*注意事項:

55",65" 素材, 噴漆之色差檢驗標準請比照 PHILIPS No. 80007

RD 已確認,如 mail 說明



蘇州佳世達 DQ9

承 認 書

客戶 : DIVA
料號 : 3MD665P1010 (M3545)
品名 : REAR COVER (M) (RUG6513AMI,BLACK)

QISDA 料號: 3J.64701.A11
QISDA 品名: RC MIDDLE RUG6513AMI

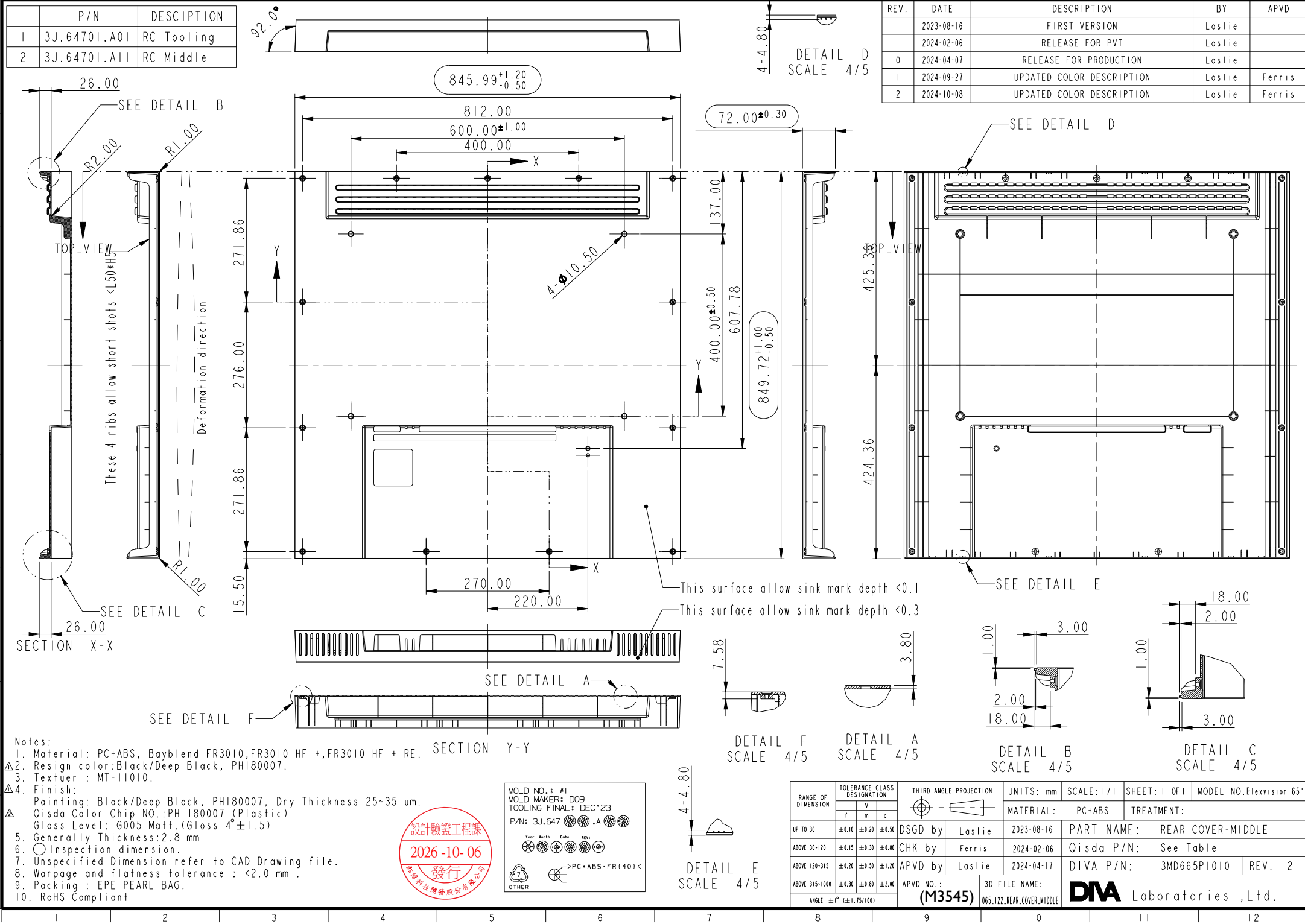
版本: 0
日期 : 2026.09.30

設計驗證工程課
2026 -10- 06
發行

(本封面非供應商文件)

