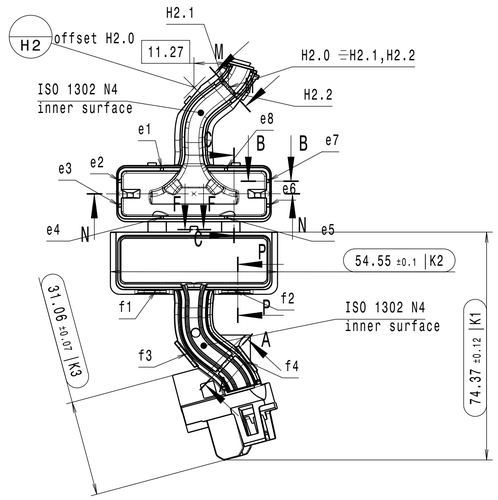
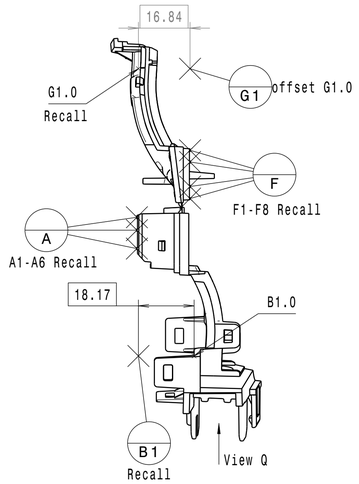
Specific Quality Requirements	(Only for external supply)
Initial sample process according to: ○ VDA Volume 2 ⓧ AIAG	Applicable Preh Quality Standard Purchasing: MP.03 Actual Version

Customer Standards and Requirements	
Applicable specifications to be considered:	Submission specifications to be documented:
GS 93008, GS 93016	---

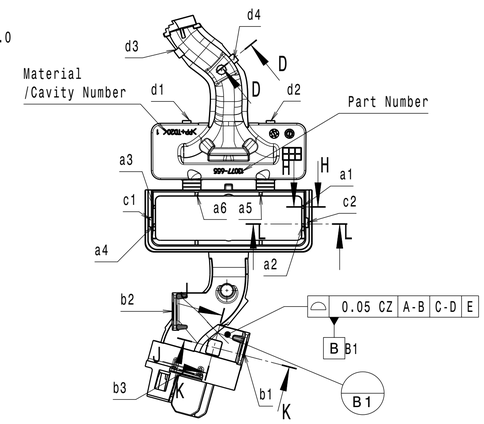
Packaging according to Packaging Specification Data (PSD)		○ Additional external PSD available
Packaging according to Preh Packaging Guideline	○ Expendable Packaging	○ Returnable Packaging
ⓧ ESD-Protection DIN EN 61340-5-3 D	Max. quantity of parts per smallest packaging unit: ____	
○ Bulk Material (No Special Requirements)	○ Packaged in PE-Bag / Heat Sealed	
○ On Reel (max. Ø800 mm)	○ Special packaging according to special agreement	



