

SOP

Item No.:TC017L(SMT) Series
Procedure: Knob Dispensing

Doc No.: WB-WI-079

Version: A03

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Page: 15-1

Photos:



Photo 1

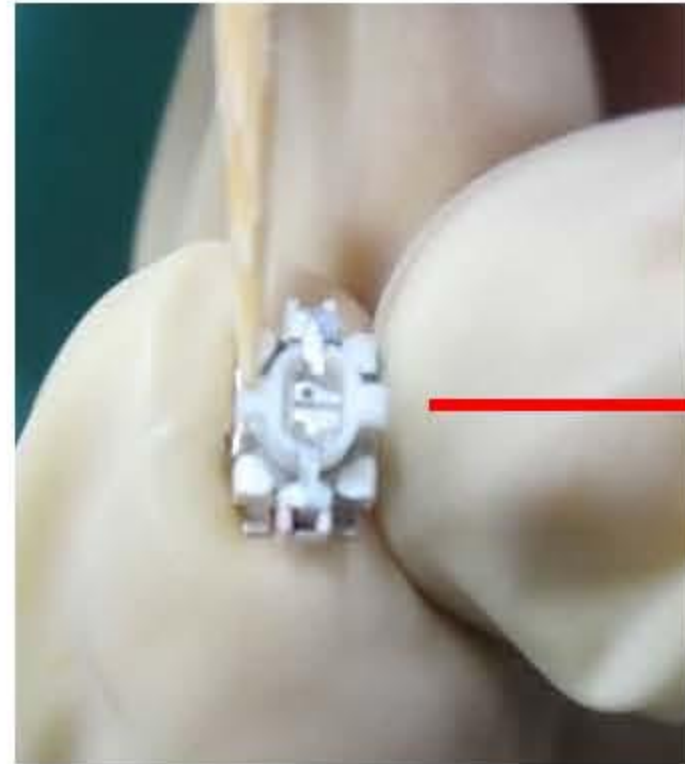


Photo 2

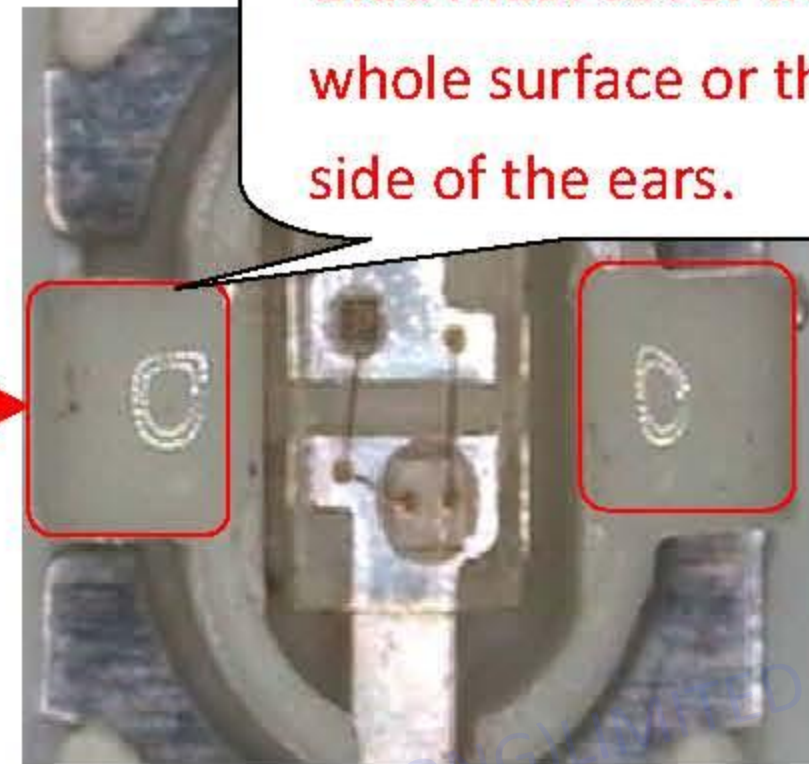


Photo 3 (OK)

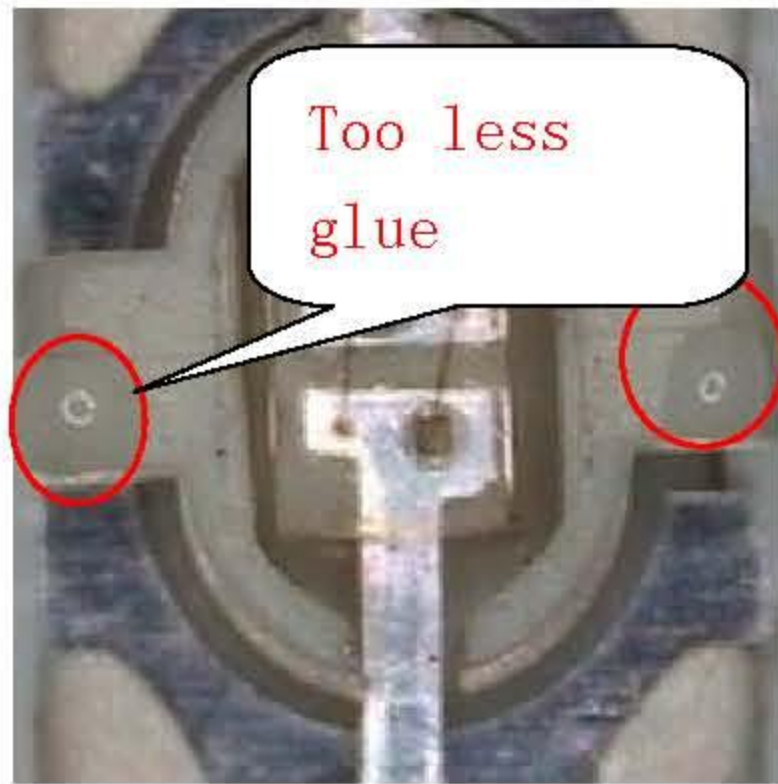


Photo 4 (NG)



Photo 5



Photo 6

Operating Steps:

1. Use a toothpick to take a proper amount of W-900K glue with right hand. Dispense the glue on the right and left ears of the actuator, the glue must cover the whole surface. (Photo 1-Photo 3)
2. Hold the knob with right hand and tilt the switch actuator. Point the knob at the click point of the actuator. Open one side of the knob slightly then put the knob onto the actuator. (Photo 5-Photo 6)
3. Put the finished-product switch on the baking tray and bake it for $120\pm 5^{\circ}\text{C}$ / $25\pm 5\text{min}$.
4. After baking, check the first article. Take 10-20PCS to do pull-off test with 300g MIN and document it in the first article report.
5. IPQC put the pull-off test in the IPQC list.

					Notice: 1. W-900K is easy to dry out, do not squeeze too much at one time. 2. Use proper amount of glue to cover the whole ear surface. Too less glue (Photo 4) is not allowed. 3. Do not put glue on the laser-carving side of the knob. Do not attach the knob incorrectly. (Refer to finished-product SOP.) No scratch and stain on the surface. Knob must be put on correctly without tilting. 4. Terminals must not be pressed by the hand holding the switch. 5. Workers must wear static finger gloves on the thumbs, index finger and middle on both hands. Wear static bracelet on the left hand.
Tool	Expenditure	Equipment	Material		
	Toothpicks、 finger gloves W-900K glue		Part No.	Material Name	Amount
			W-900K	Glue	Proper amount
Approved by	Audited by	Admitted by			
Hu Zhibin	Cai Wen	Yen Fongjun			

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