

VR102601 – Process 012
Revision History

Attach M6e module

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

Approvals

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

1.0 Process Description

Description	Attach M6e Module
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VR Part Number	VR102601
Customer Part Number	355467-01
Configuration	Standard
Model	SRA-16(20x69]
Process Number	VR102601-012
Process Standard	1 Minutes



2. Setup

2.1 Technician

Tech #	Certification Required	Skill	Process	Safety
1	ESD S20.20-2014 Training	ESD training	Mechanical Assembly	ESD protection

2.2 Tools


2.2.1 Calibrated Tools

Number	Tool	Description	Rev	Specification	Calibration Requirements	Image
1	None					

2.2.2 Non-Calibrated Tools

Number	Tool	Type	Reference	Image
1	None			

2.3 Materials

#	VR Part Number	Mfg Part #	Manuf	Description	Qty	Requires Serial #	Size	Tolerance	COC Req	Lot Req	Incoming QA Req	Image
1	VR102663	5407A-MERCURY 6EA	Thing Magic	Thing Magic GEN 2 Reader w/ Tape Applied from process 011	1	Y	2 3/4" x 1 10/16"		Y	Y	Y	

2.4 References

Number	VR Doc Number	Rev	Description	Manuf	Description	Directory
1			None Required			

2.5 Safety

Number	Type	Description	Reference
1	Scissor Usage	Scissors need to be used per their intended usage	OSHA

3.0 Procedure

Step	Tech	Tool	Material	Tasks description	Reference Drawing	Image
1	1	NC-1	1 (tape)	Remove the tape backing to expose the adhesive on the tape. (Both Pieces)		
2	1	Hand	1	Place the M6ea reader in the cutout in the HDPE with the antenna ports facing up as shown in the picture		
3	1	Hand	None	Use hand pressure ONLY ON THE BLUE AREA OF THE Reader (do not press on the mmcx ports)		

4.0 Process Recording

Step	Tasks description	Reference Drawing / Image
1	Update the Traveler after completion of the M6e Reader.	
2	Record the selected Thing Magic Serial Number on the traveler	

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5.0 Non Compliance

#	Non Compliance	Disposition	Reference Drawing / Image
1	Tape does not stick	Remove the thermal tape and cut and re-apply the tape per process 011 and process 012	