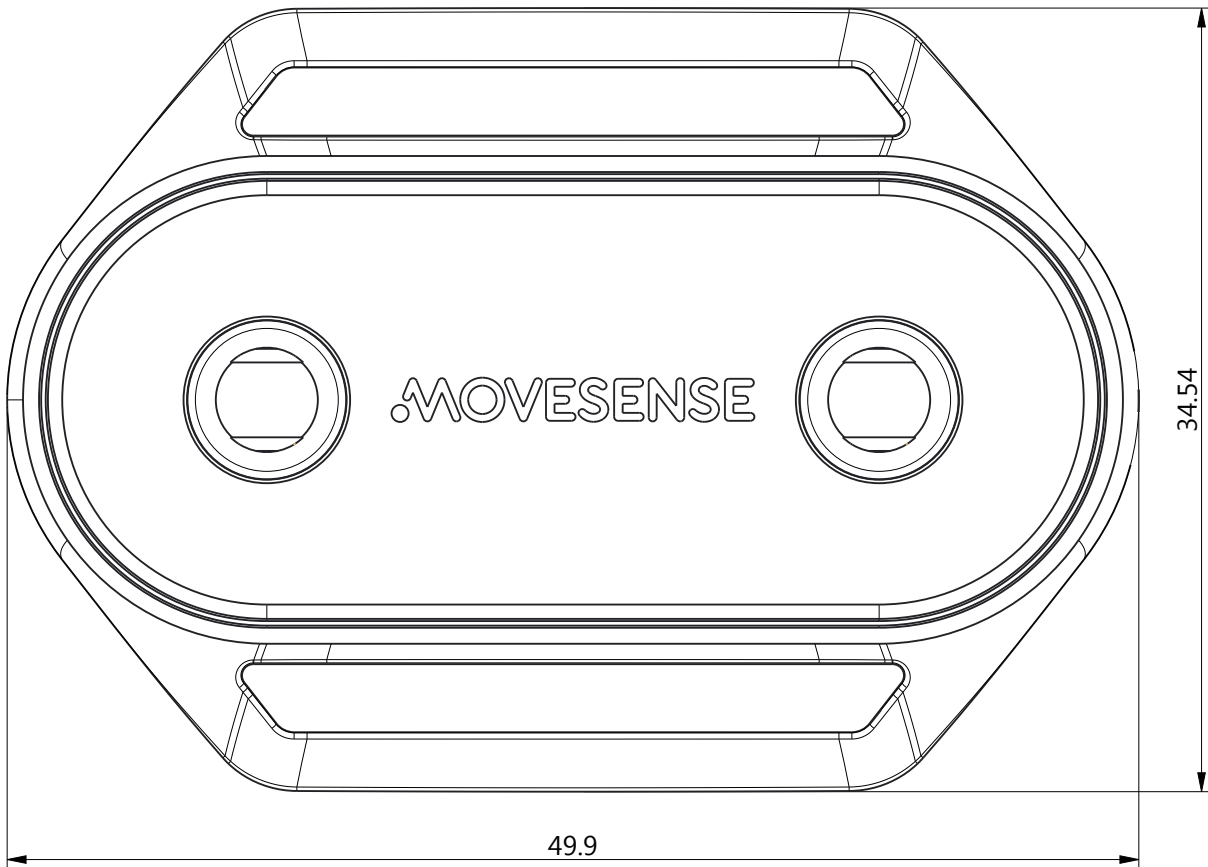
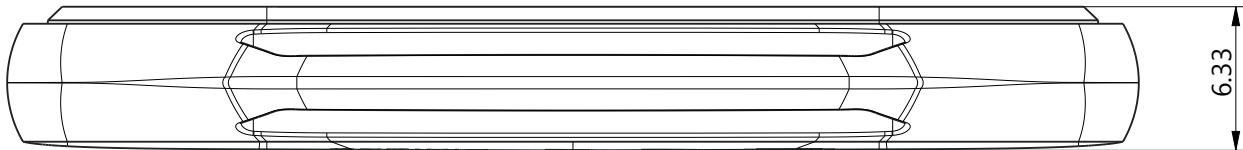
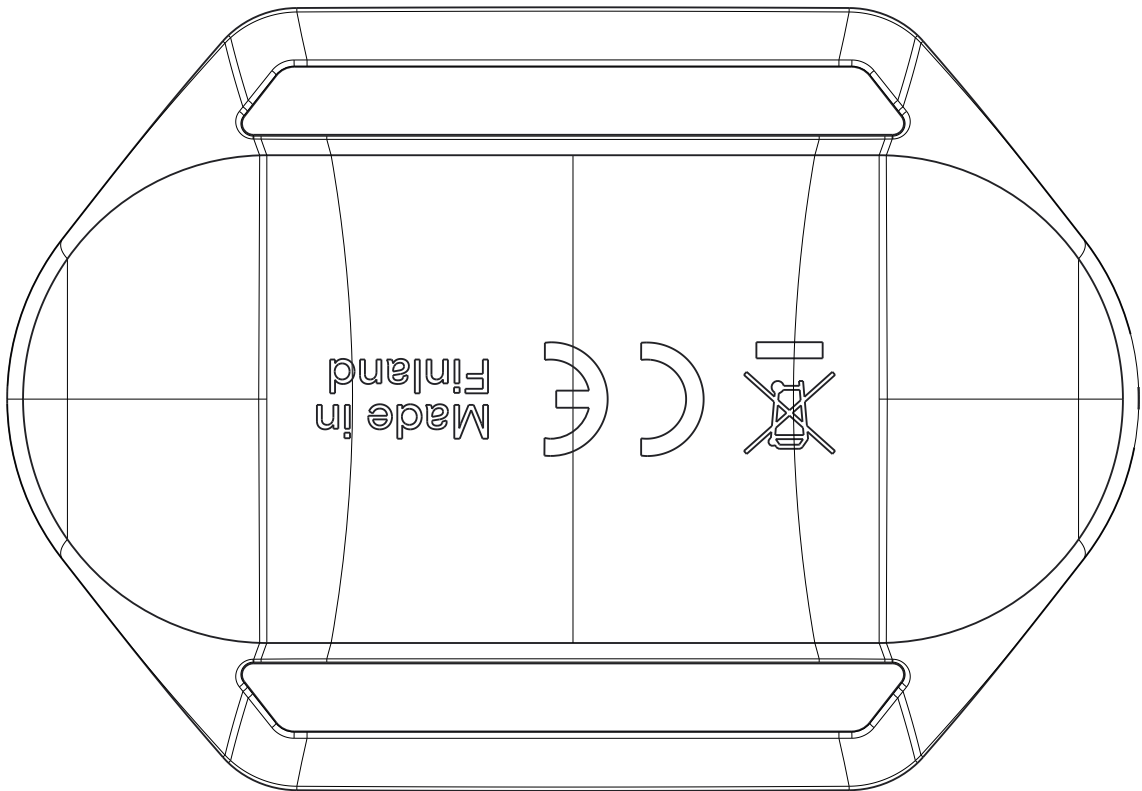
- Ideal temperature for bonding is between 20° C and 35° C, lower temperature will give lower direct adhesion and higher temperature will generally give more direct adhesion.

