

VR – Process 26

Revision History

Date / Time	Rev	Author	Description
8/26/2017	A	FS	Original Version
10/2/2017	B	FS	Process image added
2/28/2020	C	AA	Removed ABS from the heating process

Approvals

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

1.0 Process Description

Description	Pass HDPE Panel Through Heat Process Air Dry the Bottom ABS Panel
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VR Part Number	VR102601
Customer Part Number	355467-01
Configuration	Standard
Model	SRA-16(20x69]
Process Number	VR102601-26
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

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2.2.2 Non-Calibrated Tools

Number	Tool	Description	Rev	Specification	Requirements	Image
1	Anatol Electric Conveyor Dryer	Dryer to remove the glue solvent layer.	C	Temperature should be @ 300 degrees Celsius. The belt speed should be 7ft/min.	To be checked every year against a calibrated temperature sensor.	
2	J-Roller	J-Roller for Plastic Laminate	1	3 in. J-Roller for up to 25PSI	3 in. J-Roller should be free of debris that could damage the antenna panels.	

2.3 Materials

#	VR Part Number	Mfg Part #	Manuf	Description	Qty	Requires Serial #	Size	Tolerance	COC Req	Lot Req	Incoming QA Req	Image
1	VR102681	See BOM	See BOM	3/8" HDPE – Front Side	1	N	See Engineering Drawing	See Engineering Drawing	Y	Y	Y	

2.4 References

Number	VR Doc Number	Rev	Description	Manuf	Description	Directory
1						

2.5 Safety

Number	Type	Description	Reference
1	Heat Resistant Safety Gloves	Use of heat resistant gloves while placing and removing material from heat chamber is obligatory	Refer to MSDS
2	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

3.0 Procedure

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Pass HDPE Panel Through Heat Process

Step	Tech	Tool	Material	Tasks description	Reference Drawing	Image
	1	NC-1	M-2	Place the HDPE panel on top of conveyor, glue facing up and board side towards heat chamber. Wait for it com come out of the other side.		

4.0 Process Recording

Step	Tasks description	Reference Drawing / Image

5.0 Non-Compliance

#	Non Compliance	Disposition	Reference Drawing / Image