



**VR – Process 25**  
**Revision History**

Apply Glue to HDPE and 1/16 ABS

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**

<b>Description</b>	<b>Apply Glue to HDPE Bottom and Bottom ABS</b>
--------------------	---

<b>VR Part Number</b>	VR1
<b>Customer Part Number</b>	355467-01
<b>Configuration</b>	Standard
<b>Model</b>	SRA-16(20x69]
<b>Process Number</b>	VR102601-25
<b>Process Standard</b>	

VR – Process 25

## 2. Setup

### 2.1 Technician

Tech #	Certification Required	Skill	Process	Safety
1	No	Adhesive applicator	Yes	Yes

### 2.2 Tools




#### 2.2.1 Calibrated Tools

Number	Tool	Description	Rev	Specification	Calibration Requirements	Image

VR – Process 25



Apply Glue to HDPE and 1/16 ABS

2.2.2 Non-Calibrated Tools




Number	Tool	Description	Rev	Specification	Requirements	Image
1	Compressor Pressure Gauge	Pressure gauge used to control pressure inside Air Agitated Pressure Tank	1	Pressure controlled at 70PSI	Check pressure every time production starts	
2	Teflon Coated Spray Gun	Spray gun used to add adhesive to ABS and HDPE	1	Adhesive Gun Spray Fluid Flow Measurement	Adhesive Gun Spray Fluid Flow Measurement (Pressurize fluid source only; pull trigger, flow material into measuring device for 60 seconds, increase or decrease fluid source pressure to obtain desired fluid flow.)	
3	Air Agitated Pressure Tank	5 Gallon Pressure Pot, Steel Teflon Coated, 29x 18 x 16 (51-504)	1	Adhesive pressure controlled at 70PSI	Check pressure every time production starts. Maximum pressure allowed is 80PSi	

VR – Process 25

Apply Glue to HDPE and 1/16 ABS




4	Adhesive Gun Spray Air Compressor	Air compressor for adhesive application	1	Min 5HP and 17CFM	Check if compressor is running and full of air every time production starts	
5	Hose Set	Hose set for adhesive and air application	1	Set 25', 16 CFM, 5/16" air and 3/8" fluid. AFS-1142	Hoses need to be attached to the agitator tank.	

**2.3 Materials**

#	VR Part Number	Mfg Part #	Manuf	Description	Qty	Requires Serial #	Size	Tolerance	COC Req	Lot Req	Incoming QA Req	Image
1	VR102656	3M - 4693	3M	High performance 3M Adhesive	1	N	See BOM	N/A	Y	Y	N	
2	VR102684	See BOM	See BOM	1/16" ABS Bottom Side	1	N	See Drawing	See Drawing	Y	Y	Y	
3	VR102682	See BOM	See BOM	3/8" HDPE – Back Side	1	N	See Drawing	See Drawing	Y	Y	Y	

VR – Process 25

Apply Glue to HDPE and 1/16 ABS

4	VR102694	3125	Pure Tronics	Isopropyl Alcohol	1	N	N/A	N/A	N	N	N	
5	VR102695	02120 0- 21429		3M Scotch Weld No.2 Solvent	1	N	N/A	N/A	N	N	N	
6	VR102696	S- 13631 BLU	Uline	Heavy-Duty Wipers or Micro Fiber Towels	1	N	N/A	N/A	N	N	N	

## VR – Process 25

## Apply Glue to HDPE and 1/16 ABS


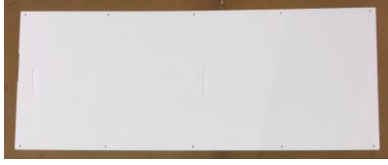
### 2.4 References

Number	VR Doc Number	Rev	Description	Manuf	Description

### 2.5 Safety

Number	Type	Description	Reference
1	Ventilation	Area needs to be well ventilated where adhesive is to be applied	Refer to MSDS
2	Dust Masks or Respirators	Use of respirator while applying adhesive is obligatory	Refer to MSDS

### 3.0 Procedure

Step	Tech	Tool	Material	Tasks description	Reference Drawing	Image
1	1		M-2, M-3, M-4, M-5, M-6	Surface Preparation (Surfaces must be dry and free of dust, dirt, grease, oil, mold release materials or other contaminants. For best results, temperature of adhesive should be at least 65°F (18°C).		
	1	NC-2	M-1, M-2	Apply even coat of adhesive to HDPE bottom (aluminum side), starting from the board side and making your way up, left to right, covering the area where the panel surfaces will be in contact with the ABS panel.		
	1	NC-2	M-1, M-2	Apply even coat of adhesive to the back of the 1/16 bottom ABS panel, starting from the mux board side and making your way up, left to right, covering the entire back of the panel		

### 4.0 Process Recording

Step	Tasks description	Reference Drawing / Image
1		

### 4.0 Non Compliance

VR – Process 25

Apply Glue to HDPE and 1/16 ABS

#	Non Compliance	Disposition	Reference Drawing / Image