

## VR – Process 29

**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

<b>Description</b>	Pass HDPE Panel Through Heat Process Air Dry the Top ABS Panel
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<b>VR Part Number</b>	VR102601
<b>Customer Part Number</b>	355467-01
<b>Configuration</b>	Standard
<b>Model</b>	SRA-16(20x69]
<b>Process Number</b>	VR102601-29
<b>Process Standard</b>	

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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

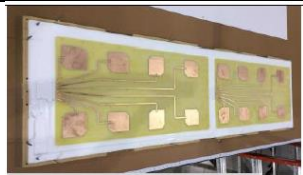
Number	Tool	Description	Rev	Specification	Calibration Requirements	Image

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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	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 come out of the other side.		
2	1	NC-1	M-2	Repeat step 2 to fully heat dry the adhesive.		

### 4.0 Process Recording

Step	Tasks description	Reference Drawing / Image

### 5.0 Non-Compliance

#	Non Compliance	Disposition	Reference Drawing / Image