

NOTES: UNLESS OTHERWISE SPECIFIED.

1. INTERPRET DRAWING PER ASME Y14.100.

2. DRAWING IS FOR INSPECTION PURPOSES ONLY.
ACTUAL PART GEOMETRY IS CONTROLLED BY 3D CAD DATABASE.
ALL NON-DIMENSIONED GEOMETRY TO BE 0.10 TO 3D CAD.

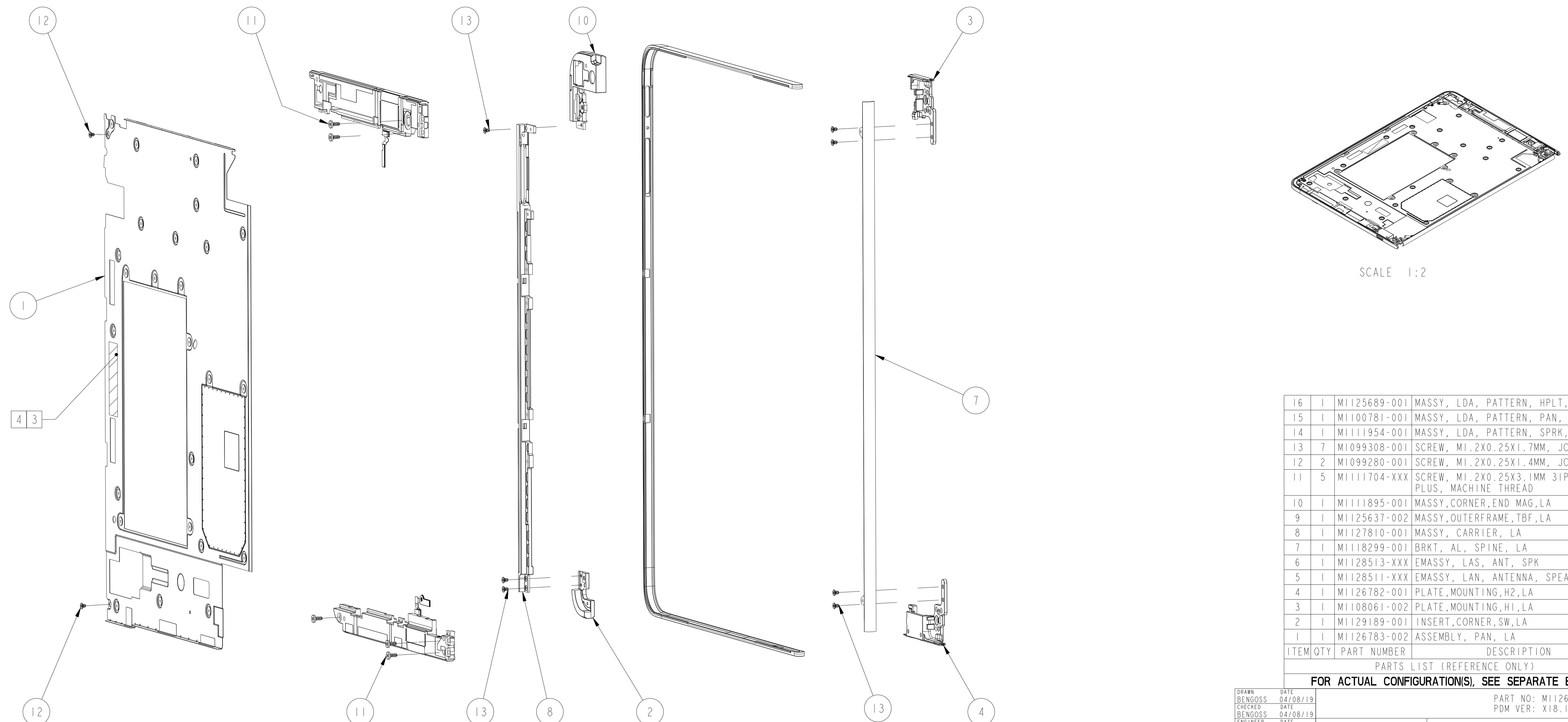
3. ADD QR CODE WITH THE FOLLOWING INFORMATION:

- A. SPEAKER INFORMATION
- B. PART NUMBER
- C. ASSEMBLY DATE
- D. SERIAL NUMBER

4. ADD READABLE MS PART NUMBER AND REVISION LABEL

5. PACKAGING TRAY AND LINERS TO MEET SURFACE RESISTANCE:
 $\geq 1.0 \times 10^4 \Omega$, $< 1.0 \times 10^{11} \Omega$, STATIC VOLTAGE WITHIN $\pm 100V$.

REVISION HISTORY			
REV	ECO NO	ZONE	DESCRIPTION
X17			EV3.0 BUILD RELEASE
X18			ADD BASIC DIM TO POINTS d15 & d16, DIM 340 & 341 WERE 0.4, DIM 601 & 701 WERE 0.9



SCALE 1:2

REFERENCE SHEET 13 FOR CONFIGURATIONS

ITEM QTY	PART NUMBER	DESCRIPTION
PARTS LIST (REFERENCE ONLY)		

FOR ACTUAL CONFIGURATION(S), SEE SEPARATE BOM(S)

PART NO: M1126781-XXX
PDM VER: X18.I

DRAWN DATE 04/08/19
CHECKED DATE 04/08/19
ENGINEER DATE 04/08/19
BENGSS 04/08/19
BENGSS 04/08/19

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN MILLIMETERS
TOLERANCE ON ANGLES $\pm 1^\circ$
INTERPRET DIM & TOL
PER ASME Y14.5-2009

DO NOT SCALE DRAWING

LEGEND:
■ = CRITICAL DIM
● = TOOLING DIM
▲ = PROCESS DIM
◎ = DIMENSION ID

SIZE: D THIRD ANGLE PROJECTION DRAWING NO: M1126781 REV: X18
SCALE: 1.25:1 SHEET: 1 OF 13

H00642 RESTRICTED SUBSTANCES
H001122 PROD PART APVL PROC
H00594 RESTRICTED SUBSTANCES
D02641 T2 SOE SPEC

DOCUMENT NO GENERAL DESCRIPTION
APPLICABLE SPECIFICATION TABLE

TOOLING DATE 04/08/19
QUALITY DATE 04/08/19

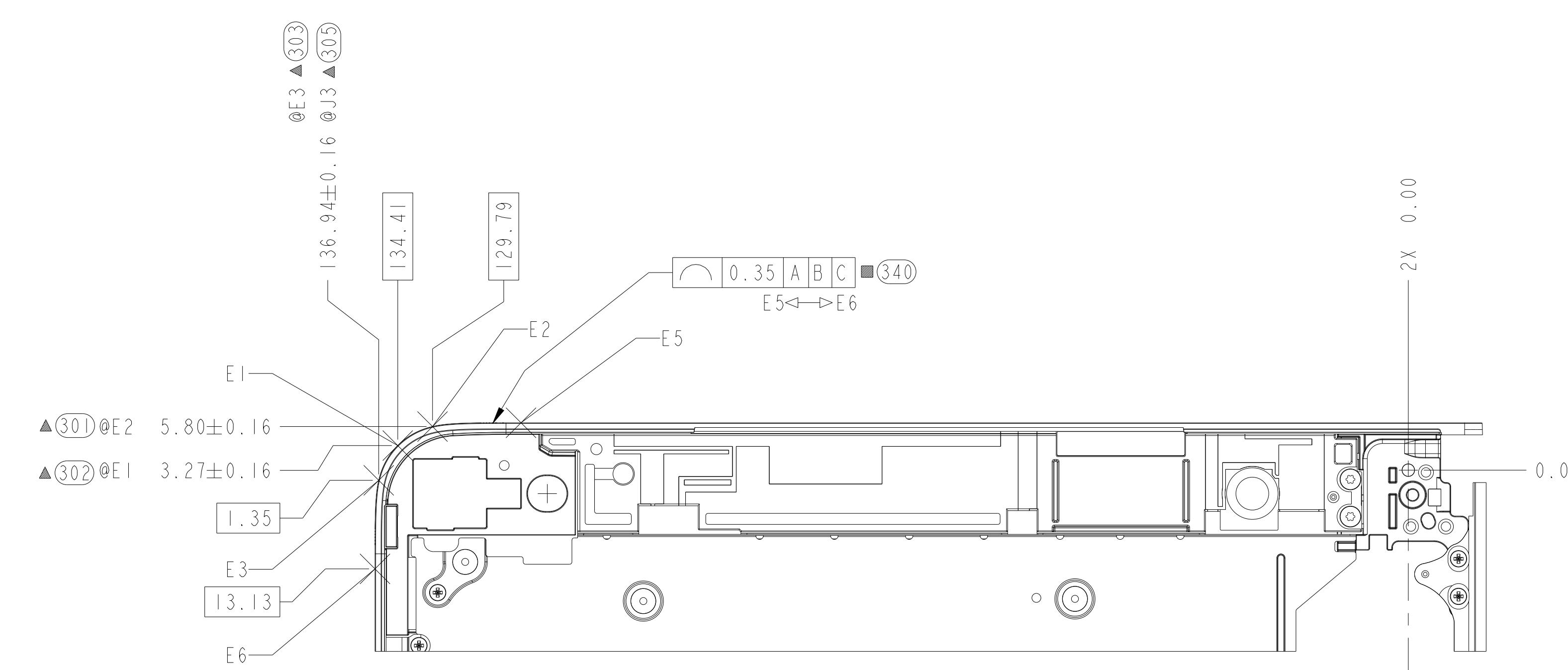
CONFIG MGMT DATE 04/08/19
VIDAGO DATE 04/08/19