	P/N	DESCIPTION
1	3J.64701.A01	RC Tooling
2	3J.64701.A11	RC Middle

REV.	DATE	DESCRIPTION	BY	APVD
	2023-08-16	FIRST VERSION	Laslie	
	2024-02-06	RELEASE FOR PVT	Laslie	
0	2024-04-07	RELEASE FOR PRODUCTION	Laslie	
1	2024-09-27	UPDATED COLOR DESCRIPTION	Laslie	Ferris
2	2024-10-08	UPDATED COLOR DESCRIPTION	Laslie	Ferris



Notes:
1. Material: PC+ABS, Bayblend FR3010,FR3010 HF +,FR3010 HF + RE.
△2. Resign color:Black/Deep Black, PH180007.
3. Textuer : MT-11010.
△4. Finish:
Painting: Black/Deep Black, PH180007, Dry Thickness 25~35 um.
△ Qisda Color Chip NO.:PH 180007 (Plastic)
Gloss Level: G005 Matt.(Gloss 4°±1.5)
5. Generally Thickness:2.8 mm
6. ◯Inspection dimension.
7. Unspecified Dimension refer to CAD Drawing file.
8. Warpage and flatness tolerance : <2.0 mm .
9. Packing : EPE PEARL BAG.
10. RoHS Compliant

設計驗證工程課
2026 -10- 06
發行

MOLD NO.: #1
MOLD MAKER: D09
TOOLING FINAL: DEC'23
P/N: 3J.647 .A
Year Month Date REV.
>PC+ABS-FR1401<
OTHER

RANGE OF DIMENSION	TOLERANCE CLASS DESIGNATION f	V m	V c
UP TO 30	±0.10	±0.20	±0.50
ABOVE 30~120	±0.15	±0.30	±0.80
ABOVE 120~315	±0.20	±0.50	±1.20
ABOVE 315~1000	±0.30	±0.80	±2.00
ANGLE ±1° (±1.75/100)			

THIRD ANGLE PROJECTION

DSGD by	Laslie	2023-08-16
CHK by	Ferris	2024-02-06
APVD by	Laslie	2024-04-17

APVD NO.: (M3545)

3D FILE NAME: 065.122.REAR_COVER_MIDDLE

UNITS: mm | SCALE: 1/1 | SHEET: 1 OF 1 | MODEL NO.:Flexvision 65"

MATERIAL: PC+ABS | TREATMENT:

PART NAME: REAR COVER-MIDDLE

Qisda P/N: See Table

DIVA P/N: 3MD665P1010 | REV. 2

DIVA Laboratories ,Ltd.

Qisda

Dimension Approval Sheet

Model Name:	RUG6513AMI	**Sample Approval Sheet NO.:**	
Part Name:	RC MIDDLE	**Material:**	PC/ABS
Part Number:	3J.64701.A11 **REV:** A0	**Color:**	BLACK
Vendor:	DQ9	**Date:**	2024.5.8

Inspection Gauge:

Coordinate Measuring Machine	(CMM)	Micro Scope	(M)	Radius Gauge		**Distribution**	
Caliper	(C)	Height Gauge	(HG)	Block Gauge		R&D	
Micrometer	(M)	Projector	(P)	Visual		QC	
Pin Gauge	(PG)	Thickness Gauge	(T)	Lever Type Dial Test		Purchase	
						Vendor	

