

Shenzhen KTC Technology Group
Shenzhen KTC Technology Co., Ltd.

Operation Instructions

Product Name: 49L71F

Prepared by: Liu Xiaojun

Examined by: _____

Approved by: _____

Date: 2015.5.16

Station name	take flat iron			Model	49L71F base	Serial/NO	Base process 01	Document NO	ITDV0601	Version	v4.0
								Effective date	2014/6/26	Update date	2014/6/26

NO	Material number	Amount	Discription	Working contents and requirements	Figure mark	Tool parameter
1	7130-50L61F-42120001	1	Hardware base/hardware support	take out flat iron from packing box, remote its protection bag, put it on working table	figure 1	
2			prevail with production order	check base, to see if there is any scratch, deform, paint loss or damage, put defective products in defective area.	figure 1	
3						
4						
5				after self check, products are ready for next step production.		

Notices	1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i>. 2. Make defective marks when defective materil occurs and make original package, pile up. 3. Operator should be familiar with material, make a strictly self checking in order to defective product flow to the next step		1
---------	---	--	--

picture:

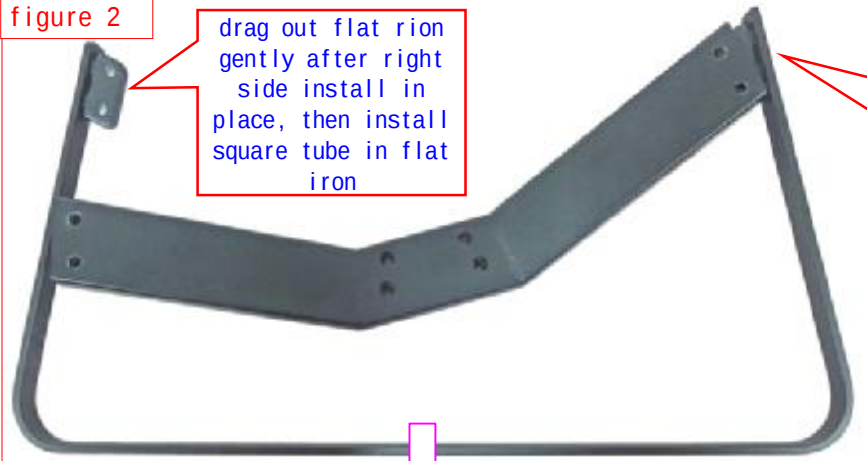
figure 1

Hardware base/hardware support

check appearance of flat iron, make sure there is no scratch, deformation or damage etc

Engineer Controlled Seal

Verify records		Please read and understand the operating instructions carefully	Prepared by	Verify	Approve
			Liu Xiaoju		

Station name	Support used for installing metal hollow base		Model	49L71F base	Serial/NO	Base process 02	Document NO	ITDV0602	Version	v4.0
							Effective date	2014/6/26	Update date	2014/6/26
NO	Material number	Amount	Discription		Working contents and requirements			Figure mark	Tool parameter	
1					take hollow base from last working station, put it on working table			figure 2		
2	7103-50L61F-4004U001	1	Die casting support		take metal hollow base, remote its package, check its appearance makes sure no scratch or damage etc			figure 1		
3										
4			prevail with production order		OK square support puting related to hollow base flat iron, install it on flat iron from right side first , then drag left side gently, lastly plug square tube.			figure 1/2		
5					after self check, products are ready for next step production.					
Notices	1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> .									
	2. Make defective marks when defective materil occurs and make original package, pile up.									
	3. Operator should be familiar with material, make a strictly self checking in order to defective product flow to the next step									
 figure 1 Die casting support check appearance of support, make sure there is no scatch, deformation or damage etc  figure 2 drag out flat rion gently after right side install in place, then install square tube in flat iron install this edge first.  										
Verify records					Please read and understand the operating instructions carefully		Prepared by	Verify	Approve	Engineer Controlled Seal
							Liu Xiaoju			

Station name	Fix Right Ottoman			Model	49L71F base	Serial/NO	Base process 03	Document NO	ITDV0603	Version	v4.0
								Effective date	2014/6/26	Update date	2014/6/26

NO	Material number	Amount	Discription	Working contents and requirements	Figure mark	Tool parameter
1				rotate base, bottom put on working table	figure 1	Electric driver
2	7912-223036-01801021	1	Black pad/adhesive tape	take righ ottoman *1PCS, thin side to base side,thick side inside put on base for postion.	figure 1	4±1kgfcm
3	7B11-050713-00105111	2	Φ5×7mm Screw	take Φ5×7mm Screw*2PCS, fix base ottoman to base.	figure 1 ▲	
4			prevail with production order	after self check, products are ready for next step production.		
5						

Notices

1. Wastes produced by this station shall be placed in the assigned position. Refer to *Waste Classification and Disposal List*.
2. Make defective marks when defective materil occurs and make original package, pile up.
3. Operator should be familiar with material, make a strictly self checking in order to defective product flow to the next step

3

picture:

figure 1

Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them everywhere.

Verify records

Please read and understand the operating instructions carefully

Take only one screw at a time

Prepared by

Liu Xiaoju

Verify

Approve

Engineer Controlled Seal

利用 pdfFactory Pro 测试版本创建的PDF文档 www.pdffactory.com

Station name	Fix Left Ottoman			Model	49L71F base	Serial/NO	Base process 04	Document NO	ITDV0604	Version	v4.0
								Effective date	2014/6/26	Update date	2014/6/26

NO	Material number	Amount	Discription	Working contents and requirements	Figure mark	Tool parameter
1	7912-223036-01801011	1	Black pad/adhesive tape	take left ottoman *1PCS, thin side to base side,thick side inside put on base for postion.	figure 1	Electric driver 4±1kgfcm
2	7B11-050713-00105111	2	Φ5×7mm Screw	take Φ5×7mm Screw*2PCS, fix base ottoman to base.	figure 1 ▲	
3			prevail with production order	after self check, products are ready for next step production.		
4						
5						

Notices	1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i>. 2. Make defective marks when defective materil occurs and make original package, pile up. 3. Operator should be familiar with material, make a strictly self checking in order to defective product flow to the next step	 4
---------	---	--

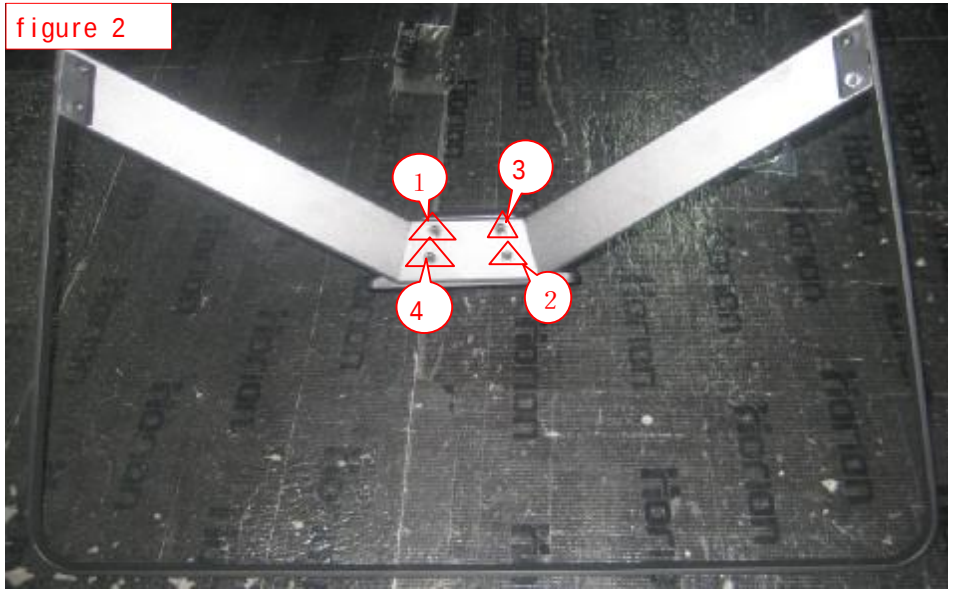
figure 1

Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them everywhere.