TITLE: MASSY, FRAME, LA

8 7 6 5 4 3 2 1

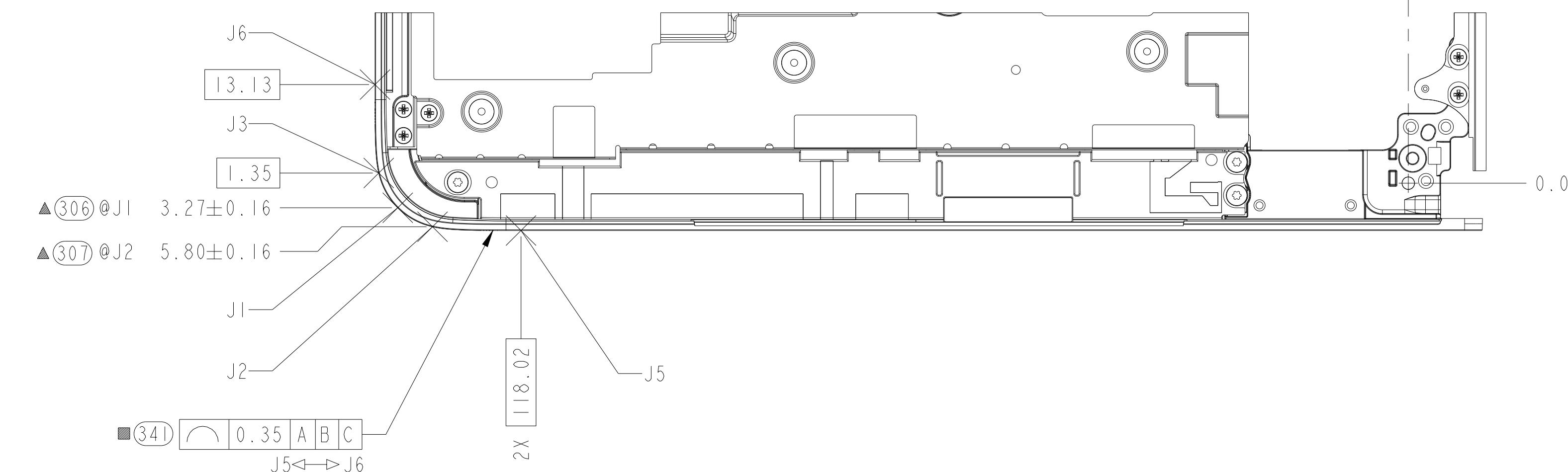
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PROFILE

