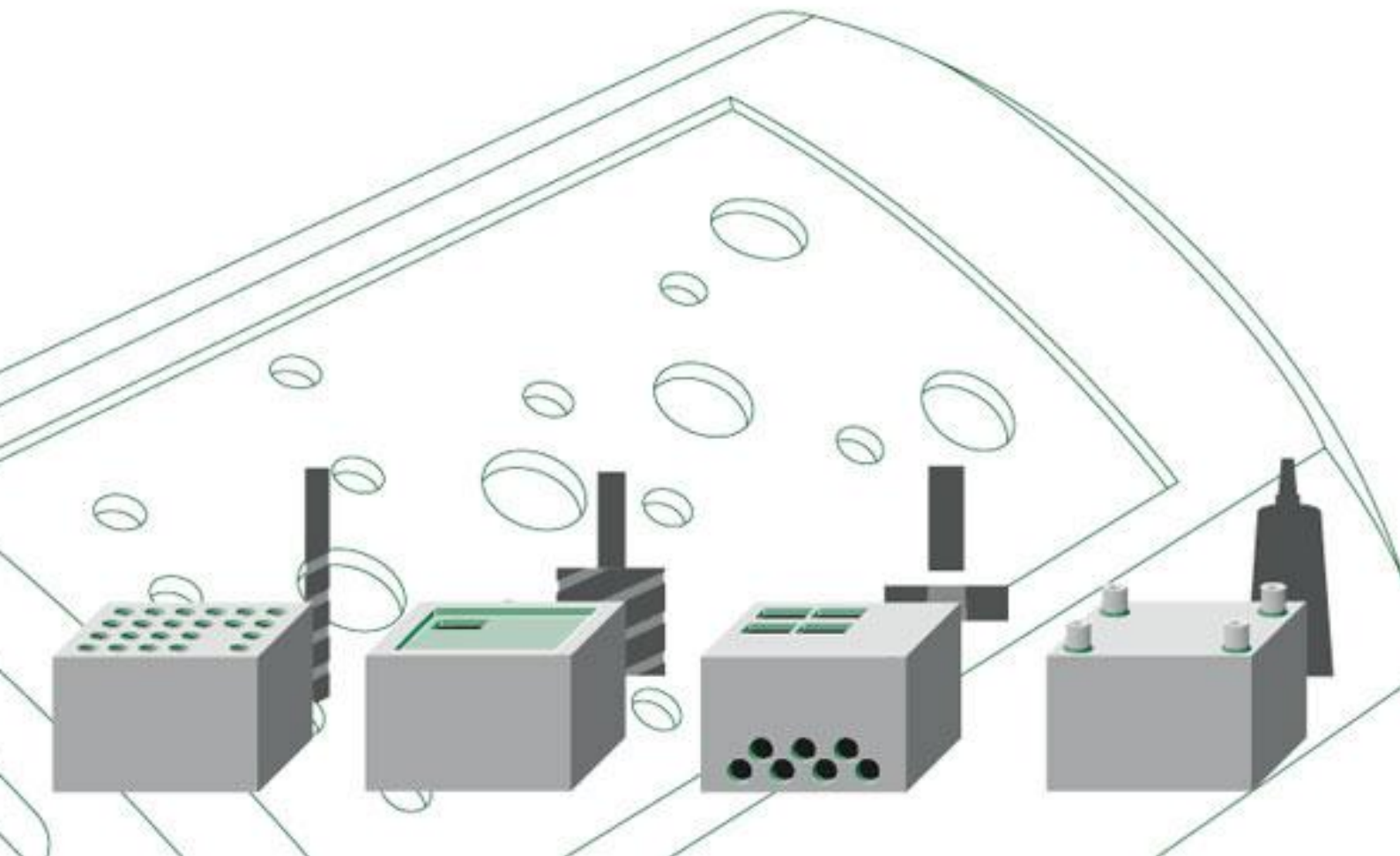


MACHINING



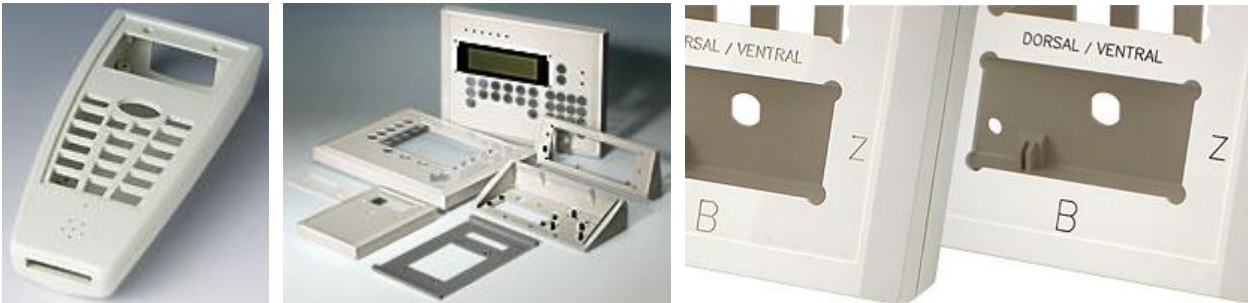
SERVICES

In our SERVICE-CENTRE we can fulfil your processing wishes quickly and cheaply. State-of-the art machines guarantee high and uniform quality.

Our services: drilling, tapping and threading, milling, punching, engraving and glueing in place of additional distance ribs and bosses for fastening of PCBs.

Incomplete information makes the working process complicated and time-consuming. We should therefore like to inform you in the following of the specifications required to ensure smooth implementation, from the formulation of the requirements through the inquiry to the order. Please, follow also the technical references, general tolerance etc.

DESIGN EXAMPLES



GENERAL INFORMATION

- Part-No. Of the standard enclosure of tuning knob
- Repeat order with/without modification
- Quantity
The number of pieces delivered may vary by +10% from the order quantity.
For order quantities that are not to be undershot, please give us specific notification.
- Intended price
- Required delivery period
- Part-No. and designation of the additional parts
If orders are placed, additional parts are given an OKW Part-No. The delivery of these parts must be announced on time with information of our Part-No.
Please note this on the delivery note for shipment. No quality tests are carried out on additional products by the incoming merchandise department.

Scheduled delays of complete shipments due to late supply have to be borne by the customer.

GEOMETRICAL DESCRIPTION OF THE REQUIRED MODIFICATION

- according to the drawing no., status, date (if required date of receipt)
- according to sample
- according to last delivery with/without modification
- according to sketch

Please give the following information:

- on the part (upper or lower part, tongue or groove part etc.)
- on the side (which side is to be modified?)
- on the radii (size)