Verify records		Please read and understand the operating instructions carefully	Take only one screw at a time	Prepared by	Verify	Approve
				Liu Xiaoju		

Engineer Controlled Seal

Station name	Fix Support		Model	49L71F base	Serial/NO	Base process 05	Document NO	ITDV0605	Version	v4.0
							Effective date	2014/6/26	Update date	2014/6/26
NO	Material number	Amount	Discription		Working contents and requirements			Figure mark	Tool parameter	
1	7037-50L61F-4U701111	1	Base support		take support to check it's appearance, and them put it on base.			figure 1	Electric driver	
2	7B11-041013-00105411	4	Φ4×(10+8)mm Screw		take Φ4×(10+8)mm H head blac zinc plated machine screw *4PCS, fix on base			figure 2	5±1kgfcm	
3			prevail with production order		after self check, products are ready for next step production.					
4										
Notices 1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> . 2. Make defective marks when defective materil occurs and make original package, pile up. 3. Operator should be familiar with material, make a strictly self checking in order to defective product flow to the next step									5	
figure 1						figure 2				
Process Requirements: 1. Check for rusted screws, missing slots or bad cross slot. 2. Check if the electric screwdriver torque force is within the specified requirements. 3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt). 4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw. 5. Put the defective screws in the defective product box and do not throw them everywhere.										
Verify records			Please read and understand the operating instructions carefully		Take only one screw at a time		Prepared by	Verify	Approve	Engineer Controlled Seal
							Liu Xiaoju			

Station name	QC Base Check			Model	49L71F base	Serial/NO	Base process 06	Document NO	ITDV0606	Version	v4.0
								Effective date	2014/6/26	Update date	2014/6/26
NO	Material number	Amount	Discription	Working contents and requirements					Figure mark	Tool parameter	
1				check appearance of base, make sure ther is no scratch or damage					physical drawing		
2				check ottoman stick postion, make sure there is no missing or defective sticking.							
3				put OK base on level glass to check its appearance, press with hands.						Level glass	
4				to make sure there is no tilt, or other defectiveness. If there is any defective							
5				products, put it in defective area.							
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to <i>Waste Classification and Disposal List</i> . 2.Make defective marks when defective materil occurs and make original package, pile up. 3.Please make sure level table steadily before operation, four feet should touch ground.									
picture: figure 1  Check the base should be smooth, no tilt / inequality undesirable phenomena											
Verify records				Please read and understand the operating instructions carefully			Prepared by	Verify	Approve	Engineer Controlled Seal	
							Liu Xiaoju				

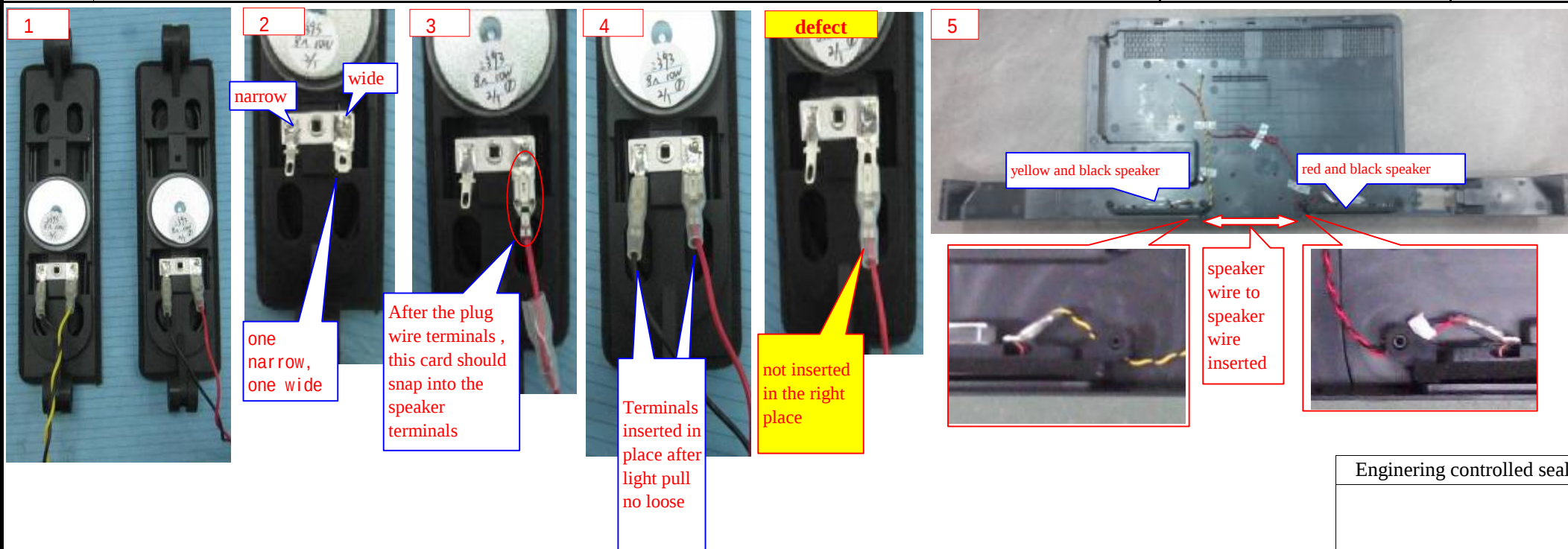
Station name	Back Cover Processing-Taking Back Cover			Model	49L71F	Series/NO.	Pre process 01	Document NO.	ITA460101	Version	v5.0
				Program	T8 V59	Working hrs	25S	Effective date	2014/9/15	Update date	2014/9/15
NO	Material number	Amount	Description	Working contents and requirements					Mark figure	Tool parameter	
1	7002-49L71F-04B00021	1	Plastic back cover	take back cover from box, remove its packing,check its appearance to make sure it is OK. If there is any defective ones, put them in defective box.					figure 1		
2											
3			actual material number prevails with production order.	flow module to the next station with back cover inside up on working table.							
4											
5											
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List. 2.Back cover appearance should be well without scratch, color difference, color missing, deformation or damage.								1	
1 											
Modify records				Please read and understand the operating instructions carefully				Prepare	Verify	Approve	Engineering controlled seal
								Liu Xiaoju	徐晓娟	胡军	

Station name	Back Cover Processing-Speaker Installation		Model	49L71F	Series/NO.	Pre process 02	Document NO.	ITA460102	Version	v5.0
			Program	T8 V59	Working hrs	25S	Effective date	2014/9/15	Update date	2014/9/15
NO	Material number	Amount	Description		Working contents and requirements				Mark figure	Tool parameter
1	7711-22858A-50000011	2	8Ω 10W speaker		take two speaker, put them on table , check its wire connectin with one narrow, one width without oxide.				figure 1/2	
2	6149-650045-03101101	1	650mm 3pin speaker wire		take 1 red and black speaker wire, red wire to "+"(wide receiving piece),black wire inserted on "-" terminal (narrow wire receiving piece).				figure 3/4	
3	6149-300045-02101201	1	300mm 2Pin speaker wire		take yellow and black speakre wire inserted method as above .				figure 3/4	
4					after inserting OK, drag gently to make sure there is no loose.				figure 4	
5					put module to next station for processing after self check ok.				figure 5	
6										

- Notices
1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.
 2. Wire connecting wire should be inserted in receiving piece rightly.



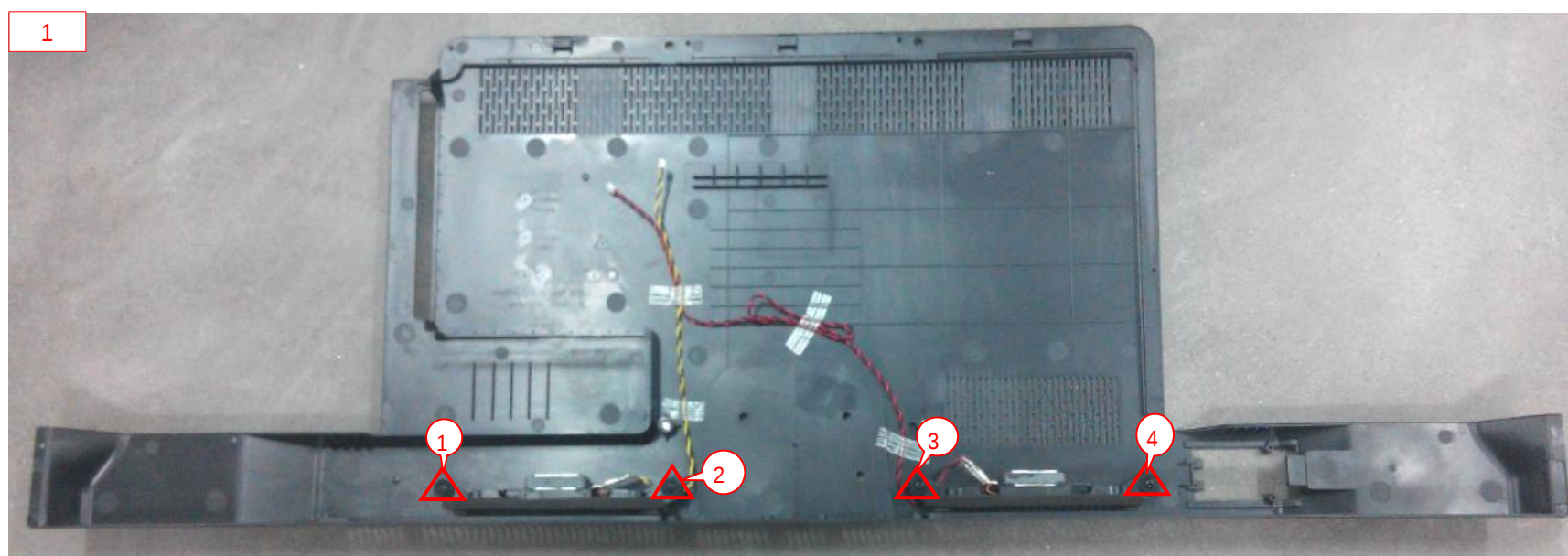
2



Engineering controlled seal

Modify records	Please read and understand the operating instructions carefully	Prepare	Verify	Approve
		Liu Xiaojun	徐小军	胡军

Station name		Back Cover Processing- Locking Speaker		Model	49L71F	Series/NO.	Pre process 03	Document NO.	ITA460103	Version	v5.0
				Program	T8 V59	Working hrs	25S	Effective date	2014/9/15	Update date	2014/9/15
NO	Material number	Amount	Description	Working contents and requirements					Mark figure	Tool parameter	
1	7B11-041082-30105113	4	Φ4×10mm Screw actual material number prevails with production order.	take Φ4×10mm round head flat gasket (Φ14-Φ15)*4PCS, to lock speaker on back cover according to 1-4.					figure 1 	electric driver 6±1kgfcm	
2				put module to next station for processing after self check ok.							
3											
4											
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.									
		2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.									



Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them everywhere.

Engineering controlled seal

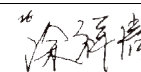
Modify records

Please read and understand the operating instructions carefully

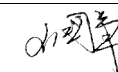
Prepare

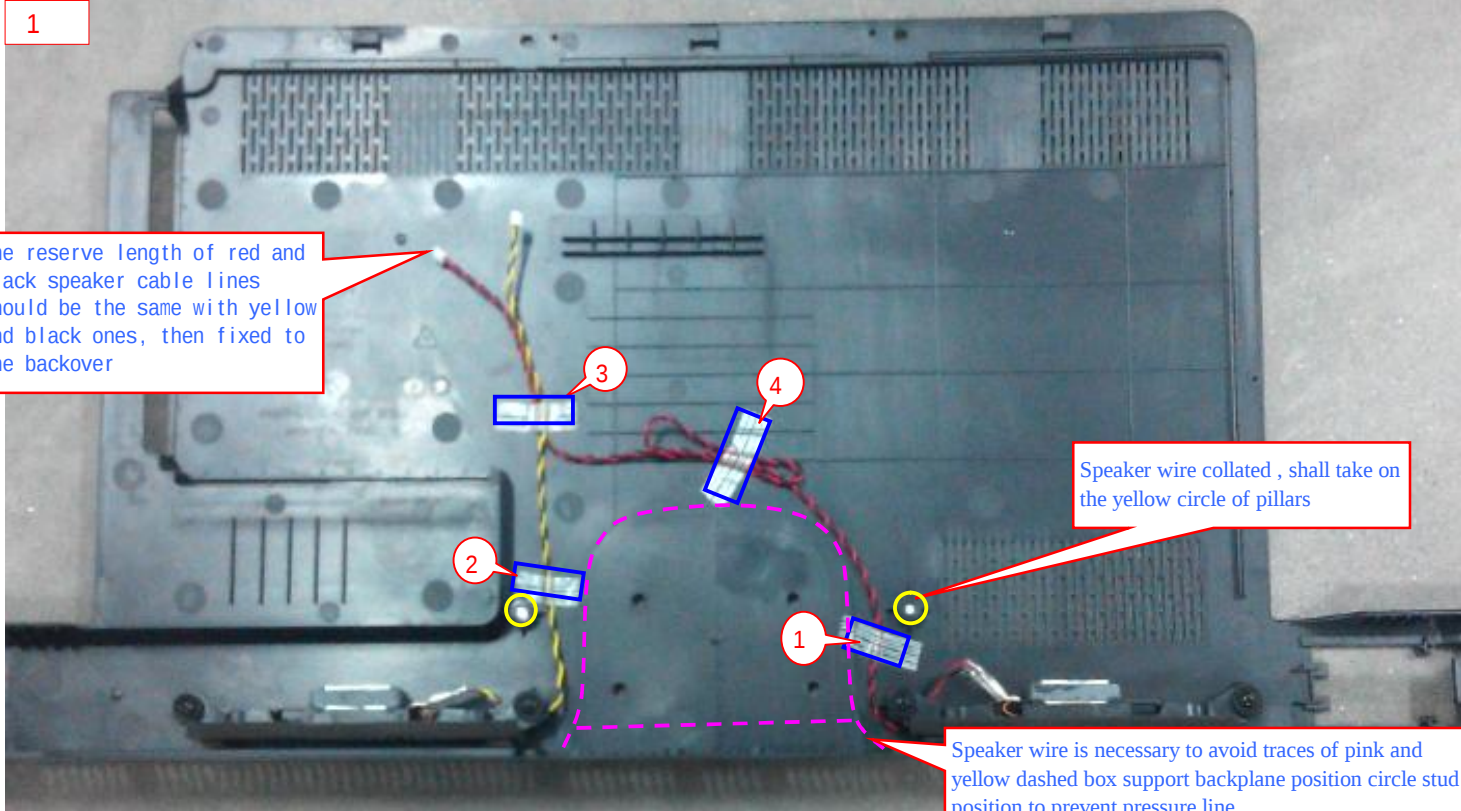
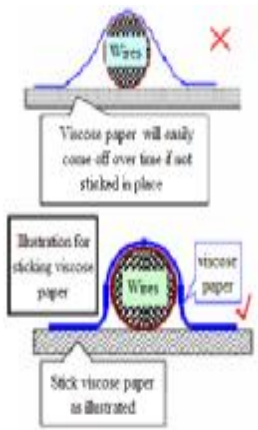
Liu Xiaojun

Verify



Approve



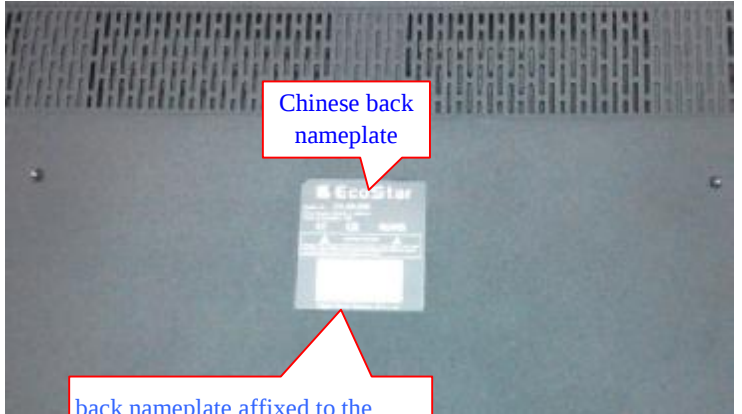
Station name	Back Cover Processing- Fixing Speaker Wire			Model	49L71F	Series/NO.	Pre process 04	Document NO.	ITA460104	Version	v5.0
				Program	T8 V59	Working hrs	25S	Effective date	2014/9/15	Update date	2014/9/15
NO	Material number	Amount	Description	Working contents and requirements						Mark figure	Tool parameter
1	7912-713050-015R1311	4	viscose papwer (length: 50mm)	cut 4 viscose paper with length of 50mm to lock speaker module wire on back cover.						figure 1 	tape machine
2											
3				put module to next station for processing after self check ok.							
4											
Notices				1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.							
				2. Viscose paper should be sticked in to "Ω" shape, it should be tight, flat, can not tilt.							
				3. Pay attention to self check and recheck to avoid any defective product flow to the next station. .							
 the reserve length of red and black speaker cable lines should be the same with yellow and black ones, then fixed to the backover Speaker wire collated, shall take on the yellow circle of pillars Speaker wire is necessary to avoid traces of pink and yellow dashed box support backplane position circle stud position to prevent pressure line 											
Modify records				Please read and understand the operating instructions carefully				Prepare	Verify	Approve	
								Liu Xiaoju			

Engineering controlled seal

Station name	Back Cover Processing- Sticking Sticy Film		Model	49L71F	Series/NO.	Pre process 05	Document NO.	ITA460105	Version	v5.0
Program			T8 V59	Working hrs	25S	Effective date	2014/9/15	Update date	2014/9/15	
NO	Material number	Amount	Description		Working contents and requirements				Mark figure	Tool parameter
1	7372-49L71F-22022211	1	Interface adhesive film		take 1PC main board side interface film, stick it on back cover main board side interface film slot.				figure 1 	
2	7372-49L71F-12022211	1	Interface adhesive film		take 1PC main board lower sticky film, stick it on back cover main board lower interface sticky film slot.				figure 1 	
3			actul material number prevails with production order.							
4					back cover back side up flowled to next station after self checking ok.					
5										
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.								
		2. Notice that label should be aligned with reference object, there should not be bubble or damage after sticking.								



Modify records		Please read and understand the operating instructions carefully	Prepare	Verify	Approve	Engineering controlled seal
			Liu Xiaojun			

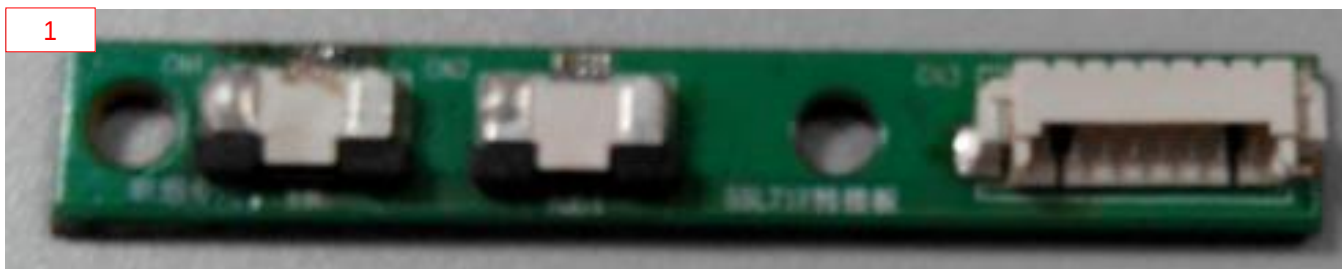
Station name	Back Cover Processing- Sticking Back Nameplate			Model	49L71F	Series/NO.	Pre process 06	Document NO.	ITA460106	Version	v5.0
				Program	T8 V59	Working hrs	25S	Effective date	2014/9/15	Update date	2014/9/15
NO	Material number	Amount	Description	Working contents and requirements					Mark figure	Tool parameter	
1	7371-49L71F-02ESA211	1	Rear nameplate	take 1PC back nameplate, check to be consistent with order module, stick it in back cover slot.					figure 1		
2											
3			actual material number prevails with production order.	put operation finished back cover on stack for production use.							
4											
5											
Notices 1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List. 2. Notice that label should be aligned with reference object, there should not be bubble or damage after sticking.  6											
1  back nameplate affixed to the inside after recess after the shell , and are to be posted , help level , press firmly .  Chinese back nameplate back nameplate affixed to the inner enclosure in the middle groove and push fastening not exceed rim and Alice feet											
										Engineering controlled seal	
Modify records					Please read and understand the operating instructions carefully		Prepare	Verify	Approve		
							Liu Xiaojun	徐晓军	刘小军		