8 7 6 5 4 3 2 1

TITLE: MASSY, FRAME, LA	
SIZE: D	THIRD ANGLE PROJECTION
DRAWING NO.: M1126781	REV.: X18

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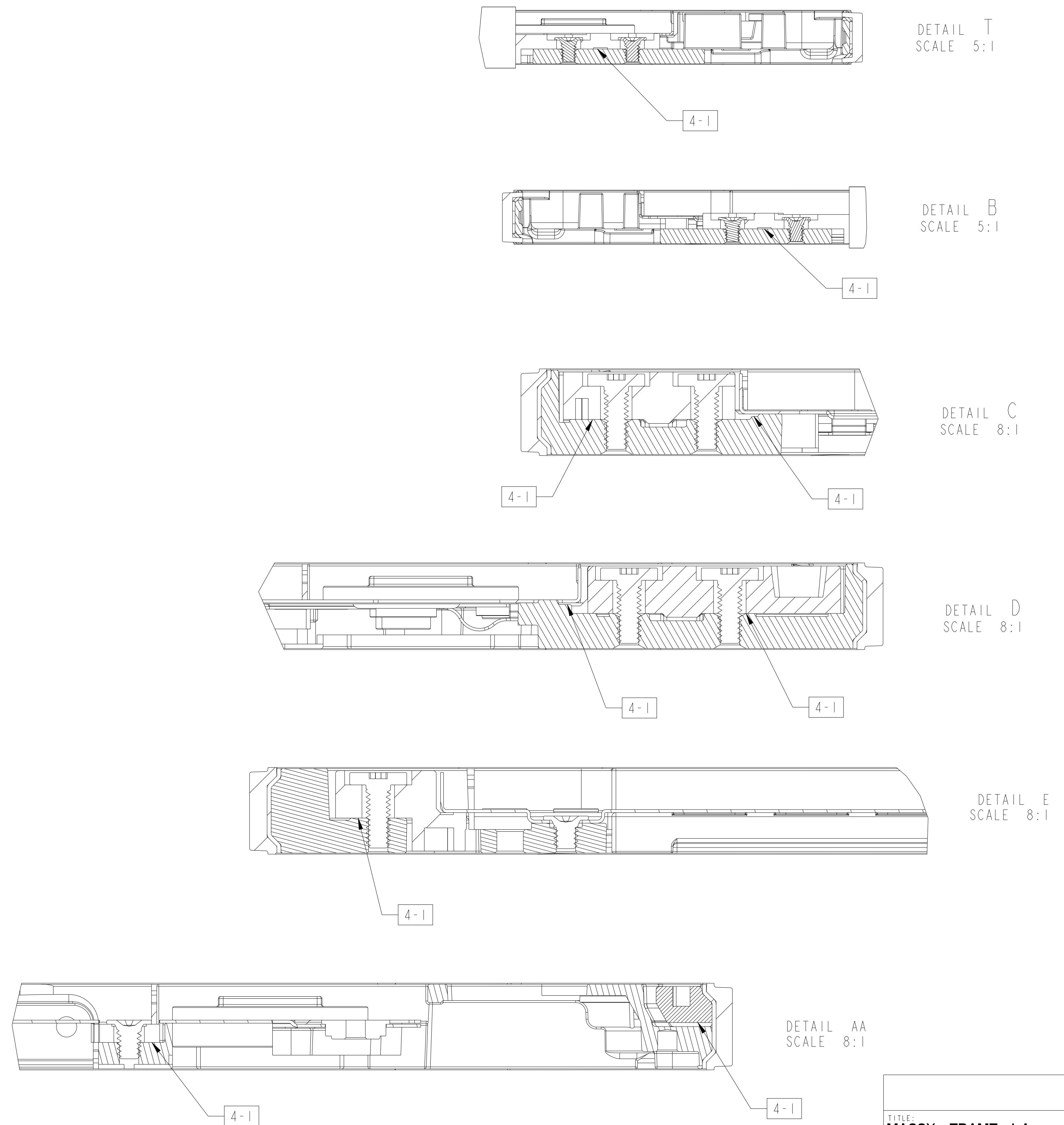
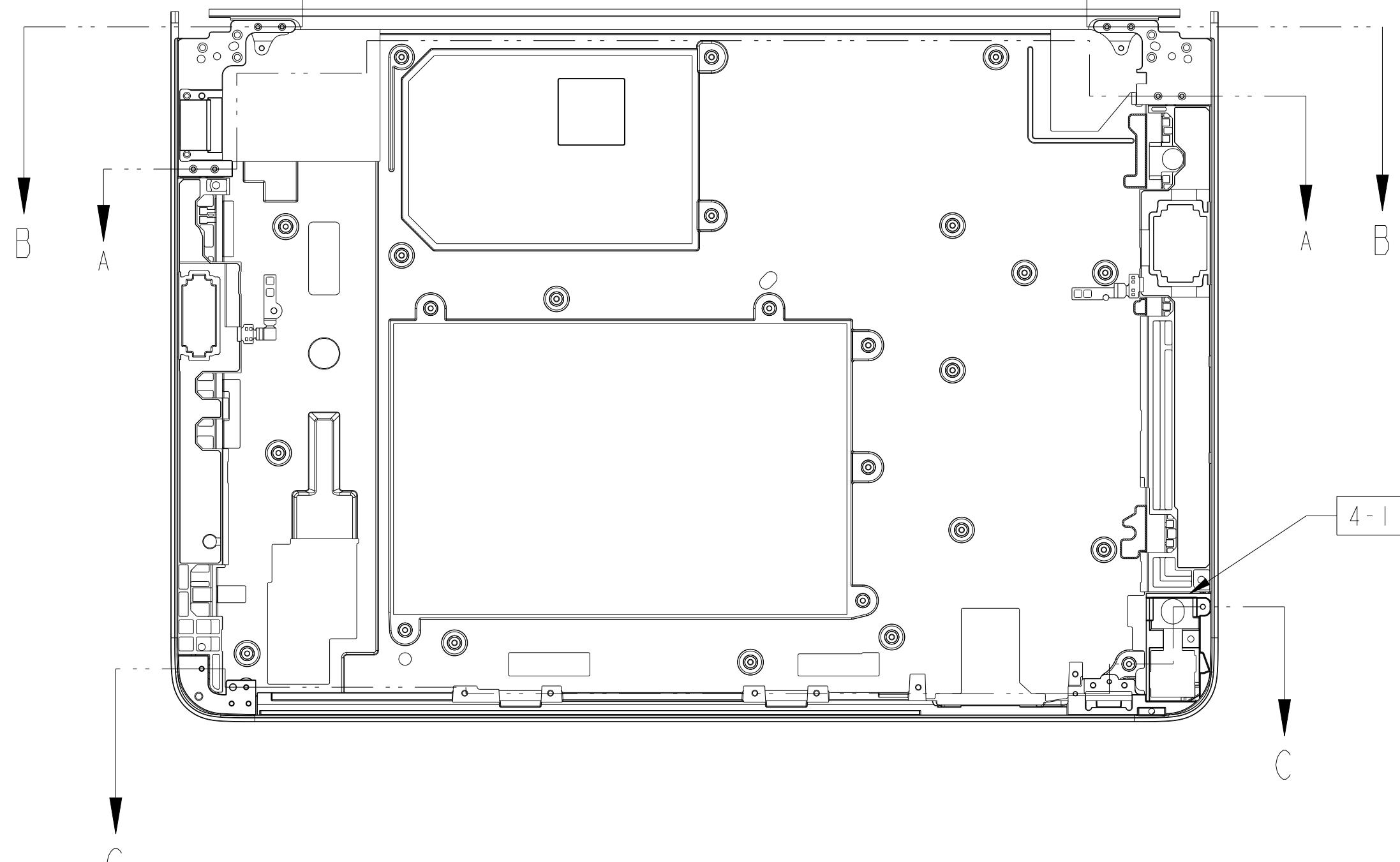
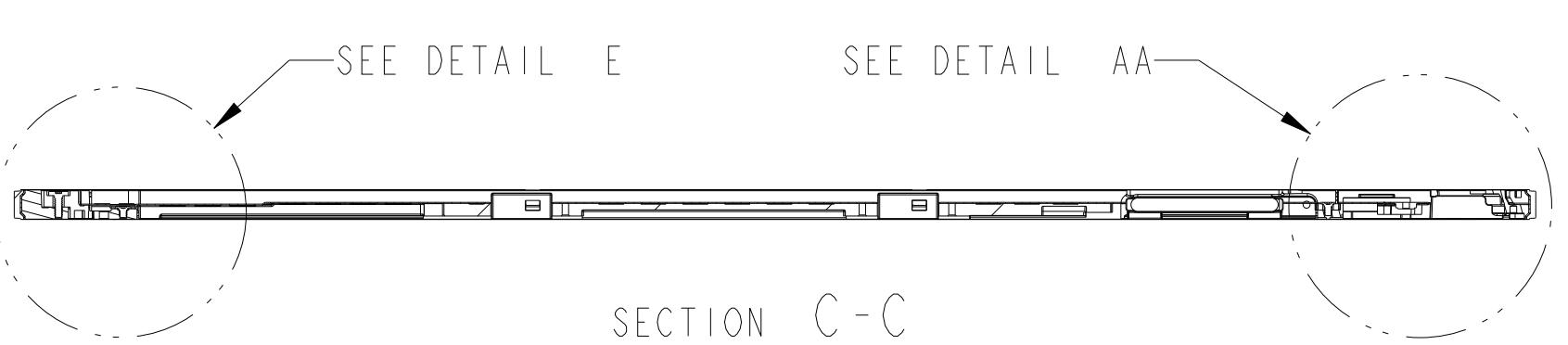
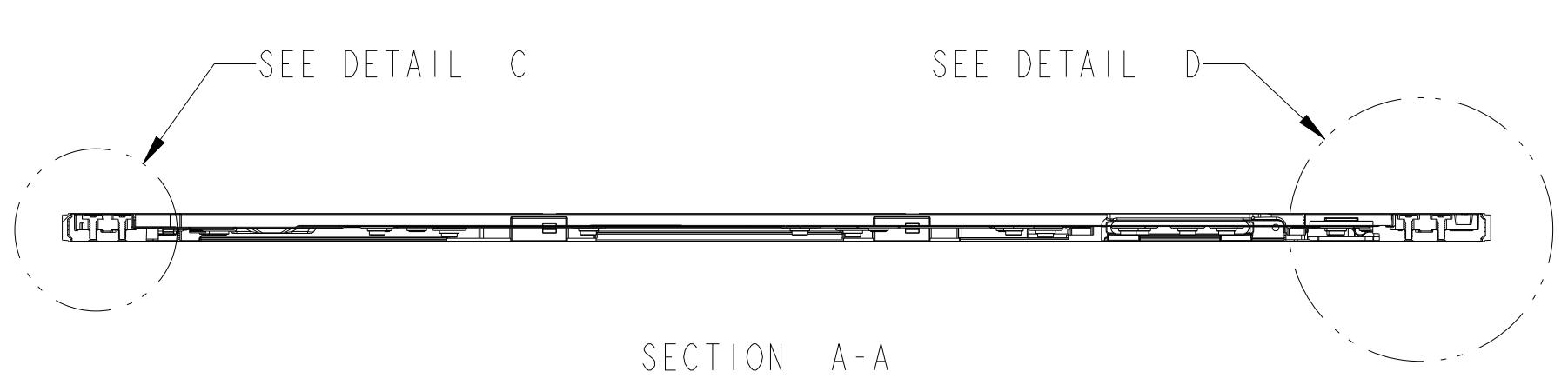
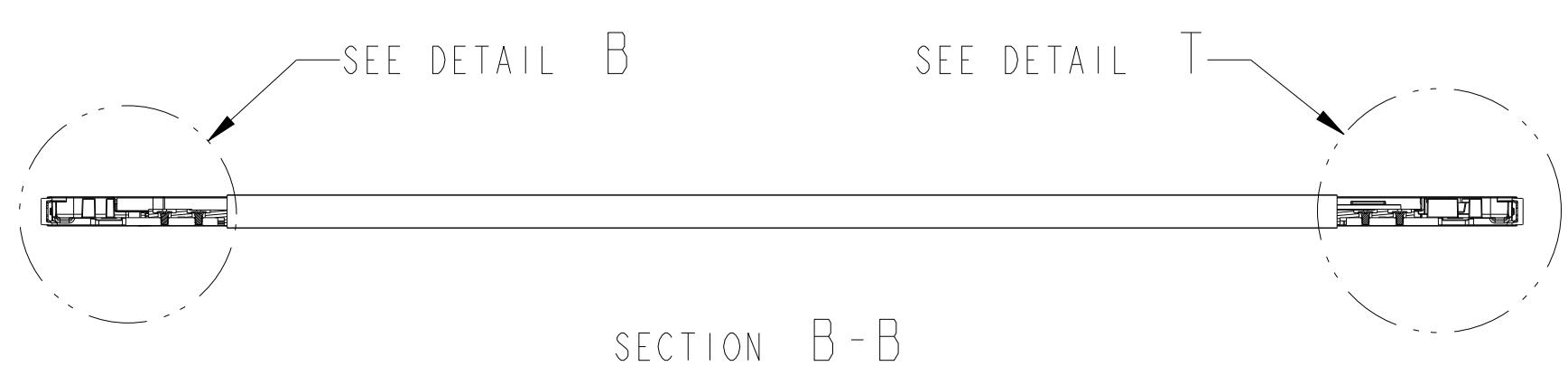
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NOTES:

4-1 APPLY ADHESIVE AT LOCATION.



