

VR – Process 31
Process
Revision History

Date / Time	Rev	Author	Description
8/26/2017	A	FS	Original Version
9/28/2017	B	FS	Process image added

Approvals

Rev	Approval	Customer	Engineering	Mechanical	Software	Mfg	OPS	QA	Test	Sales	Support	Corp
A	DT											
	Initial											

1.0 Process Description

Description	Pass Panel Through Pressing Process
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VR Part Number	VR1
Customer Part Number	355467-01
Configuration	Standard
Model	SRA-16(20x69]
Process Number	VR102601-31

Process Standard	
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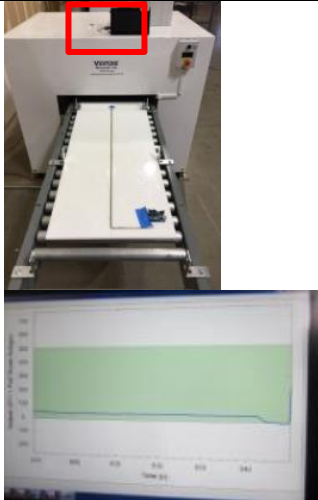
2. Setup

2.1 Technician


Tech #	Certification Required	Skill	Process	Safety
1	No	None	Yes	Yes

2.2 Tools

2.2.1 Calibrated Tools

Number	Tool	Description	Rev	Specification	Calibration Requirements	Image
1	Roller Press Force Sensor	Force Sensor Used to Validate Pressure force.	1	Force cannot be lower than 250N	To be checked against calibrated 10lb weight.	


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2	Roller Press Tachometer	Tachometer used to verify conveyor speed		Speed controlled at 11RPM	Calibrated oscilloscope need to be used to check tachometer output pulses.	
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Pass Panel Through Pressing

2.2.2 Non-Calibrated Tools

Number	Tool	Type	Reference	Image
1	Pressure Controller	Pressure Gauge Valve and Pressure Sensor	Controller used to confirm roller press pressure. Gauge needs to be set to 30PSI. Green LED on stack light should be ON.	

2.3 Materials

#	VR Part Number	Mfg Part #	Manuf	Description	Qty	Requires Serial #	Size	Tolerance	COC Req	Lot Req	Incoming QA Req	Image
1	VR102601	See BOM	See BOM	Bottom ABS, HDPE and Top ABS	1	N	See Engineering Drawing	See Engineering Drawing	Y	Y	Y	

2.4 References

Number	VR Doc Number	Rev	Description	Manuf	Description	Directory
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1						
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2.5 Safety

Number	Type	Description	Reference
1	Safety Power Cut Off Training	All personnel working with or around gluing area need to be able to use safety power cutoff switch.	VR Internal training


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Procedure

Step	Tech	Tool	Material	Tasks description	Reference Drawing	Image
	1		M-1	Place antenna assembly panel on top of conveyor with the bottom ABS side facing up.		
	1		M-2	Slide the shelf all the way inside the chamber without applying too much pressure. Once the roller starts to turn, wait for the speed to reach 11RPM.		

	1		M-2	Check that the green light is ON		
	1			Once the speed is at 11RMP and the green light is on push the shelf in and wait for it to come out of the other side. *The Green light on top of the conveyor should stay on during the entire process.		
	1			If the green light goes off and the buzzer is triggered, the operator should pass the shelf through the roller one more time, with the same side facing up.		

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	1			<p>Once the bottom ABS side has gone through the above process, flip the shelf (bottom ABS side facing DOWN) and run the same process. Always check for the green light and the buzzer.</p>		
				<p>Visually check for gaps between the panels before placing it back into the ESD bag.</p>		

4.0 Process Recording

Step	Tasks description	Reference Drawing / Image

5.0 Non Compliance

#	Non Compliance	Disposition	Reference Drawing / Image