Station name		Power Wire Processing		Model	49L71F	Series/NO.	Pre process 07	Document NO.	ITA460107	Version	v5.0	
				Program	T8 V59	Working hrs	25S	Effective date	2014/9/15	Update date	2014/9/15	
NO	Material number	Amount	Description			Working contents and requirements				Mark figure	Tool parameter	
1	6264-250008-13210001	1	TV-5 8/128A 250VAC 4pin switch			insert 2pin red and black power wire and 250V power wire on rocker switch as figure.				figure 1/2		
2	6110-151632-08462201	1	1.5M+0.16M POWER CORD			put finished power wire in circulation box in order, each layer uses a foil sheet.				figure 3		
3	6149-250056-02V31201	1	250mm 2pin wire			to separate, on box can not be over 4 layers.						
						put full circulation box in regulated place waiting for line production after self check OK.						
4												
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.									7	
		2.When putting module in circulation box, put them in order, do not mess up.										



Modify records		Please read and understand the operating instructions carefully	Prepare	Verify	Approve	Engineering controlled seal
			Liu Xiaojun	徐晓军	刘小军	

Station name		Remote Control Interface Module Processing		Model	49L71F	Series/NO.	Pre process 08	Document NO.	ITA460108	Version	v5.0
				Program	T8 V59	Working hrs	15S	Effective date	2014/9/15	Update date	2014/9/15
NO	Material number	Amount	Description	Working contents and requirements					Mark figure	Tool parameter	
1	9019-112L71-00004011	1	Switch plate	take L71F model remote control interface board module, make sure the appearance is OK, put good ones on working table with foil side up.					figure 1		
2	7912-522055-0080R111	1	Black pad/adhesive tape	take interface board mylar film, remove back side protection paper, then sticky it on interface board foil side , screw to screw, do not bevel.					figure 2		
3			actual material number prevails with production order.	put process finished interface board on static tray plate after self check OK.							
4											
5											
Notices	1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.										
	2. Wear static ring and static gloves during operation.										

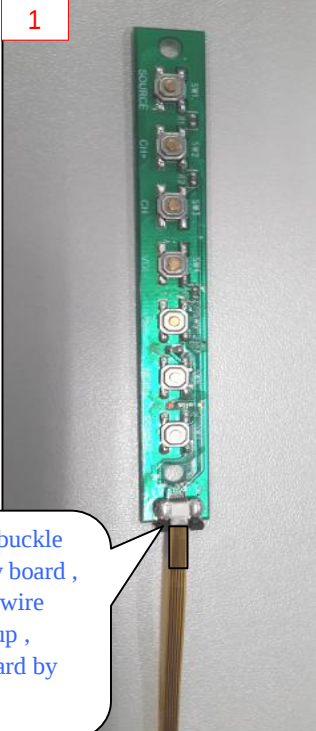


Modify records		Please read and understand the operating instructions carefully	Prepare	Verify	Approve	Engineering controlled seal
			Liu Xiaojun	徐晓军	刘小军	

Station name	Key Board Module Processing		Model	49L71F	Series/NO.		Pre process 09		Document NO.	ITA460109	Version	v5.0
			Program	T8 V59	Working hrs		25S		Effective date	2014/11/11	Update date	2014/11/11
NO	Material number	Amount	Description	Working contents and requirements						Mark figure	Tool parameter	
1	7096-42L71F-44B01101	1	Key bracket	insert double terminal wire on key board module socket.						figure 1		
2	7030-42L71F-4U711201	1	Button array	take row button and key bracket , check row button and bracke, make sure no deformation or breakage.						figure 2		
3	614Z-4500HA-05DD1201	1	450mm FPC two-terminal wire	combine row button and key bracket as in figure 3.						figure 3		
4	9014-112L71-00002011	1	Key board	install combined key board in figure 4 in combined bracket.						figure 4		
5			actual material number prevails with production order.	Put module on circulation tray waiting for production use after self check Ok.								

Notices	1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.												9
	2.Wear static ring during operation.												

1



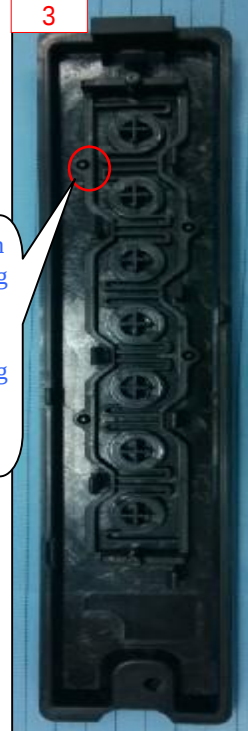
First black buckle pull out key board , connecting wire metal side up , buckle inward by tight

2



install row button on bracket rightly note foolproof positioning holes column installed correctly

3



row button positioning holes , bracket positioning column

4



The top button snaps into the bracket plate , the alignment column Gently press the keypad , so that the edge snaps completely stuck key board , installed after checking whether installed in place, press the top button should not have to die , not the card into the other bad touch phenomenon

Modify records		Please read and understand the operating instructions carefully	Prepare	Verify	Approve	Engineering controlled seal
			Liu Xiaojun	徐晓军	刘小军	

Station name		Display Placement		Model	49L71F	Series/NO.	Machine assemble 01	Document NO.	ITA460201	Version	v5.0	
				Program	T8 V59	Working hrs	27s	Effective date	2014/9/15	Update date	2014/9/15	
NO	Material number	Amount	Description		Working contents and requirements				Mark figure	Tool parameter		
1	7422-490LGK-385A7421-F	1	49" TFT KTC K490WD7-LJ330A1 LED PANEL		take display, remove its protection device, check its appearance to make sure it is OK.				figure 1			
2					catch frame of display, do not touch any part of display area.				figure 2			
3					put display on tooling board with display side down gently.				figure 2			
4			prevail with production order		click foot switch to let it flow to the next station after self check OK.							
5												
6												
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List										1
		2.Fetch display gently, do not scratch screen, catch display plastic frame, do not touch or damage screen.										
		3.Make good anti static measures, wear anti static gloves and cloth.										

1



take out display, put it on working table, remove its protection film and protection bag.



make sure display is OK.



do not press glass , hold it up from one side.

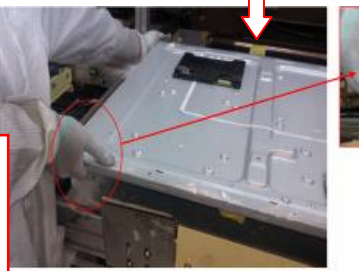


When lifting the screen , palms pressed to the back of the hand not glass, hand hold while the lower corners of the module position