TITLE:
MASSY, FRAME, LA

SIZE: THIRD ANGLE PROJECTION DRAWING NO.: M1126781 REV: X18
D SCALE: 1:1 SHEET: 4 OF 13

JOINT CROSS SECTIONS

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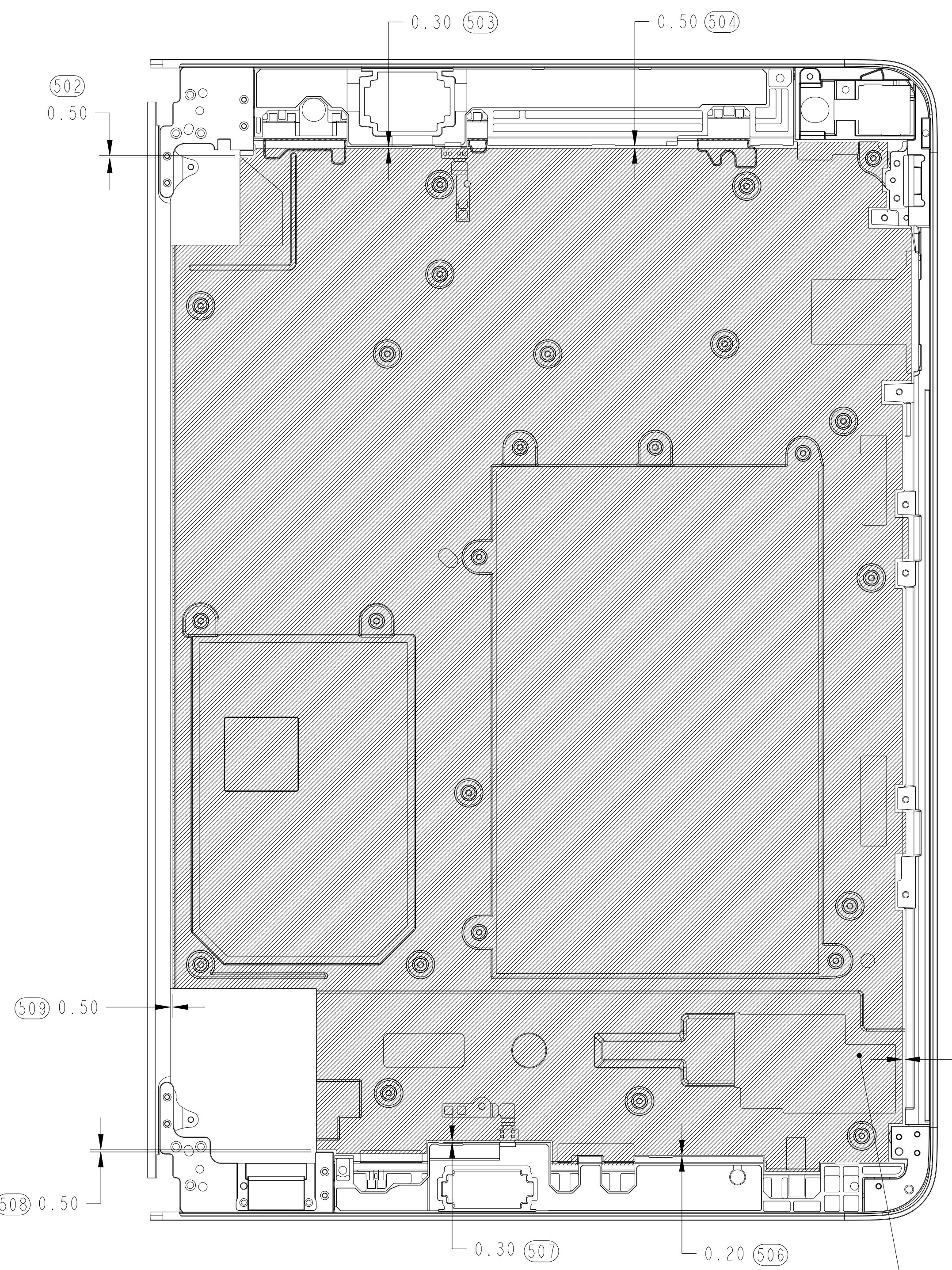
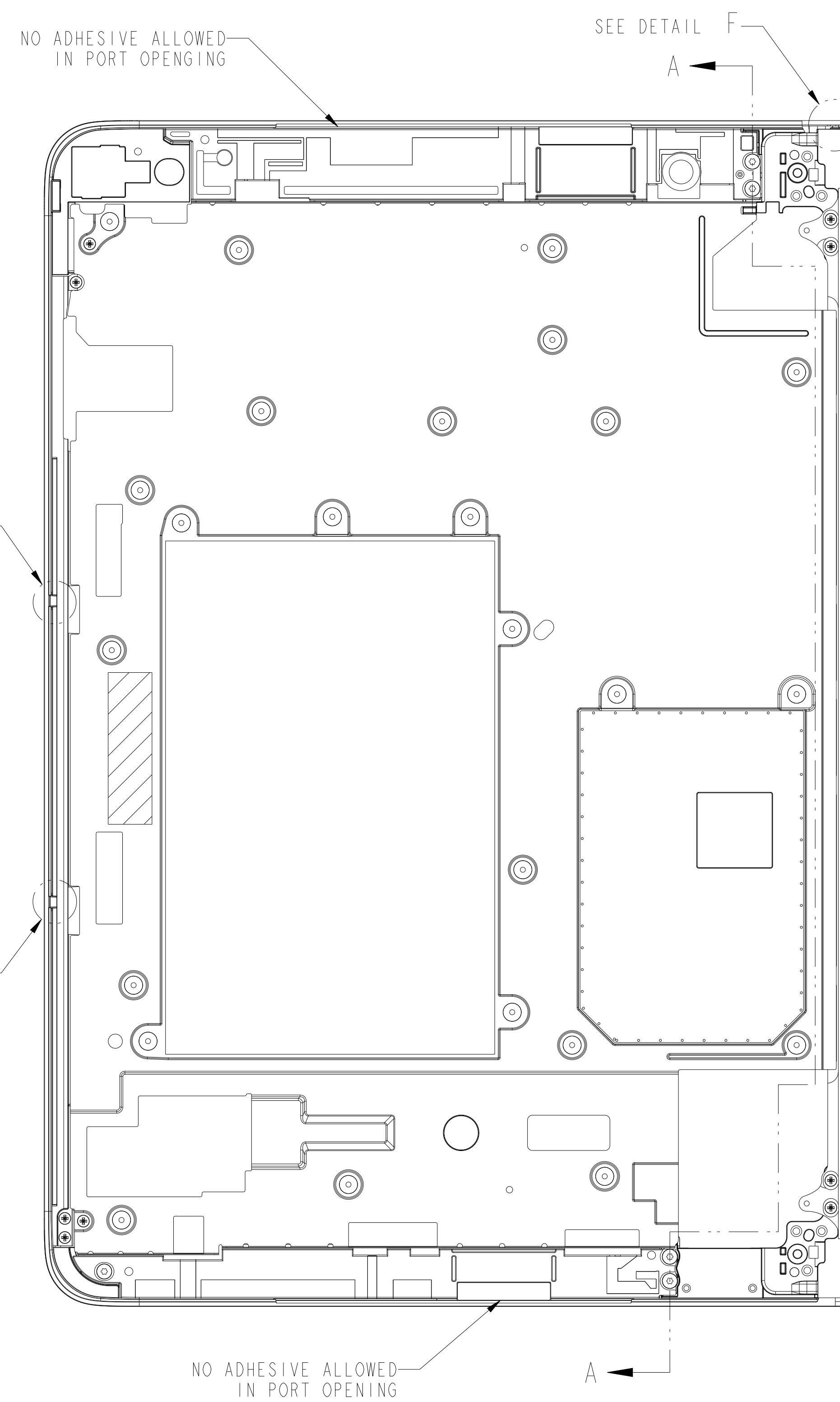
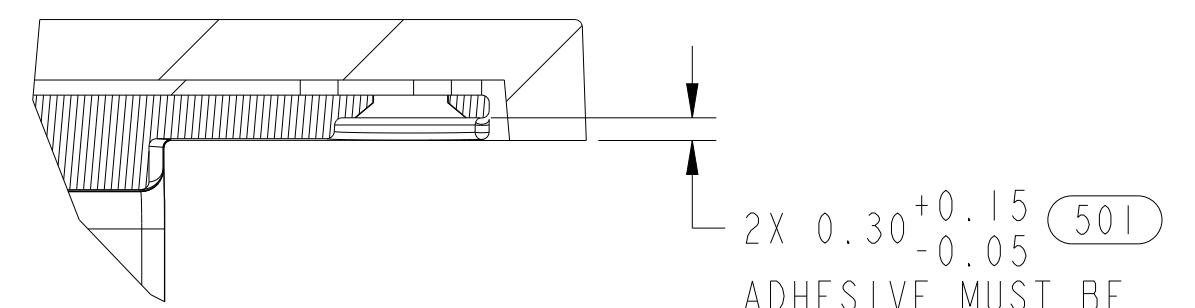
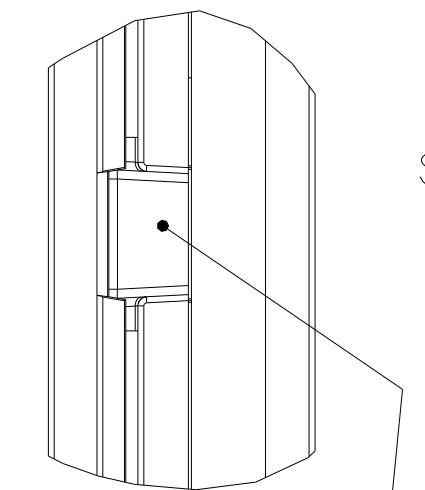
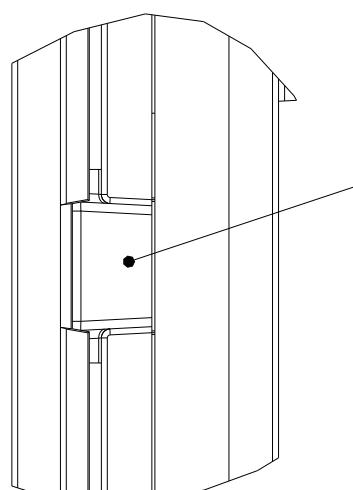
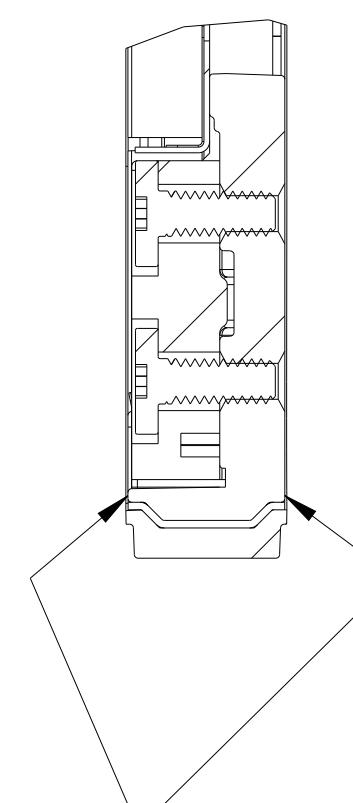
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**ADHESIVE KEEPOUT**DETAIL F
SCALE 10:1DETAIL M
SCALE 8:1NO ADHESIVE ALLOWED
IN PORT OPENINGDETAIL N
SCALE 8:1DETAIL R
SCALE 5:1ADHESIVE SHALL
NOT PROTRUDE ABOVE
SURFACE (DATUM A & D)
ALONG PERIMETER

