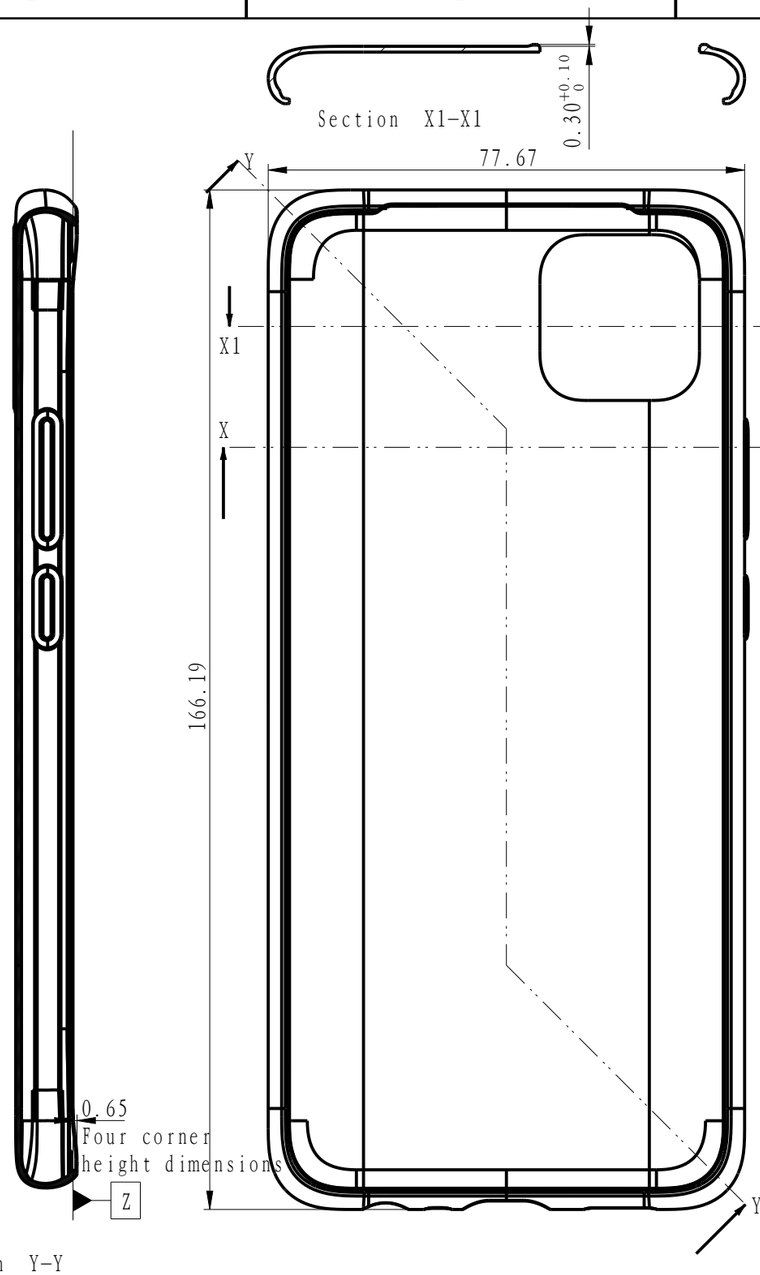

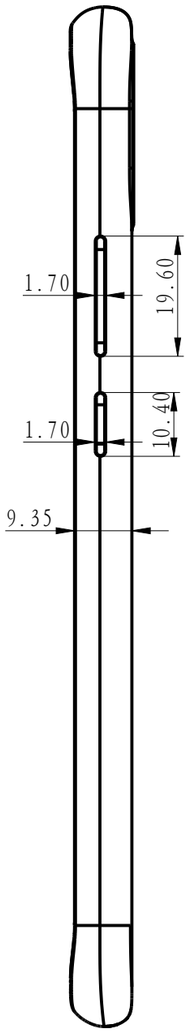

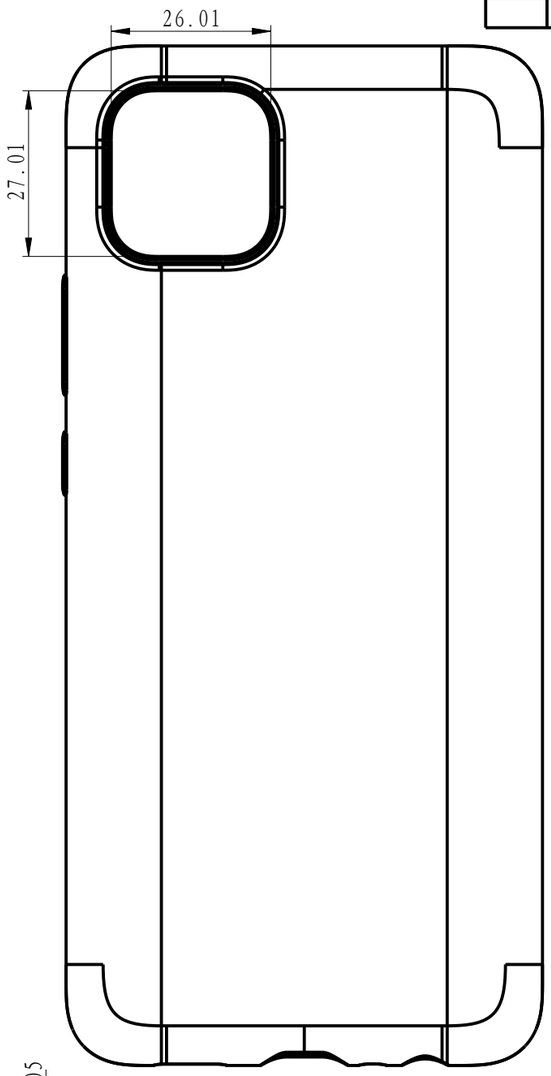

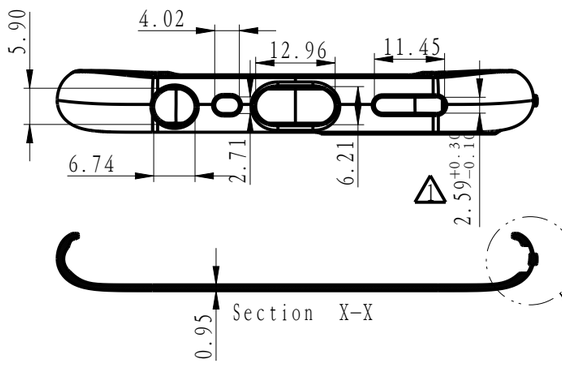

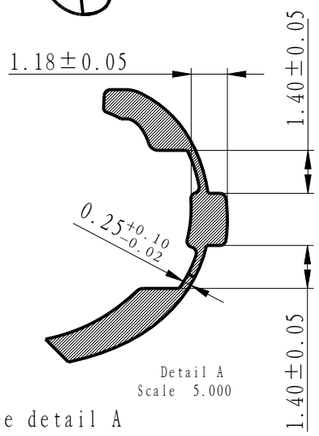

Change history					
Area	Mark	Change contect discription	Date	Change	Approve
N/A	N/A	First issue	2020/07/10		
	1	The Speaker sound hole tolerance adjustment	2021/09/02		

Unmarked dimension tolerance table					
>	≤	Plastic	Metal	Die Casting	Rubber
0	3	±0.05	±0.05	±0.10	±0.10
3	6	±0.07	±0.05	±0.10	±0.10
6	30	±0.10	±0.10	±0.15	±0.15
30	120	±0.15	±0.15	±0.25	±0.25
120	~	±0.20	±0.20	±0.30	±0.3%
Unmarked angle tolerance ±0.5°					

