

all dimensions measurement at the raw part ③

For all surfaces, without an dedicated tolerance, a general tolerance is applied according to following norm: ISO 20457:2020-03 – T6. Deviating from the norm, the first nominal size range of the tolerance tables will be used as follows: 0.1 to 3. The set main coordinate system will be used as datum system for the general position tolerance.

Part measurement according to following additional Preh requirements: "GD&T 3D-Scan"

Depending on part geometry and tolerance specifications either by optical 3D-Scan or computer tomography (CT). The measuring areas and datums for measurement shall be taken from the 3D-model (.CATPart). According to GD&T 3D-Scan Preh Requirements“ they shall be completely verified on the actual part geometry. For every measuring area at least 80 % of the given area has to be checked within the measuring.

Geometries which can be found more than once must be shown in the measurement report according to their number.

Non marked sharp edges may feature a maximum radius of $R=0.3 \text{ mm}$. (T100)

In the support area, engaging area, guiding area and areas used for datums, ejector marks and burrs are not allowed. (T101)

Surfaces identified as guiding areas must be manufactured by HSC (tool). If this is not possible the tool surface can be done by eroding with an additional polishing in demolding direction or with a smooth eroding process in respect to Reference 20 referring to VDI 3400. (T102)

No demolding slants in the guiding area! (T103)

Gate mark, shape and arrangement of the ejector, mold to mold face as well as size and position of the mold cavity have to be allowed by the product engineering.

The parts have to be free from burrs, cracks, bubbles, sink marks and flow lines and may not feature contamination (like mold release agent, oil etc.) (Limit sample about acceptable discrepancies will be agreed separately).

The component dimensions must still be within the drawing tolerances even after passing through the operating temperature range (-40 °C to +85 °C) when measured in the standard climate conditions. For compliance with this requirement, the process parameters, such as tool temperature and injection parameters, must be set accordingly.

Import coordinate system:

A	B - C	D
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ISO 8015 (AD) DIN EN ISO 291-23/50-2:2008-08

Toleranz fuer Strichstaerken:	±0,02 mm
tolerance for line thickness:	
Toleranz fuer Symbolbreiten und -hoeehen:	±0,10 mm
tolerance for symbol width and height:	
Toleranz fuer Symbolpositionen:	±0,20 mm
tolerance for symbol positions:	

Burning Rate:
All Cab materials must be designed
and selected to have a burning rate
that does not exceed 150mm/min when
tested in accordance with latest version of ISO 3795.

Oberfläche im Sichtbereich vor Lackierung
sauber, trocken, fett- und trennmittelfrei.
surface in visible area clean, dry, free from grease and
releasing agent before painting.

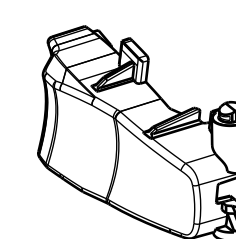
Farbton, Glanzgrad und Lackschichtdicke
muessen mit dem Urmuster uebereinstimmen.
coloring, gloss level and thickness of paint coat have to be
comply with the prototype.

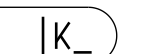


Die Lackverarbeitungsrichtlinien des
Lackherstellers sind einzuhalten.
the paint processing guidelines of the paint manufacturer
have to be observed.

Painting Table	
X	Schwarz mittelglänzend (<i>medium gloss black</i>)
	1. LACK000157 Unterlack schwarz <i>LACK000157 base coat paint black</i>
	2. LACK001364 Klarlack <i>LACK001364 clear coat</i>
Index	Paint

Specific Quality Requirements		(Only for external supply)	
Initial sample process according to:		Applicable Preh Quality Standard Purchasing:	
<input type="checkbox"/> VDA Volume 2 <input checked="" type="checkbox"/> AIAG		<input checked="" type="checkbox"/> <u>MP_03</u> Actual Version	
Customer Standards and Requirements			
Applicable specifications to be considered:		Submission specifications to be documented:	
JDM H30 (08/2018), ISO 1043 (2016), Storage Temperature: 1 min -55°C / Tmax. +105°C, JDS-6138 (2020-07) JDM F9 06/2020, RWS1330.01		DOT. § 571.302 FMVSS (2019-10-01) EN 60068-2-70 VDA 270 (06/2018) Resistance against 'List of chemicals' PREH Cosmetic specification	
Packaging according to Packaging Specification Data (PSD) <input type="checkbox"/> Additional external PSD available			
Packaging according to Preh Packaging Guideline <input type="checkbox"/> Expendable Packaging <input type="checkbox"/> Returnable Packaging			
<input checked="" type="checkbox"/> ESD-Protection DIN EN 61340-5-3 D [Max. quantity of parts per smallest packaging unit: _____]			
<input type="checkbox"/> Bulk Material (No Special Requirements)		<input type="checkbox"/> Special packaging in PE-Bag / Heat Sealed	
<input type="checkbox"/> On Reel (max. Ø800 mm)		<input checked="" type="checkbox"/> Special packaging according to special agreement	

Isometric view
Scale: 1:1



④	X	-	4	1	only raw part number 10328-096 in description added	----	2025-12-16	
	X	-	3	1	raw part number deleted	----	2025-11-06	
	X	-	2	13	alignment system changed; dimension removed	----	2025-11-06	
	X	X	1	7	added rib for assembly; adjusted BEB; adjusted dimensions	ECR0003605	2025-07-23	
20		3D	Index	Count	Change Description		Change Number	Date YYYY-MM-DD
Surface:		See Drawing			SPC Dimension:		Project Number:	10084
Material:		MAKROLON TYP 2407 white-transparent 020083			Material Number:	00698-279/0000	Volume:	1683 mm³
General Tolerance:		See Drawing			Technical Reference:		Scale:	2:1 (1:1)
Part Number:		13046-437/0001			3D Name: Code: The 3D model is binding.	dnr:72901849-00023399 CATIA V5 R14 934 934	Dimensional Unit: Projection:	mm 
Title:		rocker S1 Intlick PRM PAINT						
Approval Date:		2025-12-16		Approved By:	F. Sueppel	Creator:	A. Hauck	Sheet: 1/1 Format: A/I
BACH_M1 17.12.2025 10:25:44 Norm: GE_M1 C:\Users\johann.schneider\AppData\Local\Microsoft\Windows\Temporary Internet Files\Content.IE5\534 934 934 CATIA V5 R14 934 934								

It is whether allowed to pass this drawing on to a third party nor to copy it, unless permitted in writing. Violations lay under the obligation of compensation. We reserve the right of patent and register trade mark application.

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