SECTION A-A

TITLE:
MASSY, FRAME, LASIZE: THIRD ANGLE
PROJECTION DRAWING NO.: M1126781
REV: X18
D

SCALE: 1:6:1

SHEET:
5 OF 13

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8 7 6 5 4 3 2 1

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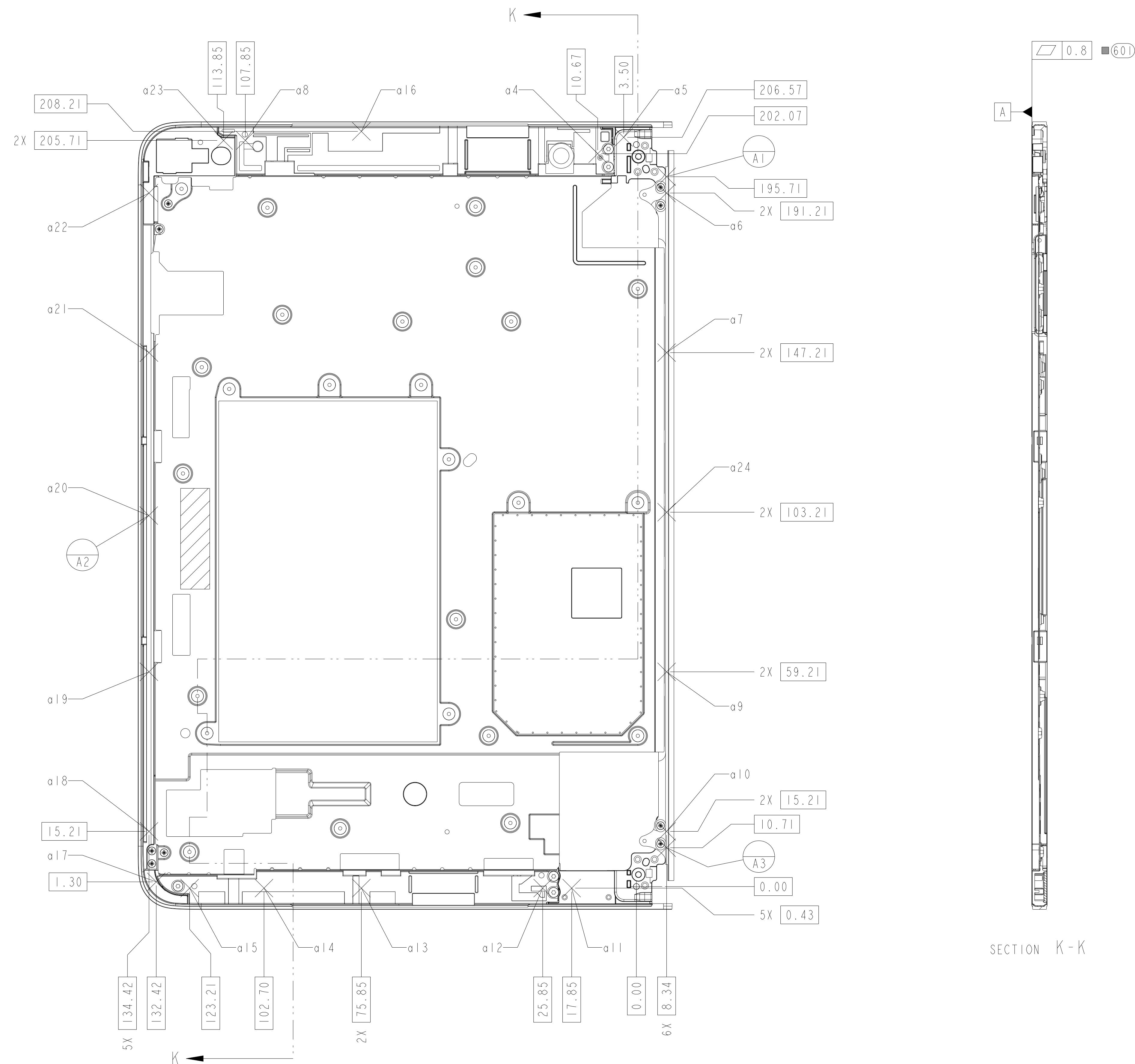
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Z-STEPS (TOP)



NOTES:
 1. ESTABLISH PLANE WITH DATUM TARGETS A1, A2, A3
 2. CALCULATE STEPS FROM PLANE
 3. MEASURE IN UNCONSTRAINED STATE

Z STEP TABLE			
LOCATION	NOMINAL	TOL.	DIM ID
A1	-	-	-
A2	-	-	-
A3	-	-	-
a4	0.100	±0.77	▲605
a6	0.00	±0.77	▲607
a7	0.00	±0.77	▲608
a8	0.100	±0.77	▲609
a9	0.00	±0.77	▲610
a10	0.00	±0.77	▲611
a11	0.00	±0.77	▲612
a12	0.100	±0.77	▲613
a13	0.100	±0.77	▲614
a14	0.100	±0.77	▲615
a15	0.100	±0.77	▲616
a16	0.100	±0.77	▲617
a17	0.00	±0.77	▲618
a18	0.00	±0.77	▲619
a19	0.00	±0.77	▲620
a21	0.00	±0.77	▲622
a22	0.00	±0.77	▲623
a23	0.00	±0.77	▲624
a24	0.00	±0.77	▲625