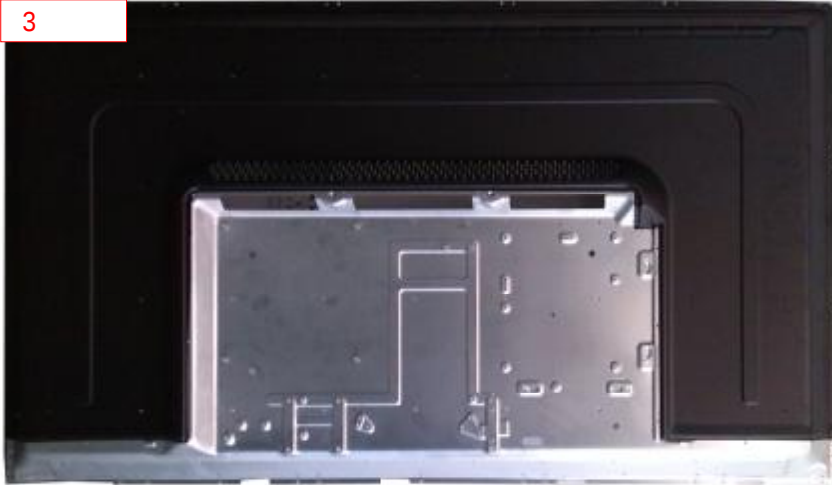
2



do not press glass , hold it up from one side. do not break screen

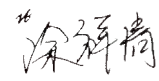



3

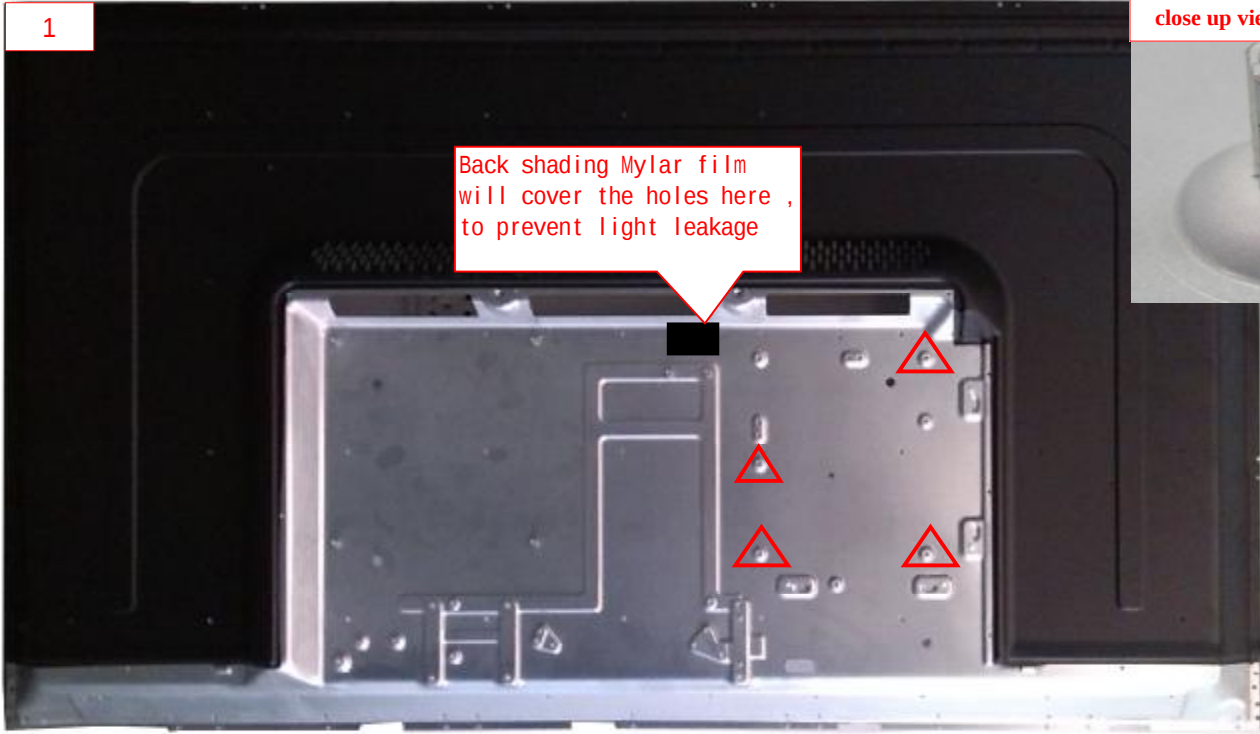
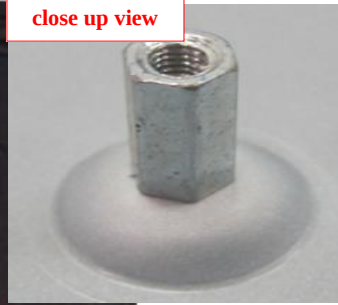
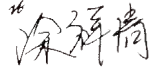


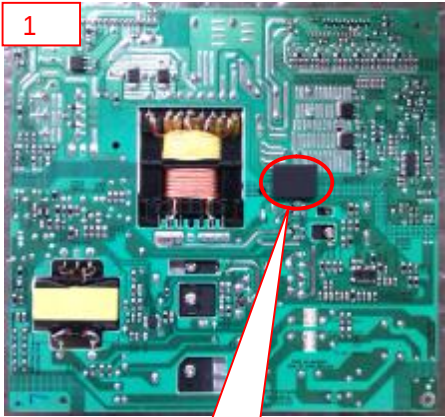
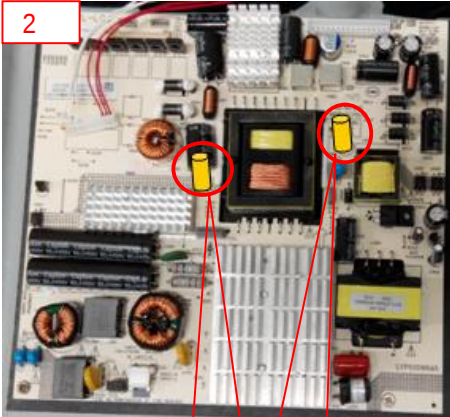
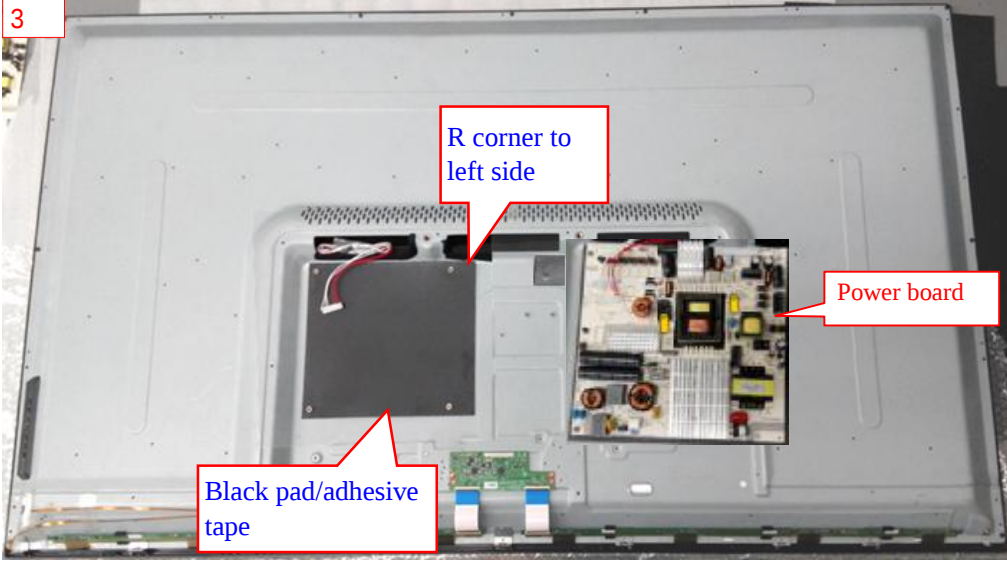
display operation process requirements:
 1. catch display plastic frame during opeartion, do not touch any part of screen .
 2. Check display to make sure there is no scratch/dirt/ damage etc.
 3.wear anti static cloth and gloves during operation to avoid screen damage.

Engineering controlled seal

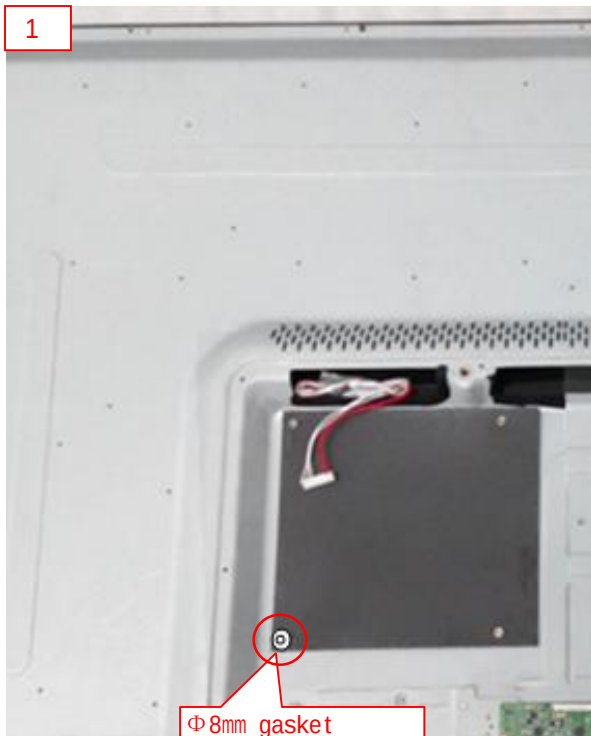
Modify records	Please read and understand the operating instructions carefully	Prepare	Verify	Approve
		Liu Xiaoju		