Application pressure:

- Pressure Sensitive Tape need surface contact, for this an minimum application pressure is needed of 1 kg/cm² for a time of 1 to 3 seconds for shiny and flexible surfaces and 2 kg/cm2 for a time of 3 to 5 seconds for smooth and rough surfaces, this can be done by a pressure roller or pressure plates (more pressure and longer time will result in higher direct adhesion).
- After application pressure the adhesive will flow onto the surface and the bond strength will increase in time, general guide lines to achieve ultimate bond strength:
50 % after 30 min
90 % after 24 hrs
100% after 72 hrs
(depending on temperature and surface conditions)

NOTE: In this application tape shall be pressed with 120 - 150 N for 5 seconds.

STRAP BUCKLE ASSEMBLY



2:1

1	1	MOVESENSE-ACCESSORY-ADHESIVE-2		1.5	In Work
2	1	MOVESENSE-ACCESSORY-STRAP-BUCKL		1.23	In Work
3	1	MOVESENSE-CONNECTOR		1.1	In Work
No.	Qty.	Name	Item No.	Version	Approval State

NameSTRAP-BUCKLE-ASSEMBLY				Material		Tolerance Table: Class fine Dim. RangeTolerance		4		
Geometry number	74974A	Part revision	1	Drawing version	1.8	Surface finish	>0,5 - 3	±0,05	3	
		Sheet	3/3	Project number	001	Surface Treatment	> 3 - 6	±0,05	2	
SUUNTO		Scale	3:1	Approved for	In Work	Other	>6 - 30	±0,1	1	Pull-out test to check USW and adhesive quality
		Size	A3	Created by	Date8.5.2018	Weight	10.98g	>30 - 120	±0,15	Note Table