Vendor Input **Low** **High**

If the Range is Greater Than 50% of the Total Tolerance the Cell will be RED

Item	Dim. Loc.	Gage Code	Cav. No	Spec.	Upper Tol	Lower Tol	Upper Limit	Lower Limit		Sample 1	Sample 2	Sample 3	RD Check Sample	Average	Status	Range	Disposition	Comments
1	A5	CMM	1	845.99	1.2	0.5	847.19	845.49		846.981	846.896	846.623	846.981	846.87025	OK	0.147		
2	D8	CMM	2	849.72	1	0.5	850.72	849.22		850.539	850.259	850.334	850.539	850.41775	OK	0.124		
3	B8	CMM	3	72	0.3	0.3	72.3	71.7		72.150	72.220	72.260	72.150	72.195	OK	0.047		
4	B1	CMM		26	0.2	0.2	26.2	25.8		26.060	26.040	26.060	26.060	26.055	OK	0.009		
5	B1	CMM		2	0.2	0.2	2.2	1.8		2.130	1.980	1.980	2.130	2.055	OK	0.075		
6	B2	CMM		1	0.2	0.2	1.2	0.8		0.980	1.033	0.963	0.980	0.989	OK	0.026		
7	D1	CMM		2	0.2	0.2	2.2	1.8		2.129	1.988	1.980	2.129	2.0565	OK	0.073		
8	E1	CMM		26	0.2	0.2	26.2	25.8		26.050	26.040	26.000	26.050	26.035	OK	0.021		
9	E2	CMM		1	0.2	0.2	1.2	0.8		1.010	1.018	0.933	1.010	0.99275	OK	0.035		
10	A3	CMM		92	0.3	0.3	92.3	91.7		91.860	92.120	92.030	91.860	91.9675	OK	0.112		
11	A5	CMM		812	0.8	0.8	812.8	811.2		812.392	812.515	812.443	812.392	812.4355	OK	0.050		
12	B5	CMM		600	1	1	601	599		600.168	600.261	600.259	600.168	600.214	OK	0.046		
13	B5	CMM		400	0.8	0.8	400.8	399.2		399.909	400.001	400.070	399.909	399.97225	OK	0.068		
14	C3	CMM		271.86	0.5	0.5	272.36	271.36		271.776	271.859	271.878	271.776	271.82225	OK	0.047		
15	D3	CMM		276	0.5	0.5	276.5	275.5		275.943	276.034	276.034	275.943	275.9885	OK	0.046		
16	E3	CMM		271.86	0.5	0.5	272.36	271.36		271.795	272.081	272.003	271.795	271.9185	OK	0.127		
17	E3	CMM		15.5	0.2	0.2	15.7	15.3		15.520	15.532	15.549	15.520	15.53025	OK	0.012		
18	E5	CMM		270	0.5	0.5	270.5	269.5		269.928	269.927	269.972	269.928	269.93875	OK	0.019		
19	E5	CMM		220	0.5	0.5	220.5	219.5		220.142	219.942	220.160	220.142	220.0965	OK	0.090		
20	B7	CMM		137	0.3	0.3	137.3	136.7		137.077	136.945	136.925	137.077	137.006	OK	0.071		
21	C7	CMM		400	0.5	0.5	400.5	399.5		400.013	400.153	400.156	400.013	400.08375	OK	0.071		
22	C7	CMM		607.78	0.8	0.8	608.58	606.98		607.697	607.640	607.787	607.697	607.70525	OK	0.053		
23	C9	CMM		425.36	0.8	0.8	426.16	424.56		425.274	425.054	425.409	425.274	425.25275	OK	0.127		
	D9	CMM		424.36	0.8	0.8	425.16	423.56		424.059	424.106	423.933	424.059	424.03925	OK	0.064		
	F9	CMM		3.8	0.2	0.2	4	3.6		4.000	3.932	3.978	4.000	3.9775	OK	0.028		
	F10	CMM		1	0.2	0.2	1.2	0.8		1.120	1.030	1.030	1.120	1.075	OK	0.045		
	F10	CMM		3	0.2	0.2	3.2	2.8		2.950	2.949	2.955	2.950	2.951	OK	0.002		
	F10	CMM		2	0.2	0.2	2.2	1.8		2.040	2.015	1.942	2.040	2.00925	OK	0.040		
	F10	CMM		18	0.2	0.2	18.2	17.8		17.920	17.981	17.965	17.920	17.9465	OK	0.027		
	F12	CMM		1	0.2	0.2	1.2	0.8		1.120	1.030	1.000	1.120	1.0675	OK	0.054		
	F12	CMM		18	0.2	0.2	18.2	17.8		17.870	17.820	18.030	17.870	17.8975	OK	0.079		
	F12	CMM		2	0.2	0.2	2.2	1.8		2.040	1.980	1.950	2.040	2.0025	OK	0.039		
	F12	CMM		3	0.2	0.2	3.2	2.8		2.990	2.970	3.010	2.990	2.99	OK	0.014		
	A11	CMM		4.8	0.2	0.2	5	4.6		4.820	4.660	4.680	4.820	4.745	OK	0.075		
	A11	CMM		7.58	0.2	0.2	7.78	7.38		7.690	7.650	7.680	7.690	7.6775	OK	0.016		

Initiator:Guofeng Zhang Reviewed by :Carlos Q Chen Approve by: DIVA/Leslie

Tooling Trial Shoot Report

Date: 2024/4/10 Rev:1.0 Page:1 of 1

Model	RUG6513AMI	**Tooling (Styling)**	
Part No	3J.64701.A11	**Part Name**	RC MIDDLE
Sequence No	QI230101/QP-987	**Cavity**	1
Mold Maker	DQ9	**Molder**	DQ9

Mold Specification

Mold Dimension (W/O Package)				**Mold Dimension(W Package)**			
L (cm)	**W(cm)**	**H(cm)**	**Weight(Kg)**	**L (cm)**	**W(cm)**	**H(cm)**	**Weight(Kg)**
Shrinkage	**Texture**	**Ringbolt (mm)**	**Locator (mm)**	**Cavity Side Material**	**Core Side Material**	**Slider Material**	