KTC® Operating Instructions

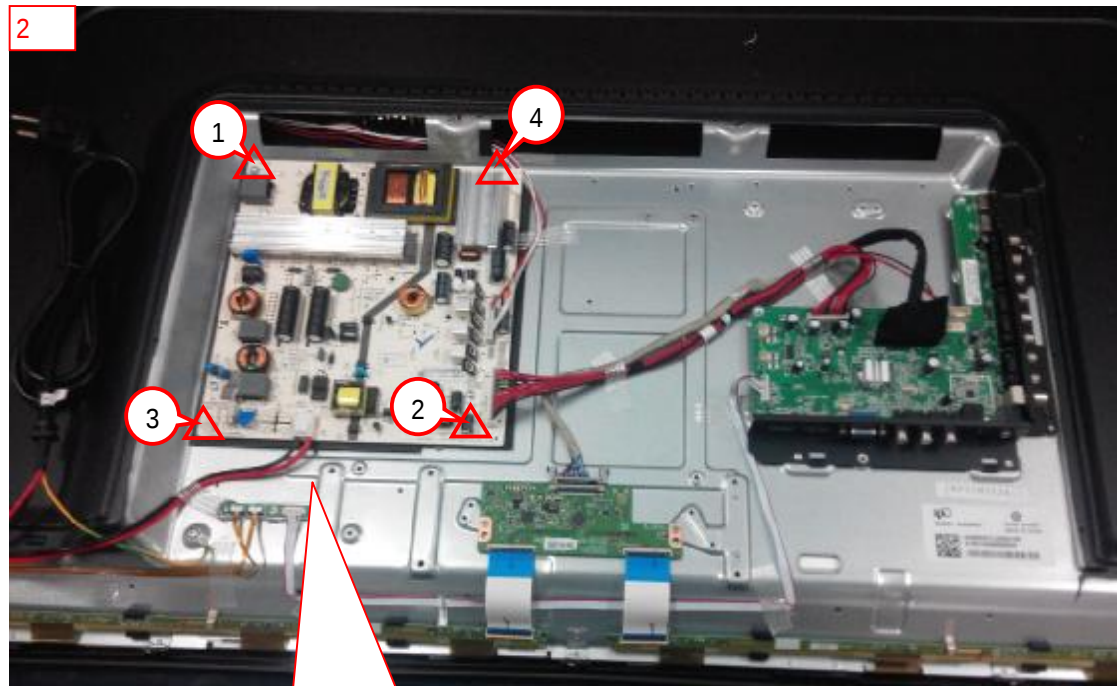
Station name	Locking Main Board Hex Screw			Model	49L71F	Series/NO.	Machine assemble 02	Document NO.	ITA460202	Version	v5. 1
				Program	T8 V59	Working hrs	25s	Effective date	2014/9/15	Update date	2014/11/11
NO	Material number	Amount	Description	Working contents and requirements					Mark figure	Tool parameter	
1	7B11-0302F0-00102111	4	Φ3×2.5×6mm Screw	take 4PCS screws, lock them on right side of display back.					figure 1 	electric driver	
2	7912-512027-027R0511	1	Black pad/adhesive tape	take light shield mylar film, stick it in figure position to avoid light leakage.					figure 1	3±0.5kgfcm	
3											
4				click foot switch to let it flow to the next station after self check OK.							
5			prevail with production order								
6											
Notices				1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List. 2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed. 3. Wear static ring during operation.					 		
1  close up view 				Process Requirements: 1. Check for rusted screws, missing slots or bad cross slot. 2. Check if the electric screwdriver torque force is within the specified requirements. 3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt). 4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw. 5. Put the defective screws in the defective product box and do not throw them everywhere.							
Modify records				Please read and understand the operating instructions carefully					Take only one screw at a time		
				Prepare		Verify		Approve			
				Liu Xiaoju							
				Engineering controlled seal							

Station name	Mylar Film Installation		Model	49L71F	Series/NO.		Machine assemble 03		Document NO.	ITA460203	Version	v5.2				
			Program	T8 V59	Working hrs			25s	Effective date	2014/10/29	Update date	2014/11/11				
NO	Material number	Amount	Description		Working contents and requirements					Mark figure	Tool parameter					
1	7912-513211-2200R411	1	Black pad/adhesive tape		remove protection film on mylar film, sticky it on left side display back power board fixing position.					figure 3						
2	9012-112A40-15003271	1	L6562D+L6599A+AP3105+AP3041 K-PL-L01 LED Combo Power board		take power board, make sure the appearance is OK, put good ones on working table.					figure 1						
3	7912-112020-0154R313	1	silica gel pad		take fire proof silicon gasket 1PC, stick it on power board foil side as figure.					figure 1						
4	7913-011803-03020111	2	insulated column for power		take power separation column *2PCS, insert it on power board parts side on mylar film as figure.					figure 2/3						
5	prevail with production order				click foot switch to let it flow to the next station after self check OK											
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.							 							
		2. Wear static ring during operation.														
 20*15*4.3mm 70° black fire proof silicon gasket  71F power separation column  R corner to left side Power board Black pad/adhesive tape																
											Engineering controlled seal					
Modify records				Please read and understand the operating instructions carefully			Prepare	Verify	Approve							
							Liu Xiaoju	徐晓菊	刘小菊							

Station name		Locking Power Board		Model	49L71F	Series/NO.	Machine assemble 04	Document NO.	ITA460204	Version	v5.0	
				Program	T8 V59	Working hrs	25s	Effective date	2014/9/15	Update date	2014/9/15	
NO	Material number		Amount	Description		Working contents and requirements				Mark figure	Tool parameter	
1	7140-000000-03100001		1	Gasket		take Φ7.8mm(inner diameter Φ4.0mm)*H0.7mm gasket *1PCS, stick it on display back screw column of lower left corner						
2						put display back poer board on mylar film, do not touch gasket off				figure 1	electric driver 4±1kgfcm	
3	7B11-0307C2-50102111		4	M3×7mm Screw		take M3×7mm P head screw *4PCS, locking power board on display back screw column from 1-4.				figure 2		
4										figure 2⚠		
5												
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.										
		2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.										
		3.Wear static ring during operation.										



$\Phi 8\text{mm}$ gasket attached on this screw hole



intall power board on mylar film, notic that lower corner need to be installed related to gasket

- Process Requirements:**
1. Check for rusted screws, missing slots or bad cross slot.
 2. Check if the electric screwdriver torque force is within the specified requirements.
 3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
 4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
 5. Put the defective screws in the defective product box and do not throw them everywhere.

Enginering controlled seal

Modify records

Please read and understand the operating instructions carefully

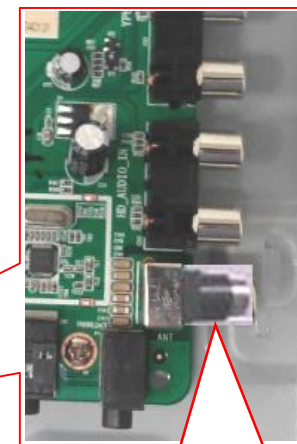
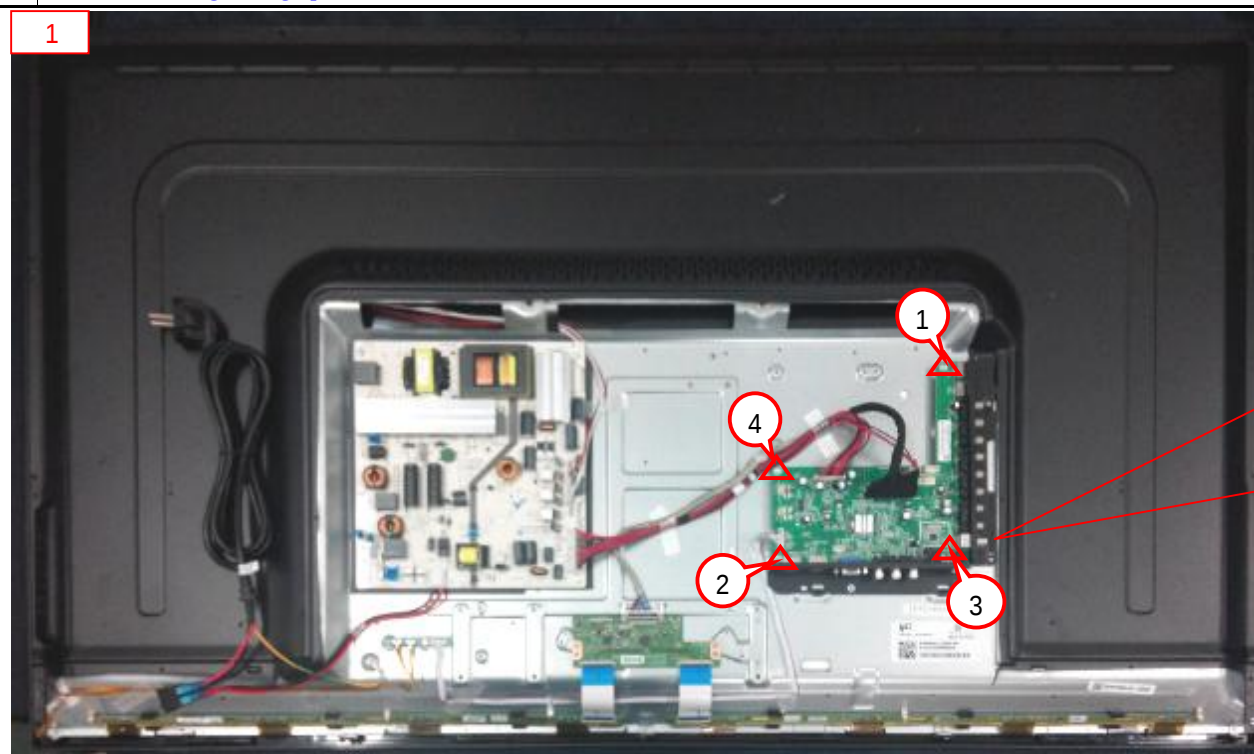
Take only one screw at a time

Prepare
Liu Xiaoju

Verify

Approve

Station name		Locking Main Board		Model	49L71F	Series/NO.	Machine assemble 05	Document NO.	ITA460205	Version	v5.0
				Program	T8 V59	Working hrs	25s	Effective date	2014/9/15	Update date	2014/9/15
NO	Material number	Amount	Description			Working contents and requirements			Mark figure	Tool parameter	
1	9011-11T82A-483B3221	1	TSUMV59XUS-SJ(NO DD B)+NXP18275 2*HDMI+2*USB mainboard			take main board, check its sppearance, make sure it is OK, and NXP silicon LNB IEC socket insulation cover applied on LNB head rightly.			figure 1	electric driver 4±1kgfcm	
2	70E8-000000-44401101	1	(Φ14*10) insulation sleeve			take M3×7mm P head screw *4PCS, to lock main board on screw			figure 1 		
3	7B11-0307C2-50102111	4	M3×7mm Screw			column from 1-4.					
4			prevail with production order			click foot switch to let it flow to the next station after self check OK.					
5											
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.								5	
		2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.									
		3.Wear static ring during operation.									