TITLE: MASSY, FRAME, LA

SIZE: THIRD ANGLE PROJECTION DRAWING NO: M1126781 REV: X18
 D SCALE: 1:6:1 SHEET: 6 OF 13

8 7 6 5 4 3 2 1

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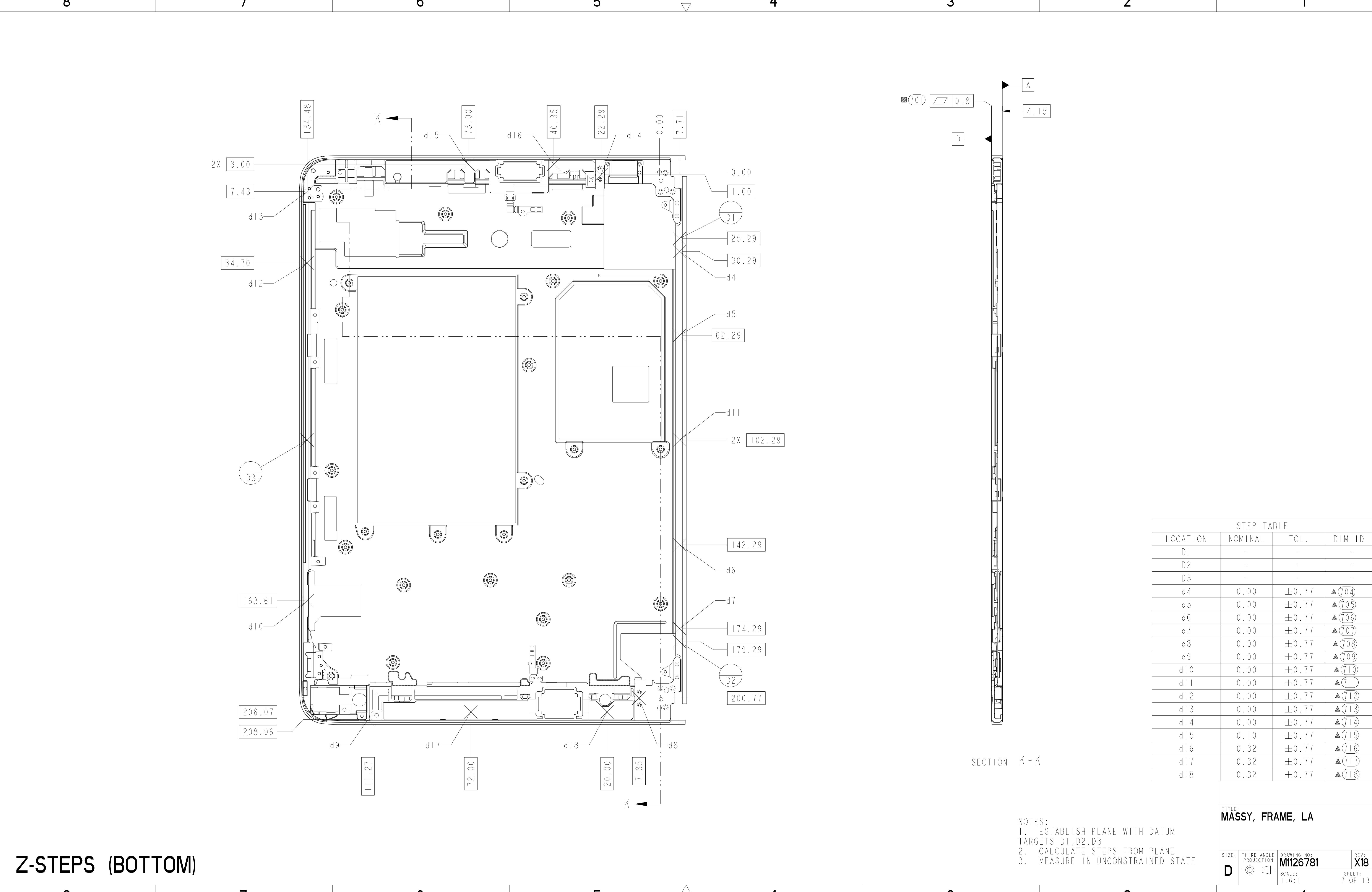
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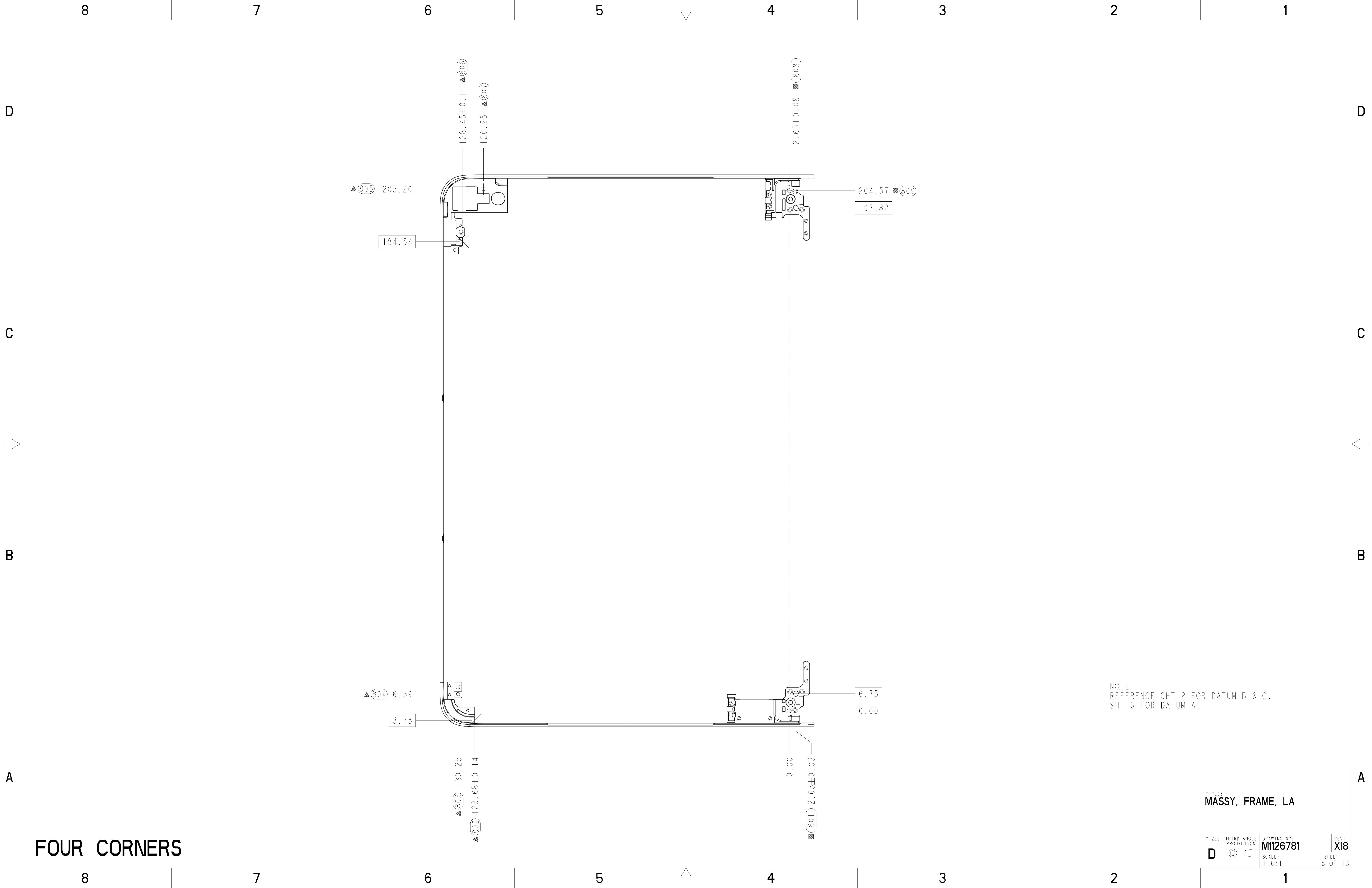
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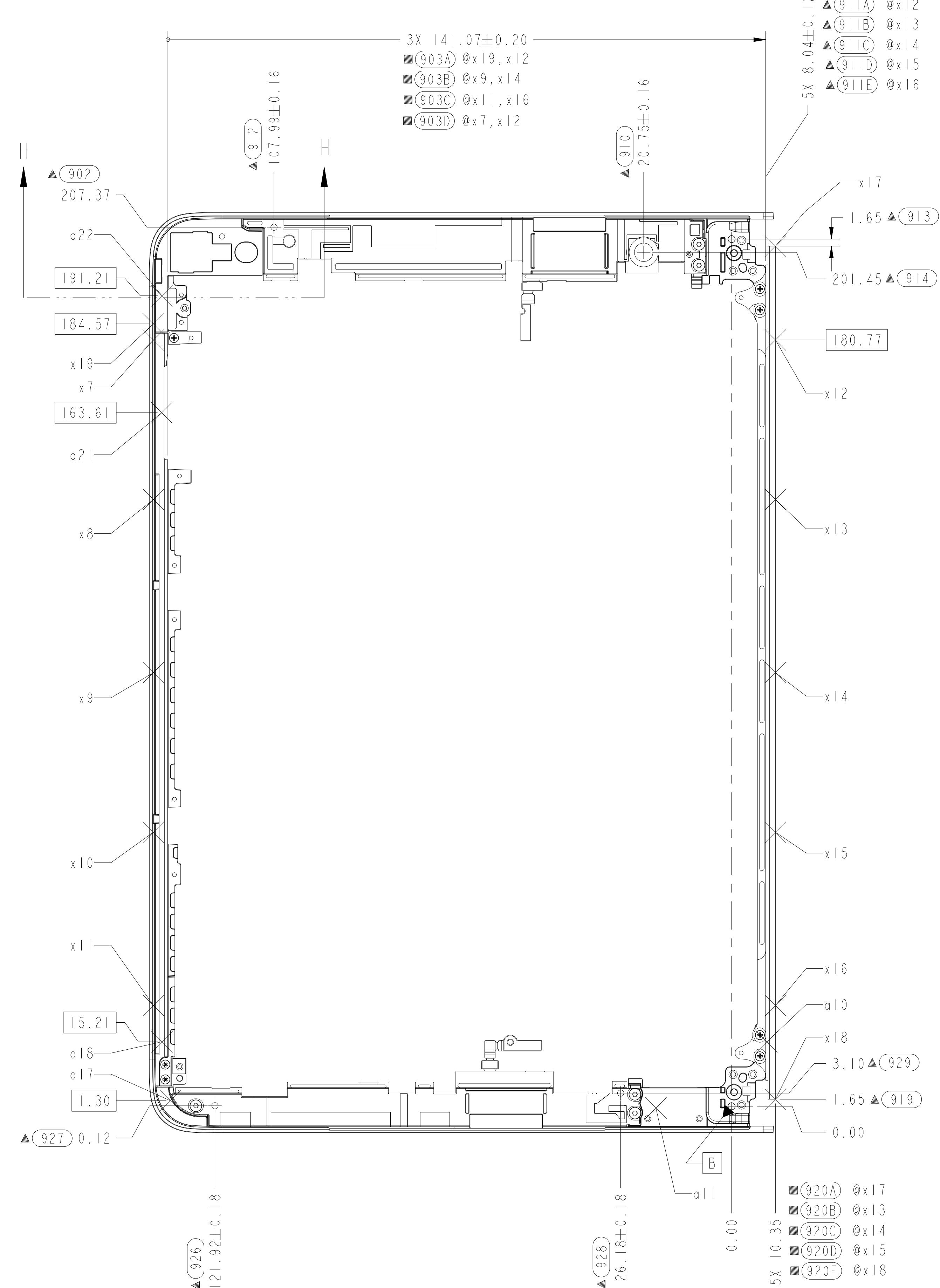
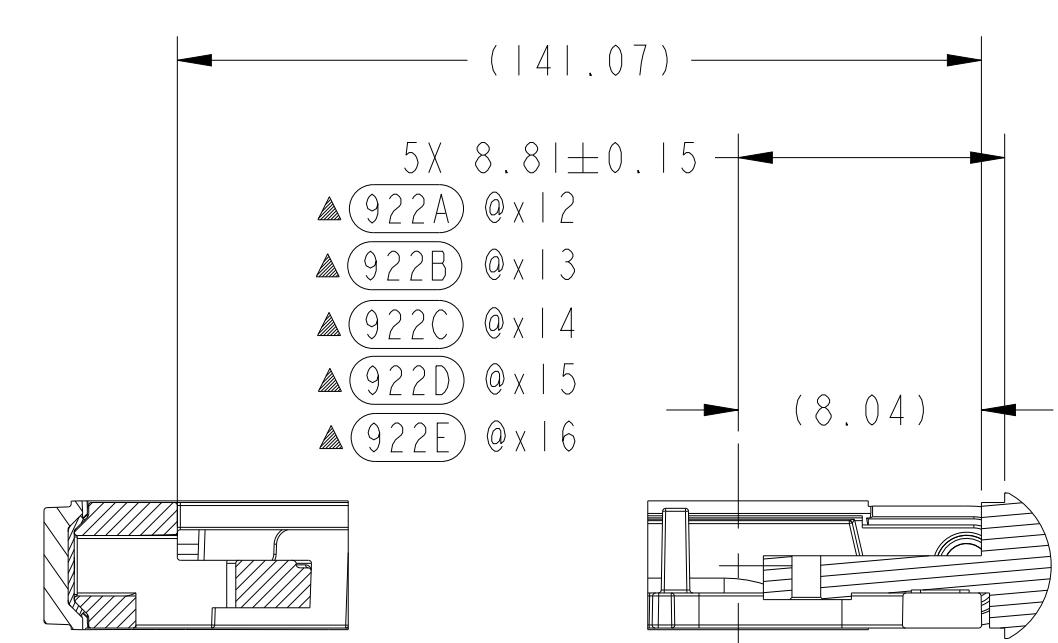
C

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SPINE CENTER		
CALC.	NOMINAL	DIMENSION
(913) - (919)	=	0.00±0.05 ■(931)

Z STEP TABLE		
CALC.	NOMINAL	DIMENSION
a22-a21	=	0.00 ■(904)
a17-a18	=	0.00 ■(905)
a5-a6	=	2.99 ■(906)
a11-a10	=	0.00 ■(907)
a5-a4	=	2.89 ■(932)
a11-a12	=	0.10 ■(933)
a17-a15	=	0.10 ■(934)
a23-a8	=	0.10 ■(935)

NOTES:
1. REFERENCE SHT 2 FOR DATUM B & C,
SHT 6 FOR DATUM A.
2. POINTS "a" TAKEN FROM SHEET 6.

