

VR – Process 31

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 | | | | | | | | | | | |

1.0 Process Description

| | |
|-------------|--|
| Description | Pass Panel Through Pressing Process |
|-------------|--|

| | |
|----------------------|---------------|
| VR Part Number | VR1 |
| Customer Part Number | 355467-01 |
| Configuration | Standard |
| Model | SRA-16(20x69] |
| Process Number | VR102601-31 |
| Process Standard | |



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 |
|--------|---------------------------|---|-----|---------------------------------|---|--|
| 1 | Roller Press Force Sensor | Force Sensor Used to Validate Pressure force. | 1 | Force cannot be lower than 250N | To be checked against calibrated 10lb weight. |   |

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| | | | | | | |
|---|----------------------------|---|--|------------------------------|---|---|
| 2 | Roller Press Tachometer | Tachometer used to verify conveyor speed | | Speed controlled at 11RPM | Calibrated oscilloscope need to be used to check tachometer output pulses. |  |
|---|----------------------------|---|--|------------------------------|---|---|


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2.2.2 Non-Calibrated Tools

| Number | Tool | Type | Reference | Image |
|--------|----------------|----------------------|--|---|
| 1 | Pressure Gauge | Pressure Gauge Valve | Gauge used to confirm roller press pressure. Need to be set to 30PSI. |  |

2.3 Materials

| # | VR Part Number | Mfg Part # | Manuf | Description | Qty | Requires Serial # | Size | Tolerance | COC Req | Lot Req | Incoming QA Req | Image |
|---|----------------|------------|---------|------------------------------|-----|-------------------|-------------------------|-------------------------|---------|---------|-----------------|--|
| 1 | VR102601 | See BOM | See BOM | Bottom ABS, HDPE and Top ABS | 1 | N | See Engineering Drawing | See Engineering Drawing | Y | Y | Y |  |



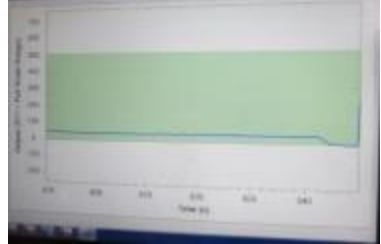
2.4 References

| Number | VR Doc Number | Rev | Description | Manuf | Description | Directory |
|--------|---------------|-----|-------------|-------|-------------|-----------|
| 1 | | | | | | |

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2.5 Safety

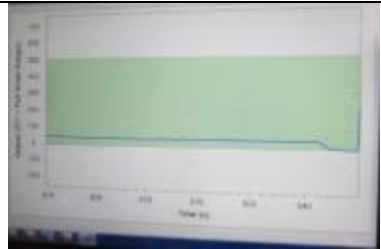

| Number | Type | Description | Reference |
|--------|-------------------------------------|---|----------------------|
| 1 | Safety Power Cut Off Training | All personnel working with or around gluing area need to be able to use safety power cutoff switch. | VR Internal training |

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Procedure

| Step | Tech | Tool | Material | Tasks description | Reference Drawing | Image |
|------|------|------|----------|--|-------------------|---|
| | 1 | | M-1 | Place antenna assembly panel on top of conveyor with the bottom ABS side facing up. | |  |
| | 1 | | M-2 | Slide the shelf all the way inside the chamber without applying too much pressure. Once the roller starts to turn, wait for the speed to reach 11RPM. | |  |
| | 1 | | | Once the speed is at 11RMP push the shelf in and watch the tablet screen for changes on the graph. The marker should be above 250N until the shelf comes out the other side. | |  |

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| | | | | | | |
|--|---|--|--|---|--|---|
| | 1 | | | <p>If the graph is below the 250N mark, pass the shelf one more time with the same side facing up.</p> | |  |
| | 1 | | | <p>Once the bottom ABS side has pass the above process, flip the shelf (bottom ABS side facing DOWN) and run the same process. Always checking the tables screen for changes in the force value.</p> | |  |

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4.0 Process Recording

| Step | Tasks description | Reference Drawing / Image |
|------|-------------------|---------------------------|
| | | |

5.0 Non Compliance

| # | Non Compliance | Disposition | Reference Drawing / Image |
|---|----------------|-------------|---------------------------|
| | | | |