

VR – Process 29
 Process
Revision History

Pass Panel Through Heat

Date / Time	Rev	Author	Description
8/26/2017	A	FS	Original Version
10/2/2017	B	FS	Process image added

Approvals

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

1.0 Process Description

Description	Pass HDPE and Top ABS Panel Through Heat Process
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VR Part Number	VR1
Customer Part Number	355467-01
Configuration	Standard
Model	SRA-16(20x69]
Process Number	VR102601-29

Process Standard	
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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
1	Heat Chamber Temp Sensor	Temp Sensors used to verify the temperature of each lamp inside the heat chamber.	1	Temperature should be between 200 and 230 degrees Celsius.	To be checked every year against a calibrated temperature controlled chamber.	

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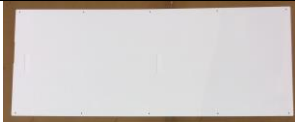

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2	Heat Chamber Tachometer	Tachometer used to verify conveyor speed		Speed controlled between 5 and 6 RPM	Calibrated oscilloscope needs to be used to check tachometer output pulses.	
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2.2.2 Non-Calibrated Tools

Number	Tool	Description	Rev	Specification	Requirements	Image
1	Heat Lamp	1500W infrared Heat Lamp	1	3x Heat Lamp of 1500W	3x Heat Lamp of 1500W	
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	VR102683	See BOM	See BOM	1/8" ABS – Top 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	

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
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Procedure

Step	Tech	Tool	Material	Tasks description	Reference Drawing	Image
	1	NC-1	M-1	Place ABS panel on top of conveyor. The glued side should be facing up and the board side towards the heat chamber.		
	1	NC-1	M-2	Once the ABS panel is out of the other side you can safely place the HDPE panel on top of conveyor, glue facing up and board side towards heat chamber. Wait for it com come out of the other side.		
	1	NC-1	M-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