

Assembly Instruction	Doc Number	Step	Step Name	Takt time	Notes
Ballot Box	VWX-001-D012	1	Fabric Bin Install	0:25:00	
		2	Trolley Handle Install	0:02:45	
		3	Deck Install	0:01:35	
		4	Door Hinge Cover	0:05:00	did not take into account door hinge patch for LP3
		5	Nameplate Install	0:02:00	
Frame	VWX-001-D013	1	Install Scissor Link Assemblies	0:05:00	
		2	Install Floor Assembly	0:03:20	
Deck	VWX-001-D014	1	Install Deck Latch Slider	0:05:00	
		2	Glue Deck	0:00:00	ignore as 2 piece machined deck only for LP3
		3	Attach Deck Latch Handle and Cove	0:01:30	
		4	Install Deck Ballot Trap	0:00:25	
		5	Install Storage Straps	0:01:35	
		6	Install MCM Plate	0:03:35	
Scissor Link	VWX-001-D015	1	Assemble Scissor Link	0:01:00	0.5 min each
Rear Frame	VWX-001-D016	1	Molded torque inserts	0:02:30	
		2	Static Scissor Slides	0:01:20	
		3	Deck Alignment Bumpers	0:00:40	
		4	Vertical Rear Tubes	0:01:00	
		5	Mobile Scisor Slides	0:00:10	
		6	Bottom Tube	0:01:40	
		7	Trolley Handle Plate	0:01:30	
		8	Deck Links	0:20:00	
		9	Wheels	0:01:40	
		10	Tube Feet	0:00:30	
		11	Scissor Slide Hole Plugs	0:00:40	
Front Frame	VWX-001-D017	1	Strike Plate	0:00:45	
		2	Deck Locating Pin	0:00:20	
		3	Static Scissor Slides	0:01:20	
		4	T-Hook Catches	0:03:00	
		5	Mobile Scisor Slides	0:00:10	
		6	Bottom Tube	0:01:00	

		7	Tube Feet	0:00:30	
		8	Scissor Slide Hole Plugs	0:00:40	
Floor	VWX-001-D018	1	Install Rubber Feet	0:06:00	
		2	Install Toe Kick		
		3	Final Assembly		
Storage Strap	VWX-001-D019	1	Fabricate Storage Strap	00:10:00	5 min each
Tube Nut	VWX-001-D020	1	Bottom Tube Assys	00:02:00	0.5 min each side x 2 assys
		2	Vertical Tube Assys	00:03:00	0.5 min each side x 3 assys
E-Ballot Bin	VWX-001-D021	1	Latch Baseplate	00:02:35	
		2	Latch Handle		
		3	Hinge Tube		
Door Latch	VWX-001-D022	1	Install Bearings	00:02:30	
		2	Install Handle		
		3	Install Latch Hooks		
Door	VWX-001-D023	1	Install E-ballot bin	00:03:20	
		2	Drill Pin Plate Holes	00:06:00	
		3	Install Pin Plates	00:01:45	
		4	Install E-Ballot Cover	00:01:00	
		5	Install Ballot Trap	00:01:30	
		6	Install Door Latch	00:02:00	
		7	Install Locking Hasp	00:00:45	
		8	Install Loop	00:01:00	
Torque Insert	VWX-001-D024	1	Torque Insert Assy	00:00:00	ignore as this is only required for LP3
Total				2:20:35	