Readable file formats for data import (WIN): Solid Works
 Alternatively: preparation of drawing for processing by OKW Gehäusesysteme against calculation.



Data medium:
 E-Mail, CD-Rom, DVD, Zip (100 MB)

TECHNICAL REFERENCES

Materials to be processed are all materials in the OKW catalogue. TPE and other materials on request.

- All dimensions < 30 mm to the reference edge of the case with a tolerance of ± 0.3 mm. All other dimensions: unless otherwise specified against DIN ISO 2768m T1. For general tolerances see below.
- The treatments on the visible side are free of burr. De-burring on the invisible side on request.
- In milling work, the corner radius selected has a decisive effect on processing times and thus on costs as well. Without punching tool the smallest radii amounts to 0.5 mm. Smaller radii are punched. Integrated parts and operating elements frequently allow a greater corner radius without any adverse effect on correct functioning. Favourable radii should be produced from 1.0 mm upwards.

Engraving

Type of engraving (Engraving can be filled with colour if required.)	Engraving width	Letter height
single font 	0.4 mm	up to 5 mm
	0.6 mm	5 – 15 mm
	0.8 mm	> 15 mm
double font (Outline) 	0.4 mm	all heights

GENERAL TOLERANCES WITHIN THE SURFACE

According to ISO 2768m T1.

Linear measure

Nominal dim.	0.5 – 6 mm	6 – 30 mm	30 – 120 mm	120 – 400 mm	400 – 1000 mm
Tolerance	± 0.1 mm	± 0.2 mm	± 0.3 mm	± 0.5 mm	± 0.8 mm

Angular measure

Nominal dim.	bis 10 mm	10 – 50 mm	50 – 120 mm	120 – 400 mm	> 400 mm
Tolerance	± 1°	± 0.5°	± 0.33°	± 0.16°	± 0.08°

Radii

Nominal dim.	0.5 – 3 mm	3 – 6 mm	6 – 30 mm	30 – 120 mm	120 – 400 mm
Tolerance	± 0.2 mm	± 0.5 mm	± 1 mm	± 2 mm	± 4 mm

FIXED COSTS

According quotation.

FORM OF DELIVERY

Same as standard (in PE-bags, in layers in the cartons).
Special agreements possible.

Quantity differencies + 10 % possible.

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