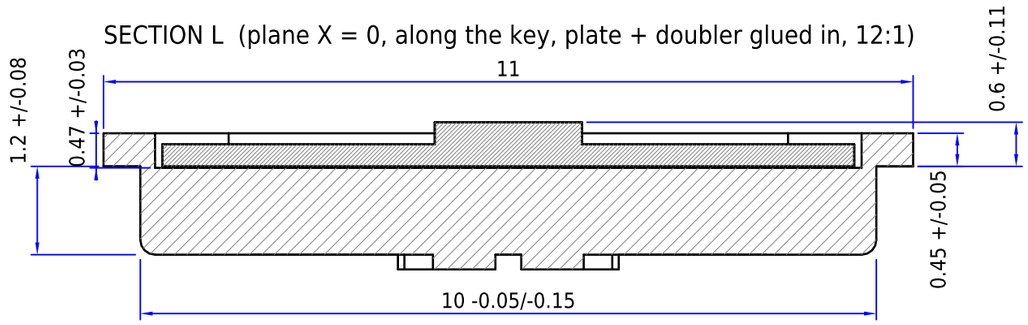
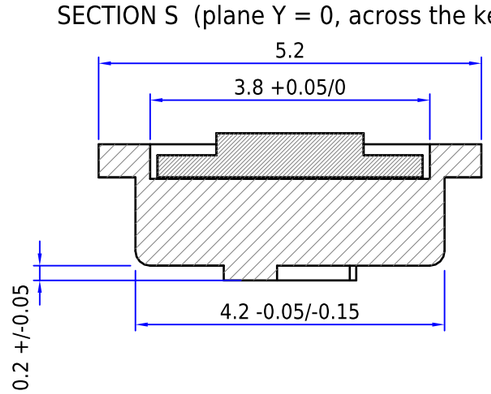
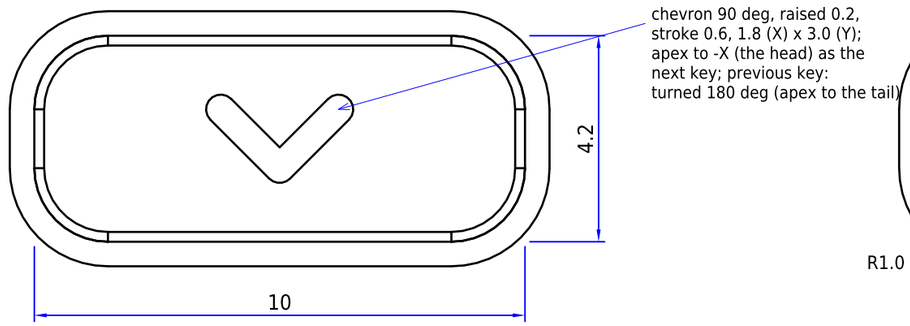
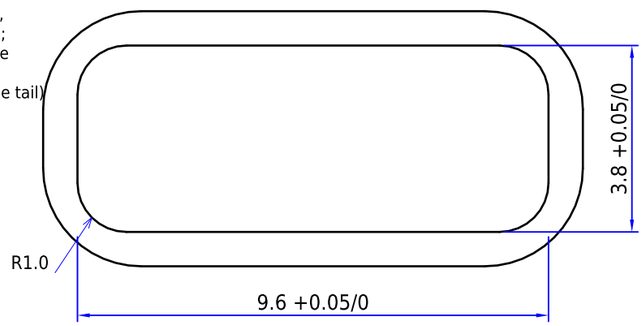


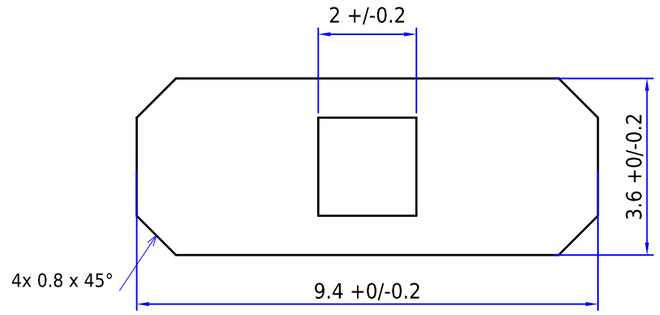




BOTTOM VIEW (from -Z, outer face, 8:1)



TOP VIEW (from +Z, inner face: the recess, 8:1)



STIFFENER: PLATE + DOUBLER (0.3 shim, 8:1)

ID	FEATURE	SPECIFICATION	TOLERANCE / NOTE
1	Rubber	black PU rubber Shore A 80 cast at home in the mould FK-H-08 (resin print or aluminium), e.g. ECON 80 or PMC-780 DRY + black colorant (Sugru, pressed in, is Shore A 70); series: moulded silicone A 75-85	Shore A 80 +/-5
2	Stiffener	plate 3.6 x 9.4, corners clipped 0.8 x 45 deg, and doubler 2.0 x 2.0, both 0.3 stainless steel shim 1.4301: cut with tin snips (or laser cut), deburred, flat	outline +0/-0.2 thickness +/-0.02
3	Gluing	doubler on the plate centre, then the plate into the recess, doubler up; cyanoacrylate on degreased, roughened faces (Sugru keys: fresh Sugru); the doubler top presses the switch	doubler top see section L
4	Key	4.2 x 10.0, R1.5; flange 5.2 x 11.0 x 0.45 on the floor of the tray; recess 3.8 x 9.6 R1.0, 0.47 deep in the inner face; no pocket, no nub	outline -0.05/-0.15 others: see sections
5	Surface	key face as the mould leaves it (aluminium mould: matte, chevron top glossy; resin mould: the print's surface); no flash on the outer face; face edge R0.2; cut the gate (flange end) and the vent stubs flush	
6	Quantity	2 per light (next and previous are the same part, turned 180 deg), plus spares; the mould casts 4 per pour	

NOTES
1 Geometry per FlashKa_key_side.step (cast rubber), FlashKa_key_stiffener.step (plate + doubler in the glued position) and FlashKa_key_side_with_plate.step; in the STEP files the key sits in the housing frame at X 18.65, here it is centred.
2 The plate makes the key a stiff rocker: pressed 2.0 mm from one end it actuates the switch with 1.035 N and 0.73 mm of key travel (rubber only, without the plate: 3.9 mm).
3 Free play doubler -> switch 0.25 mm at rest: flange underside to doubler top 0.6 +/-0.11 worst case (recess floor +/-0.05, two shims +/-0.02 each, glue films 0.02).
4 General tolerances ISO 3302-1 class M2; home-cast keys +/-0.10 where no tolerance is given. Black throughout, no paint, no marking.

SIDE KEY - CAST RUBBER + GLUED STIFFENER (2x)

Part: FK-H-04 FlashKa_key_side.step (rubber), FlashKa_key_stiffener.step (plate + doubler)	SCALE 8:1, sections 12:1 SHEET 1/1
FlashKa Keychain v0.7 2026-10-23	Units mm | ISO 3302-1 M2