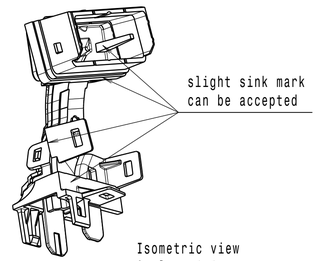
Front view.2
Scale: 1:1



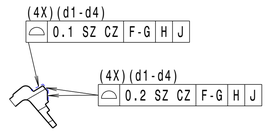
Left view
Scale: 1:1



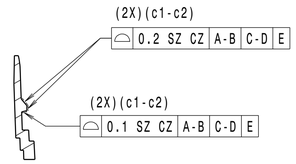
Front view.4
Scale: 1:1



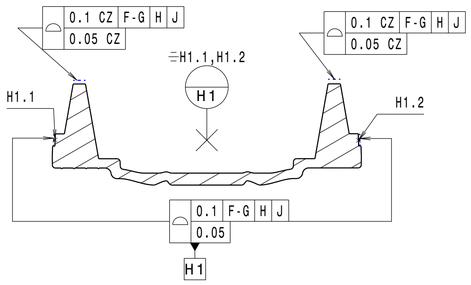
Isometric view
Scale: 1:1



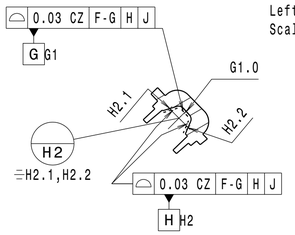
Section cut D-D
Scale: 2:1



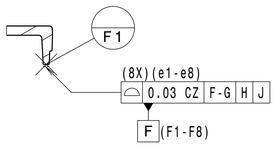
Section cut L-L
Scale: 2:1



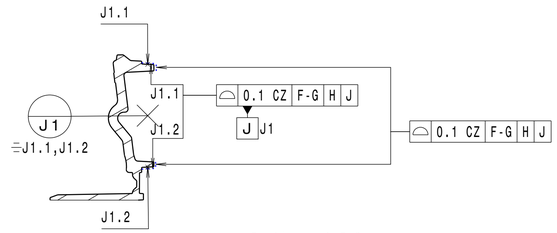
Section cut N-N
Scale: 2:1



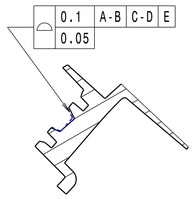
Section cut M-M
Scale: 2:1



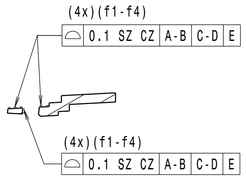
Section cut B-B
Scale: 2:1



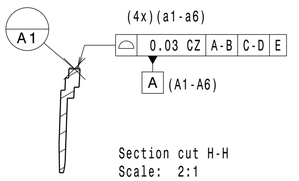
Section cut C-C
Scale: 2:1



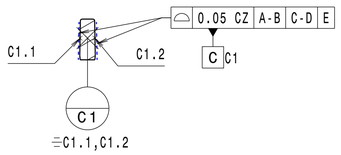
Section cut A-A
Scale: 2:1



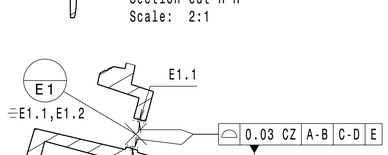
Section cut P-P
Scale: 2:1



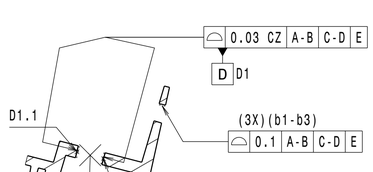
Section cut H-H
Scale: 2:1



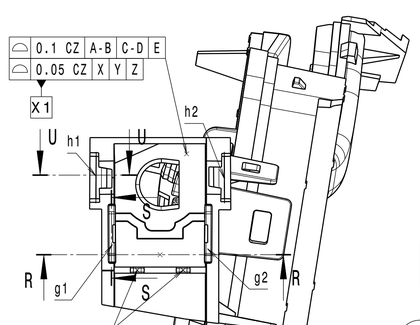
Section cut F-F
Scale: 2:1



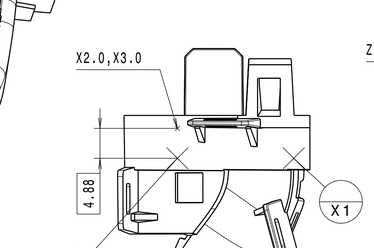
Section cut J-J
Scale: 2:1



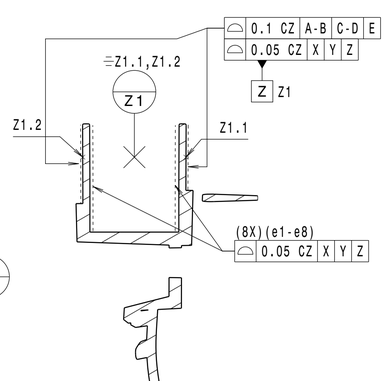
Section cut K-K
Scale: 2:1



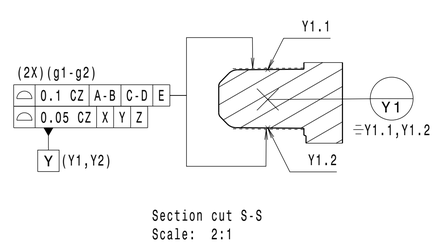
View Q
Scale: 2:1



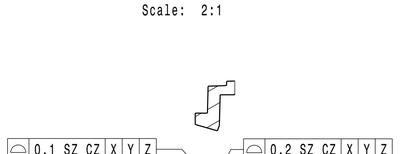
Auxiliary view E
Scale: 2:1



Section cut R-R
Scale: 2:1



Section cut S-S
Scale: 2:1



Section cut U-U
Scale: 2:1

Non marked sharp edges may feature a maximum radius of R=0.3 mm. (T100)

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

Surfaces that are marked as guiding areas must be processed in the tool using high-speed cutting (HSC).
Only if this is not possible may the surface in the tool also be done by eroding
and subsequent polishing in the demolding direction or by very fine EDM. (T102)
However, this must be confirmed by the Preh tool expert and the mechanical designer.

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.) (T104)
(Limit sample about acceptable discrepancies will be agreed separately).

Test conditions according to ISO 291 Class 2

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 E

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.

Roughness should depend on optical performance of physical part. Not need to measure it until component get bad light performance.

Part has to be measured in a measurement device!

Gate residue should be less than 0.5mm;
The hinge must be intact and free from any damage when it delivered!

X	X	2	-	3D updated based on tooling DFM; 2D add measuring points and updated based on 3D changed	----	2025-12-16
X	X	1	-	3D update for light leakage issue; 2D add datum for Housing 1, update based on new data	----	2025-09-29
2D	3D	Index	Count	Change Description	Change Number	Date YYYY-MM-DD

Surface: See Drawing	SPC Dimension: |K_	Project Number: 10660	
Material: PP+TD20 white PRET A5132T CW7920	Material Number: 00701-504/0000	Volume:	mm³
General Tolerance: See Drawing	Technical Reference: Mark Ma	Scale: 1:1 (2:1)	
Part Number: 13077-655/0000	3DX Name: drw-72901849-00023587 CAD-System: CATIA V5 R32 SP4 The 3D model is binding.	Dimensional Unit: mm Projection:	
Title: carrier_NB5_MIKO		preh	
Approval Date: 2025-12-18	Approved By: y. guo	Creator: Q. Li	Sheet: 1/1 Format: A1

50 Copy Sample 13077-655/0000 Zebrowski/Erel

It is neither allowed to pass this drawing on to a third party nor to copy it, unless permitted in writing. We reserve the right of patent application. We reserve the right of patent. Preh GmbH