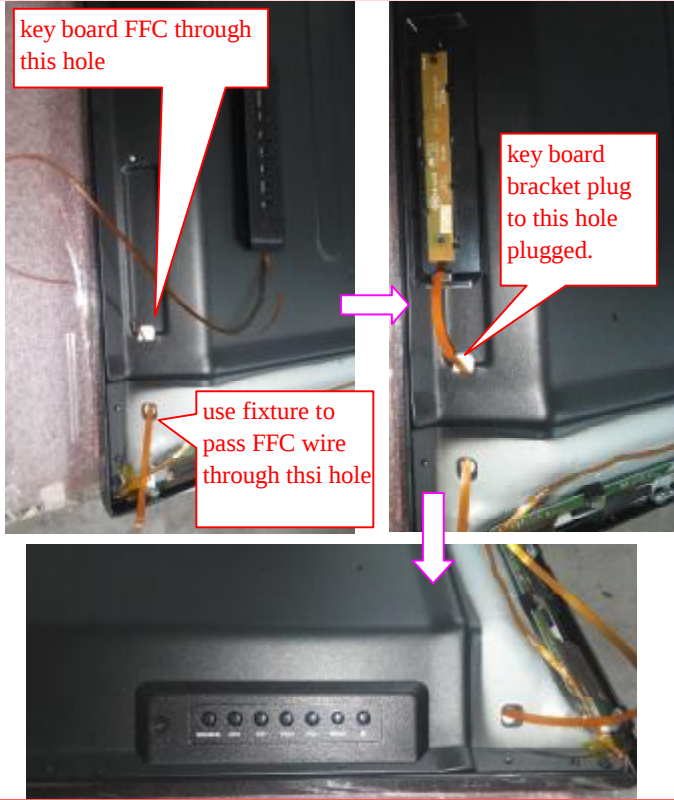
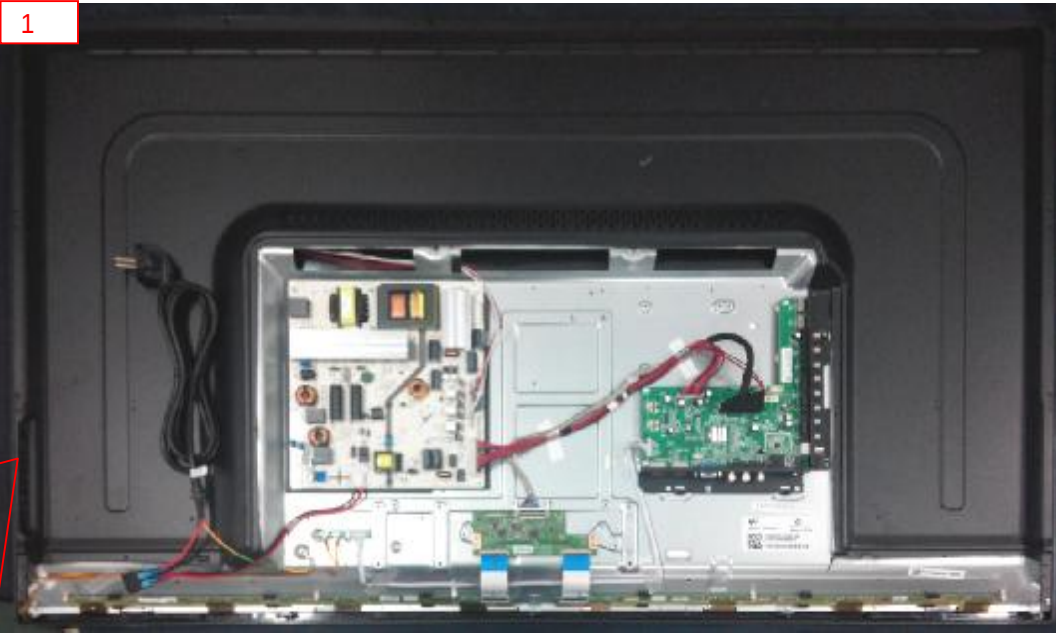


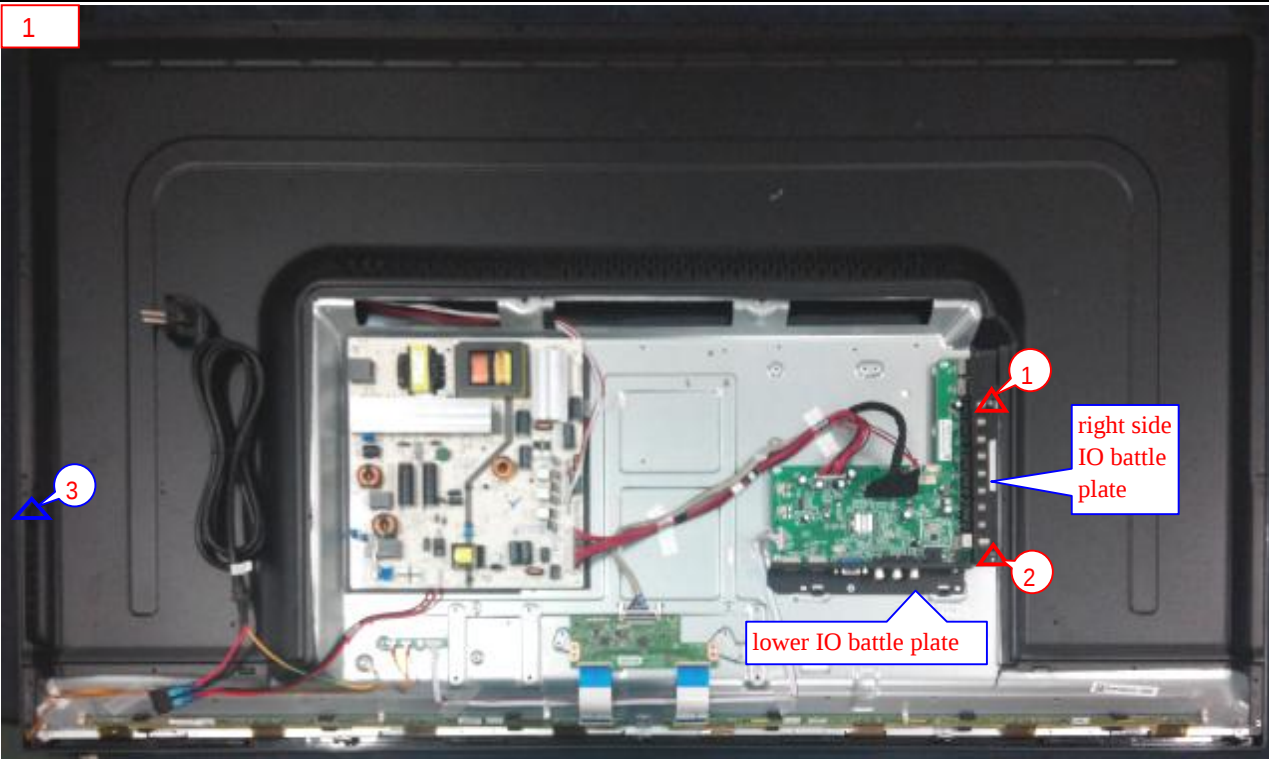
Note : 70E8-000000-44401101 NXP silicon tuner IEC socket head insulating sleeve station burning software has been installed , if found tainted installed the patch installed

- Process Requirements:**
1. Check for rusted screws, missing slots or bad cross slot.
 2. Check if the electric screwdriver torque force is within the specified requirements.
 3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
 4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
 5. Put the defective screws in the defective product box and do not throw them everywhere.

Engineering controlled seal

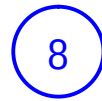
Modify records		Please read and understand the operating instructions carefully	Take only one screw at a time	Prepare	Verify	Approve
				Liu Xiaoju	徐晓娟	刘小娟