Molding Condition

Molding Machine	**1700 T**

Material	**PC/ABS FR3010 HF 901510**		**Weight**	**产品重量：2950 g，料头重量 g**	
Temperature	**Nozzle**	**Front**	**Middle**	**Rear**	
	245	**255**	**260**	**255**	
Pressure	**1st Pressure**	**2nd Pressure**	**3rd Pressure**	**4th Pressure**	**5th Pressure**
	190				
Velocity	**1st Velocity**	**2nd Velocity**	**3rd Velocity**	**4th Velocity**	**5th Velocity**
	35	**45**	**60**	**85**	**85**
Position	**1st Position**	**2nd Position**	**3rd Position**	**4th Position**	**5th Position**
	264	**255**	**240**	**200**	**65**
Holding Pressure & Velocity	**1st H/Pressure**	**2ndH/Pressure**		**1st H/Velocity**	**2nd H/Velocity**
	40	**40**		**1.5**	**2**
Time	**Cycle Time**	**Injection**	**Cooling**	**Others**	
	200	**10**	**80**	**110**	
Molder:		**Tooling Engineer:**		**Approved By: Jinbing JB Wang**	

苏州佳世达精密工业有限公司

包 装 规 范

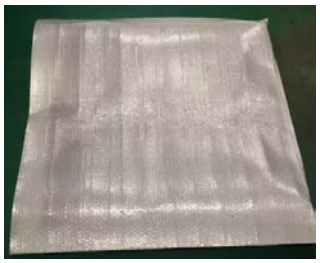
PACKAGING SPECIFICATION

客户	Qisda	制程	成型	文件编号		版本	A0
材质	PC/ABS	模号	QI230101/QP-987	穴数	1	部门	工程
包装数量		4PCS		工位名称	包装站	页码	1/1

包装图示步骤



此边朝气泡袋内装入并朝下放入纸箱







贴制品票区域:纸箱短侧面右上角

机种	客户料号	DQ9料号	品名
RUG6513AMI	3J.64701.A11	3P.18842.A12	RC MIDDLE RUG6513AMI 中盖

作业步骤:

1. 先将纸箱用透明胶带封底，封两次要封牢，
2. 在箱子底部放1pcs隔板；
3. 将加工OK后的产品装入气泡袋内，1袋装1pcs，将包装袋多余部分折向公模面；
4. 将包装好的产品垂直放入纸箱内，产品母模相对放入纸箱，产品公模面之间放1pcs隔板；
5. 装满一箱后再最上层放1pcs隔板；箱子口用胶带封口。
6. 装满后用透明胶带将制品票贴覆于纸箱短侧面右上角处(制品票上、下都须用胶带粘贴).每装完一箱贴一张制品票；

项目	序	材料名称	材料规格	材质	用量	注意事项
包装材料	1	纸箱	VS.4D109.001	瓦楞	1/4	1.胶箱请勿倒立.
	2	隔板A	VS.4D109.002	瓦楞	2/4	2.胶箱请勿淋雨，暴晒.
	3	隔板B	VS.4D109.003	瓦楞	1/4	3.在贴标签时，请将旧标签撕掉.
	4	气泡袋	VS.4B112.001	PP	4/4	4.请将标签贴至相应位置.
						5.包规中所有使用的包材符合HSF.
替代包装材料						6..除此外不可使用其它辅材,防止有害物质污染产品.

版本	修改人	变更内容	变更日期	版	修改人	变更内容	变更日期

修订日期	2023/11/15	制作		批 准		核 准	

AP_GP BOM Report

Qisda P/N	3J.64701.A11
Qisda Item description	RC MIDDLE RUG6513AMI
Maker	Qisda Molding Factory
Maker P/N	3J.64701.A11
Create date	2024/10/09

Component type	Description	Supplier	Subpart type	Subpart Description	Subpart Supplier	Sample Description	Remark	Report No.	Test Date	Cd	Pb	Hg	Cr6+	PBBs/PBDEs	Br	Cl	Br+Cl	DIBP	DEHP	BBP	DBP	F	I	Exemptions
Ink/Paint/Pigment	水性涂料（银/红/蓝/黑/白/灰/等....）	苏州市利得威电子科技有限公司	Ink/Paint	水性涂料（银/红/蓝/黑/白/灰/等....）	苏州市利得威电子科技有限公司	混测,红色,蓝色,黑色,白色,灰色与银色液体		A2240206071101001C;A2230296530101001C	2024/04/18;2023/06/21	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	
Plastic Housing	FR3010HF 901510	航耀	Plastic Resin of Housing	FR3010HF 901510	航耀	黑色塑胶颗粒	航耀是Covestro(科思创)代理商	QHJ2403038802/CH;QHJ2403038801/CH	2024/04/10;2024/04/03	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	1570	N.D	
Summary data										N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	N.D	1570	N.D	