

**Manufacturing
Procedure**

Procedure #:

MFG008 Rev. A

Date:

05/28/99

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Title:

First Mechanical

Revision

A

Description of Change

Initial Release

Date Effective

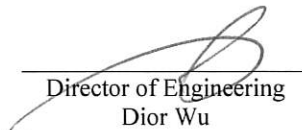
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Title:

First Mechanical**1.0 Purpose**

- 1.1 The purpose of this document is to document the first mechanical process.

2.0 Scope

- 2.1 The procedure covers all of the hardware assembly prior to hand load after manual-insertion at Meritronics.

3.0 Reference

- 3.1 SOP22 ESD procedure
3.2 SOP11 First Article Procedure
3.3 IPC-A-610 Acceptability of Electronic Assemblies

4.0 Definitions

- 4.1 PCA: Printed Circuit Assembly
4.2 TEK-MATE Lineboard: Paper board with conductive foams attached to it.

5.0 Responsibilities

- 5.1 It is everybody's responsibility to follow the ESD and safety rules described in this procedure.
5.2 Operators are responsible for following the documentation to ensure quality product.
5.3 The area supervisor in the area shall follow SOP11-First Article and will assist operators as necessary.

6.0 Equipment

- 6.1 Lineboard
6.2 Carrying Cart
6.3 Electrical / Manual screw driver
6.4 Appropriate power / non-power bits
6.5 Tilt Racks

7.0 Materials

- 7.1 PCAs
7.2 Visual aids or proper customer documentation.

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7.3 Components including connectors, screws, washers, nuts, etc.

8.0 Records

8.1 N/A

9.0 Procedure

9.1 Safety

9.1.1 To prevent electrical shock, do not open the case on electrical screw drivers or transformer.

9.2 Get MPI documentation detailing instructions for First Mechanical where appropriate.

9.3 Set-up screw drivers following MPI or customer instructions.

9.4 Hand assemble screws, nuts, components, or bolts per visual aids or customer documents to ensure proper fit before tightening. Verify the part numbers and direction of installation.

9.5 Tighten the hardware per MPI or customer requirements.

9.6 Replace screw/ bolt if the thread or head is damaged.

9.7 Check and ensure the proper alignment requirements if any.

9.8 Load the board directly on Lineboard if no masking required and enough carrying Carts are available. Otherwise, stage them on tilt racks and pass on to next station.