

# VR – Process 27

# 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 | <b>Place Panels into Assembly fixture</b> |
|-------------|---|

|                      |               |
|----------------------|---------------|
| VR Part Number       | VR1           |
| Customer Part Number | 355467-01     |
| Configuration        | Standard      |
| Model                | SRA-16(20x69] |
| Process Number       | VR102601-27   |
| Process Standard     |               |

## 2. Setup

### 2.1 Technician

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

### 2.2 Tools

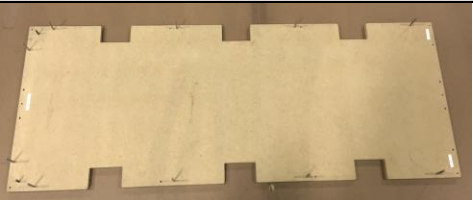

#### 2.2.1 Calibrated Tools

| 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 | VR102684       | See BOM    | See BOM | 1/16" ABS Bottom 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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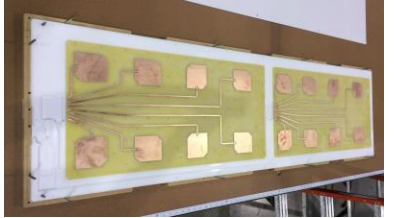
**2.4 References**

| 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-1      | Place and align the ABS 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-2      | Once the HDPE panel is ready for assembly, with the help of another person, carefully align the panel on top of the ABS 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 |
|---|----------------|-------------|---------------------------|
|   |                |             |                           |