NOTE:
1. Material: transparent TPU;
Products are not allowed to use recycled materials, without OPPO permission, not allowed to replace materials;
Raw materials meet the DKBA0.400.0368 terminal non-metallic material quality requirements , Part 1: Plastics and Rubbers if the above requirements exist any with Where the project drawing conflicts, the drawing shall prevail;
2. Appearance surface and spark pattern specific must refer to ID process documents;
3. All dimensions are final product dimensions, 2D are not marked tolerance dimensions, their tolerances are referenced to tolerance tables, 2D are not dimensioned, reference to 3D , their tolerances are referenced tolerance tables;
4. With the size of the key size, as the key testing items, need to be tested in each batch;
5. With runway size: this size for SPC control and CPK requirements,and
CPK ≥ 1.33;
6. The product shall be matched with the FA-105 machine, and the effect shall meet the corresponding Wingtech appearance standards (step, gap, etc.) and performance (feeling, etc.) standards and requirements;
7. Product appearance can not have dirty, scratches, shrinkage, top white and other defects, the product can not have more or less materials;Flash ≤ 0.05mm, step ≤ 0.05mm
Products must meet the appearance, performance, testing standards and requirements of Wingtech;
8. Parting line position, port position and size, melting wiring position, date stamp, mold number, recycling mark supplier information and other signs must be determined after consultation with Wingtech,
The symbol is 0.1mm lower than the housing, and if there is no special description, the Litter, the ejector pin cannot be higher than the surface, and Litter&ejector pin step ≤ 0.05mm, ; Slide step ≤ 0.05mm ;
9. If there is no special description, It shall be one degree reduction material draft in no draft area(drafted must be in accordance with 3D); Unfilled process fillet ≤ 0.15mm;
10. FOT, trial production, mass production must be done melting index (MFI) testing and degradation rate calculation, and FOT and sign-off need to provide a written report;
MF11: the melting index of raw materials, to meet the performance requirements of raw materials;
MF12: melting index after injection molding;
Degradation rate: (MF12-MF11)/MFX100% ≤ 30%;
11. Any defects that exceed the standards, specifications and drawing requirements need to be expressed in the sample and the certificate of recognition, and shall be admitted by Wingtech with a limited extent;
12. Sealing path can not be only ejector pin etc, require to keep the sealing path smooth , sealing ribs do not allow to lack material, sound holes do not allow to have flash;
13. The product shall meet the technical standards for reliability testing of terminals and mobile phones and structural parts, and if there is any conflict with the drawings in this specification, the drawings shall prevail;
14. About the product four-corner drop test, four-corner drop test, to not perforate as OK, the product will be deformed after environmental testing, not affect assembly is OK after testing.

All assembly match requirements:
1. All mating holes (USB hole, SPK hole / main deputy MIC hole, headphone hole, fingerprint hole, camera hole, flash hole, etc.) shall be matched with the whole machine,
No obvious shift is allowed; Deatil refered to ID signed sample.
2. Side key and the whole machine assembly need to have a good feeling, it is not allowed to be cracked after testing;The phone can not be moved in the shell in any direction after matching because of soft TPU shell .
After the shell is matched, It should not have gap between phone and shell all around , It can not have external stress, relaxation and other bad conditions in a free states;
3. All molds need to be satisfied:It need to meet the whole machine with higher,middle and lower limit dimension for DOE verification .;

Inscription require	
XXXXX	Project code
XXYY	XX: Mold NO. YY: Hole NO.
	• Trial times (mark) x Product version
	Date stamp
=XX=	Recycle stamp

Inscription require:Convex character, surface cut down 0.10mm, word is not higher than the surrounding face, word width of the minimum 0.10mm.

oppo			Protect shell		AA281-PROTECTIVE-SHELL
Design	Lujunyong		Material		Scale: 1.000 / Version: V02
Check			CMF		Unit: mm / Weight(g)
Standard					
Approve			Page	Total Pages	