

VR102601 – Process 011  
**Revision History**

Attach Thermal Tape on M6e

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	<b>Attach Thermal Tape to M6e</b>
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VR Part Number	VR102601
Customer Part Number	355467-01
Configuration	Standard
Model	SRA-16(20x69]
Process Number	VR102601-011
Process Standard	2 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	Scissors			

2.3 Materials

#	VR Part Number	Mfg Part #	Manuf	Description	Qty	Requires Serial #	Size	Tolerance	COC Req	Lot Req	Incoming QA Req	Image
1	VR000230	½-5-8810	3M	Thermal Backing Tape	1	N	6"	N/A	N	N	N	
2	VR102663	M6ea	Thing Magic	Thing Magic GEN 2 Reader	1	Y	2 ¾" 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	Cut the tape into 2 sections of 2 10/16" (70 mm)		
2	1	Hand	1 and 2	Remove the backing of one side of the tape and place one piece of the tape on each edge of the Thing Magic Module. Leave the top backing of the tape on for the next step		

### 4.0 Process Recording

Step	Tasks description	Reference Drawing / Image
1	Update the Traveler after completion of the addition of the tape being installed	
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 the processes above	