TITLE: MASSY, FRAME, LA		
SIZE: D	THIRD ANGLE PROJECTION	DRAWING NO: M1126781
REV: X18	SCALE: 1.6:1	HEET: 9 OF 13

SPEAKER AND SIDES

PAN ASSEMBLY

8 7 6 5 4 3 2 1

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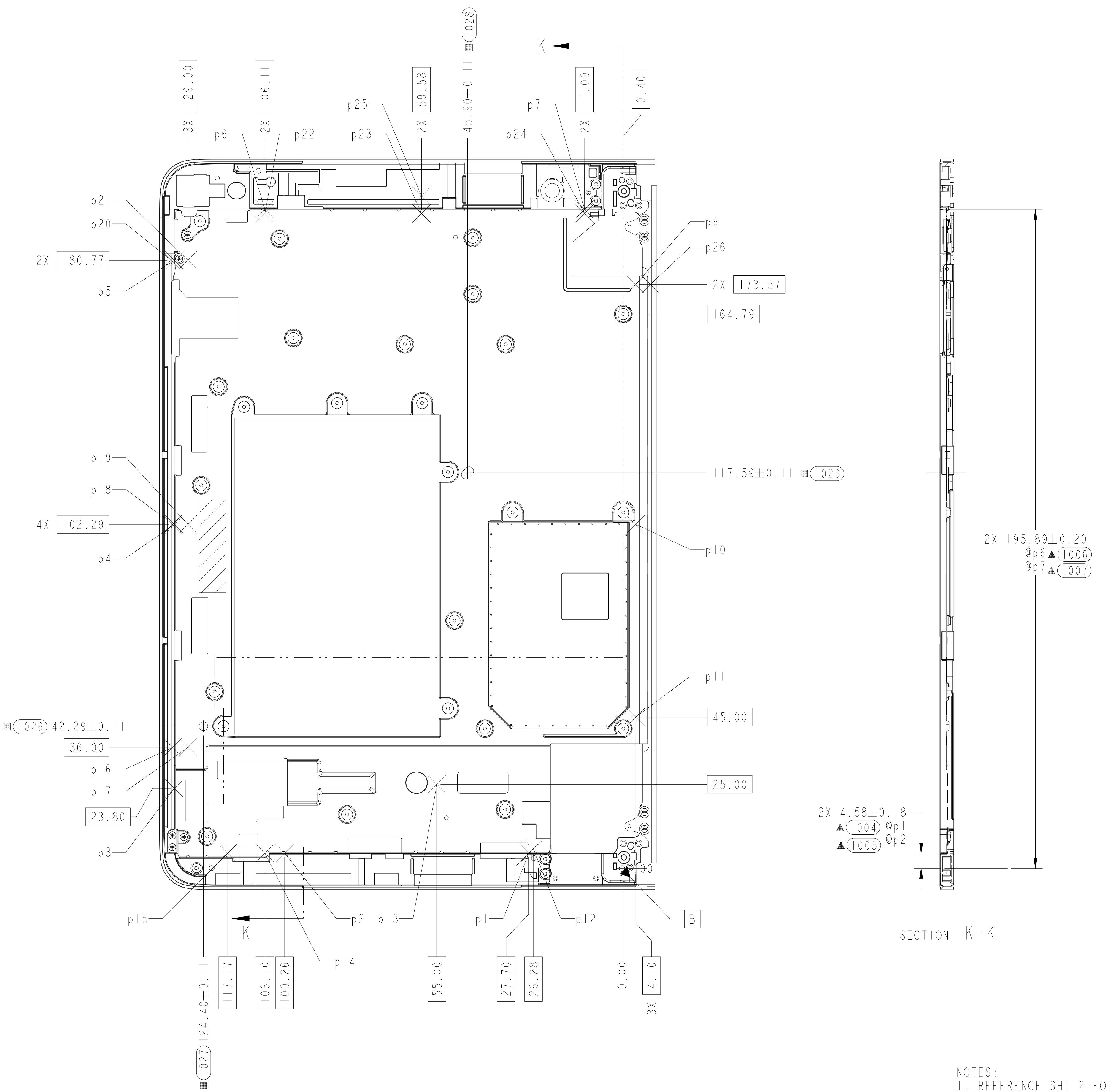
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STEP TABLE			
CALC.	NOMINAL	TOLERANCE	DIMENSION
p9-p26 =	1.76	± 0.13	■(1009)
p10-A2 =	1.76	± 0.13	■(1010)
p11-a9 =	1.76	± 0.13	■(1011)
p12-a12 =	1.91	± 0.13	■(1012)
p13-a13 =	1.91	± 0.53	■(1013)
p14-a14 =	1.91	± 0.13	■(1014)
p15-a15 =	1.91	± 0.13	■(1015)
p17-p16 =	1.76	± 0.13	■(1016)
p19-p18 =	1.76	± 0.13	■(1017)
p21-p20 =	1.76	± 0.13	■(1018)
p22-a8 =	1.66	± 0.13	■(1019)
p23-p25 =	1.66	± 0.13	■(1020)
p24-a4 =	1.66	± 0.13	■(1021)



NOTES:
1. REFERENCE SHT 2 FOR DATUM B & C,
SHT 6 FOR DATUM A.
2. POINTS "a" TAKEN FROM SHEET 6.

