



VR – Process 30

Place Panels into Assembly fixture

Revision History

Date / Time	Rev	Author	Description
8/26/2017	A	FS	Original Version

Approvals

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

1.0 Process Description

Description	Place Panels into Assembly fixture
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VR Part Number	VR1
Customer Part Number	355467-01
Configuration	Standard
Model	SRA-16(20x69]
Process Number	VR102601-30
Process Standard	

2. Setup

2.1 Technician

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

2.2 Tools

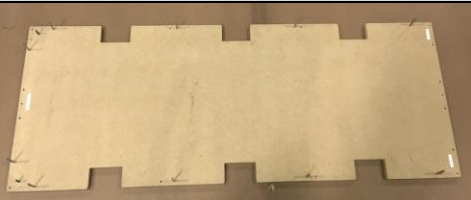

2.2.1 Calibrated Tools

Number	Tool	Description	Rev	Specification	Calibration Requirements	Image

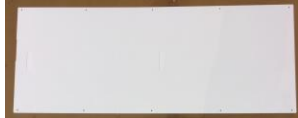

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2.2.2 Non-Calibrated Tools

Number	Tool	Type	Reference	Image
1	Assembly Fixture	MDF fixture	Fixture needed to align the ABS and HDPE panels.	
2	J-Roller for Plastic Laminate	J-Roller	3 in J-Roller for up to 25PSI	

2.3 Materials

#	VR Part Number	Mfg Part #	Manuf	Description	Qty	Requires Serial #	Size	Tolerance	COC Req	Lot Req	Incoming QA Req	Image
1	VR102683	See BOM	See BOM	1/8" ABS Top Side	1	N	See Engineering Drawing	See Engineering Drawing	Y	Y	Y	
2	VR102681	See BOM	See BOM	3/8" HDPE – Front Side	1	N	See Engineering Drawing	See Engineering Drawing	Y	Y	Y	

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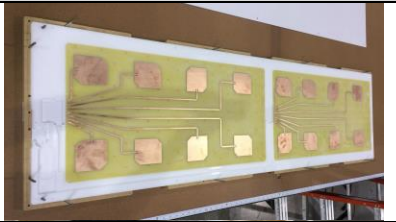

2.4 References

Number	VR Doc Number	Rev	Description	Manuf	Description	Directory
1						

2.5 Safety

Number	Type	Description	Reference

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Procedure

Step	Tech	Tool	Material	Tasks description	Reference Drawing	Image
	1	NC-1	M-2	Place and align the HDPE panel on top of the assembly fixture. The glued side should be facing up and the board side towards the bottom of the fixture.		
	2	NC-1	M-1	Once the ABS panel is ready for assembly, with the help of another person, carefully align the panel on top of the HDPE panel, starting from the board side and making your way up, applying even pressure while the glued faces get in contact with each other.		
	1	NC-1, NC-2	M-1-M-2	Use the hand the roller to bind both panels, applying even pressure throughout the HDPE panel.		

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4.0 Process Recording

Step	Tasks description	Reference Drawing / Image

5.0 Non Compliance

#	Non Compliance	Disposition	Reference Drawing / Image