TITLE: MASSY, FRAME, LA
SIZE: THIRD ANGLE PROJECTION DRAWING NO. M1126781 REV. X18
D SCALE: 1.5:1 SHEET: 10 OF 13

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SHEET NOT USED

TITLE:
MASSY, FRAME, LA

SIZE: D THIRD ANGLE PROJECTION DRAWING NO.: M1126781 REV.: X18
SCALE: 1.6:1 SHEET: 11 OF 13

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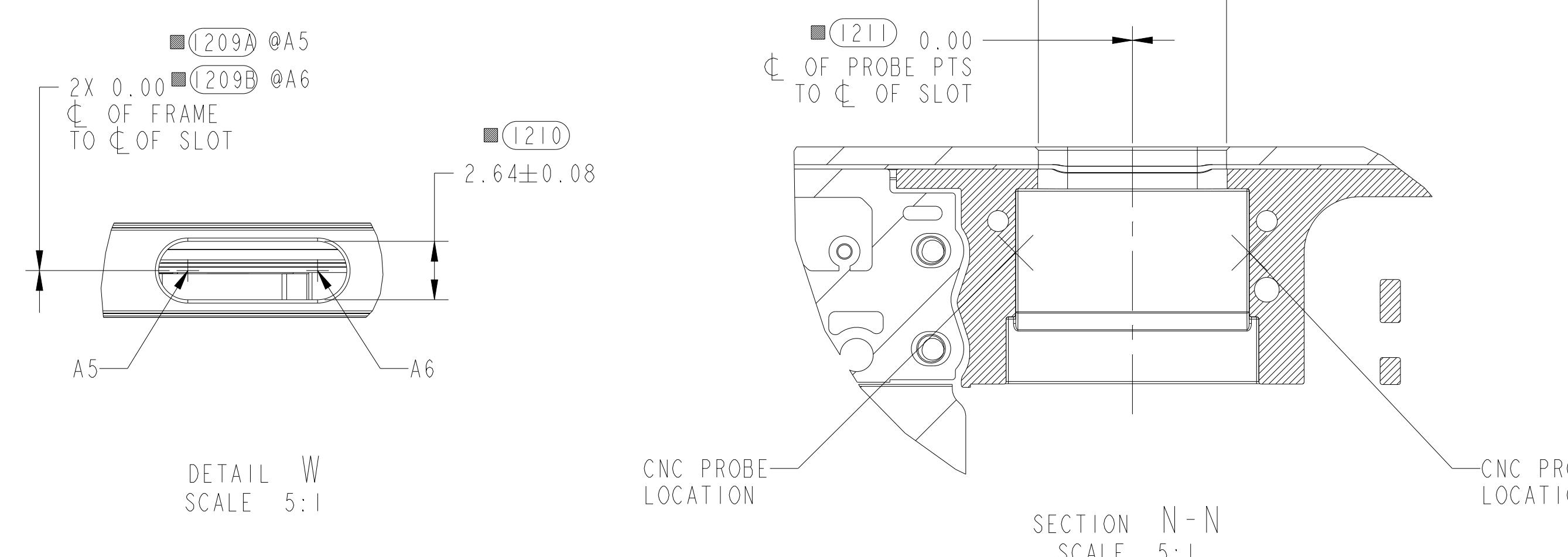
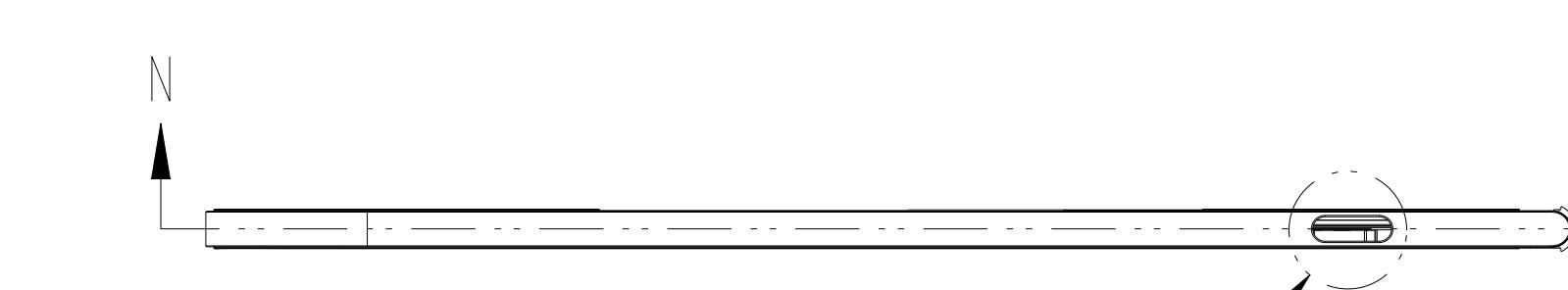
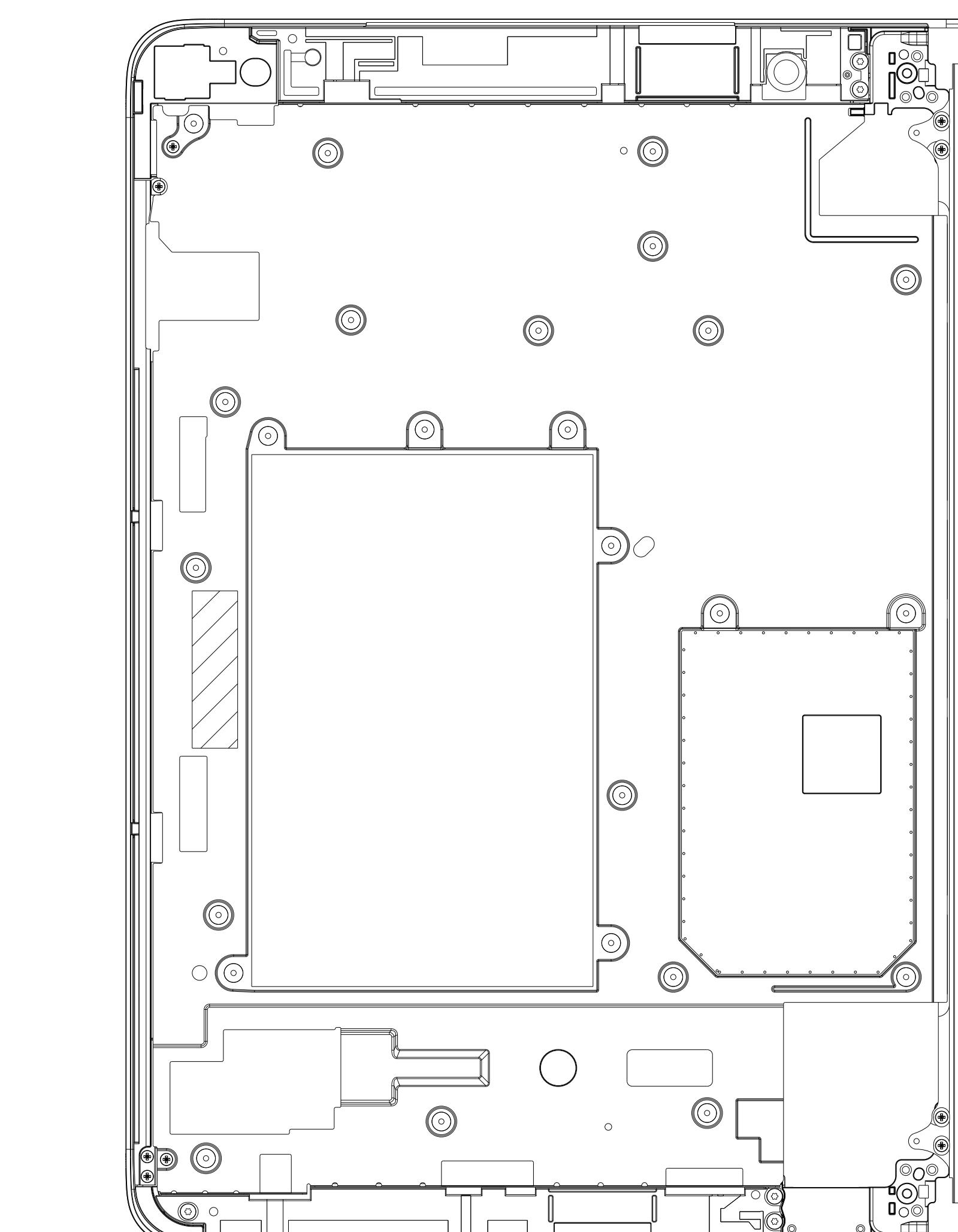
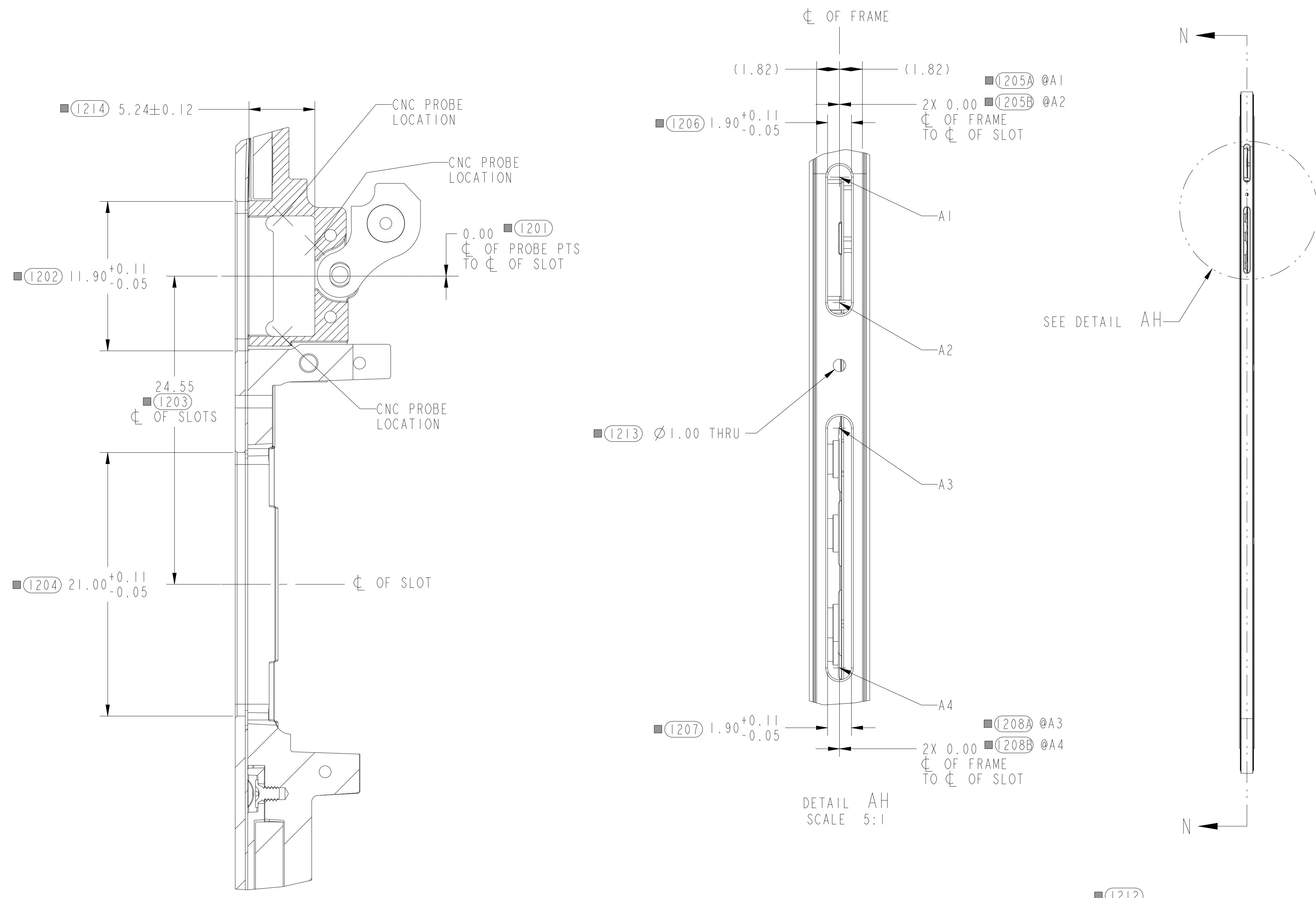
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CNC

TITLE:
MASSY, FRAME, LA

SIZE: THIRD ANGLE PROJECTION DRAWING NO.: M1126781 REV: X18
 SHEET: 12 OF 13

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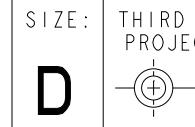
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BOM CONFIGURATIONS

BOMS CONFIG.	DESCRIPTION	ITEM #5 NORTH SPEAKER	ITEM #6 SOUTH SPEAKER
M1126781-001	POR	M1128511-004	M1128513-004

TITLE:
MASSY, FRAME, LA

SIZE: THIRD ANGLE PROJECTION DRAWING NO.: M1126781 REV: X18
D  SHEET: 13 OF 13
SCALE: 1.5:1

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