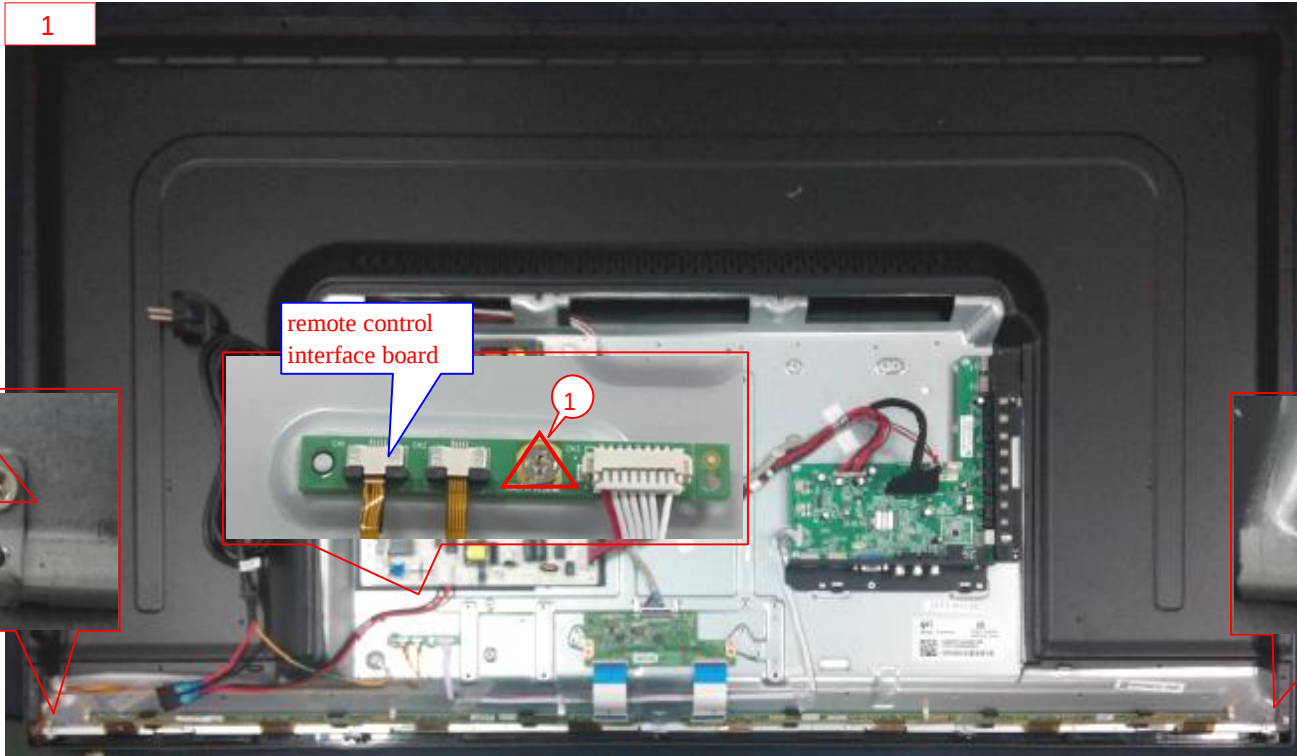
Station name		Key Board Installation		Model	49L71F	Series/NO.	Machine assemble 06	Document NO.	ITA460206	Version	v5.1
				Program	T8 V59	Working hrs	27s	Effective date	2014/11/11	Update date	2014/11/11
NO	Material number	Amount	Description	Working contents and requirements					Mark figure	Tool parameter	
1		1	pre process OK key board module	take pre process OK key board module, pass key FFC wire through from display back left side upper hole.					figure 1		
2				plug key board module on display back.					figure 1		
3			prevail with production order	click foot switch to let it flow to the next station after self check OK.							
4											
5											
Notices				1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List. 2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed. 3. Wear static ring during operation.					 	6	
				1 					Process Requirements: 1. Check for rusted screws, missing slots or bad cross slot. 2. Check if the electric screwdriver torque force is within the specified requirements. 3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt). 4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw. 5. Put the defective screws in the defective product box and do not throw them everywhere.		
									Engineering controlled seal		
Modify records		Please read and understand the operating instructions carefully		Take only one screw at a time		Prepare		Verify		Approve	
						Liu Xiaoju					

Station name	IO Battle Plate Installation		Model	49L71F	Series/NO.	Machine assemble 07	Document NO.	ITA460207	Version	v5. 1
			Program	T8 V59	Working hrs	28s	Effective date	2014/9/15	Update date	2014/11/11
NO	Material number	Amount	Description		Working contents and requirements			Mark figure	Tool parameter	
1	7111-42L71F-4112DJ01	1	Hardware baffle plate		take right side IO battle plate , install it in display back card slot relatively.			figure 1	electric driver 4±1kgfcm	
2	7111-49L71F-41120J01	1	Hardware baffle plate		take lower side IO battle plate , install it in display back card slot relatively.			figure 1		
3	7B11-0303A6-00101121	2	Φ3×3mm Screw (1-2)		take Φ3×3mm flat head screw*3PCS, fix remote control、 IO battle plate on display back.			figure 1 ▲		
4	7B11-0308BG-00305411	1	Φ3×8mm Screw (3)		take Φ3×8mm screw *1PC, lock key board module on display back.			figure 1 ▲		
5					click foot switch to let it flow to the next station after self check OK.					
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List. 2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed. 3. Wear static ring during operation.						 		7
 1 right side IO battle plate lower IO battle plate 3 close up view  Corresponding screen bezel latch back into the slot and snap it into the hole in the screen snaps back Process Requirements: 1. Check for rusted screws, missing slots or bad cross slot. 2. Check if the electric screwdriver torque force is within the specified requirements. 3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt). 4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw. 5. Put the defective screws in the defective product box and do not throw them everywhere.										
Modify records		Please read and understand the operating instructions carefully		Take only one screw at a time		Prepare		Verify		Approve
						Liu Xiaoju				
										Engineering controlled seal

Station name	Locking Bracket, Remote Control Interface Board	Model	49L71F	Series/NO.	Machine assemble 08	Document NO.	ITA460208	Version	v5.0
		Program	T8 V59	Working hrs	26s	Effective date	2014/9/15	Update date	2014/9/15

NO	Material number	Amount	Description	Working contents and requirements	Mark figure	Tool parameter
1	9019-112L71-00004011	1	Switch plate	make sure the appearance of remote control interface board with mylar film sticked , fix good ones on display back.	figure 1	Electric driver 3±0.5kgfcm
2	7142-49L71F-42320001	2	Fixed bracket	take lower fixing bracket 4*2PCS, install it on left lower corner and right lower corner display back for positioning.	figure 1	
3	7B11-0303A6-00101121	3	Φ3×3mm Screw	take Φ3×3mm screw *3PCS, lock remote control interface board, lower bracket on display back from 1-3 .	figure 1△	
4				click foot switch to let it flow to the next station after self check OK.		

Notices	1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.							
	2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.							
	3.Wear static ring during operation.							



1

2
lower fixing bracket

remote control interface board

1

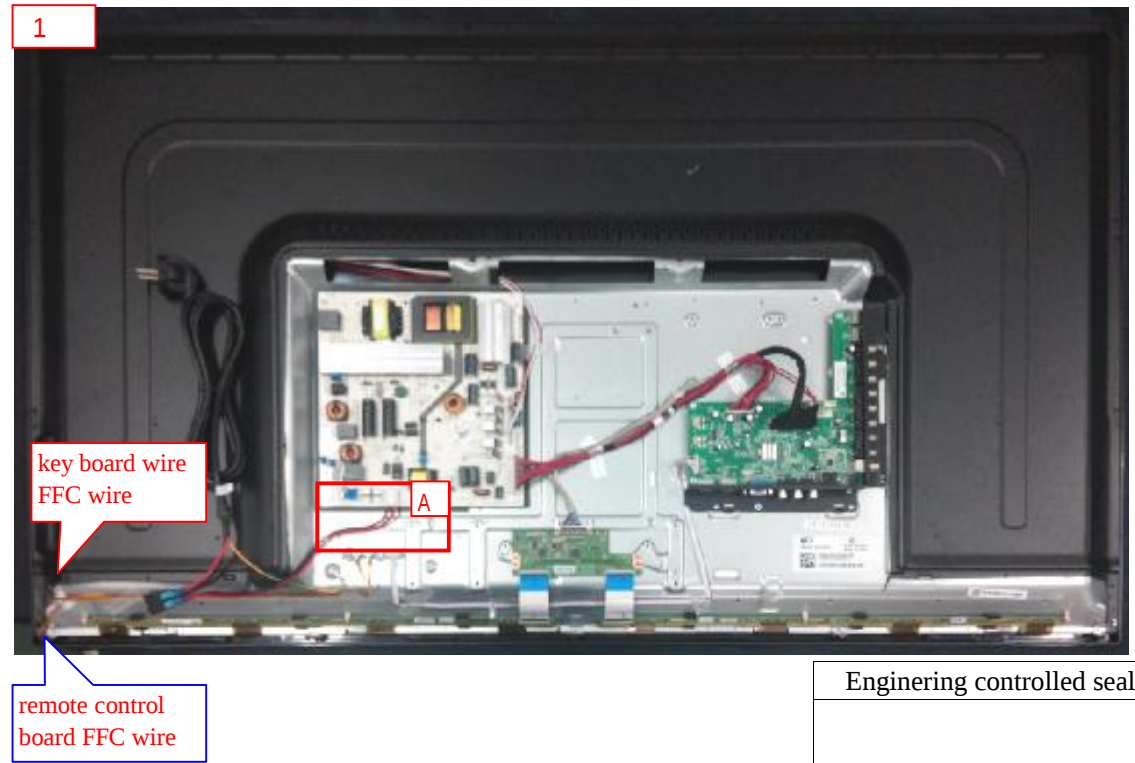
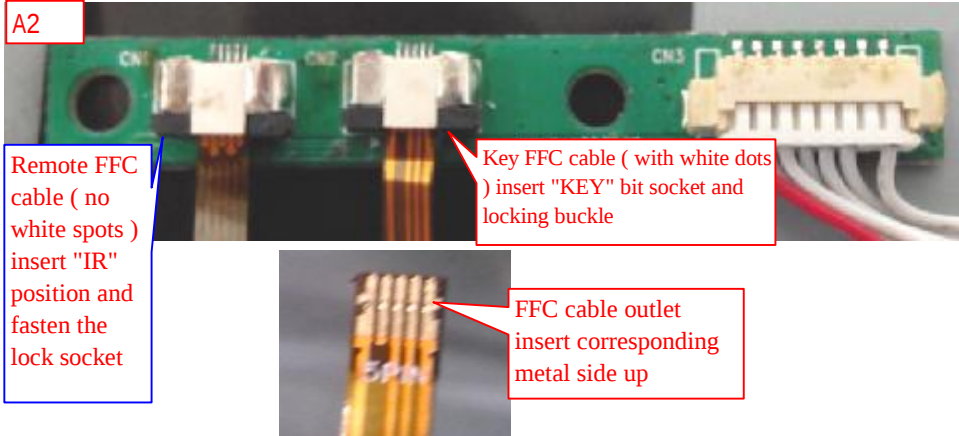
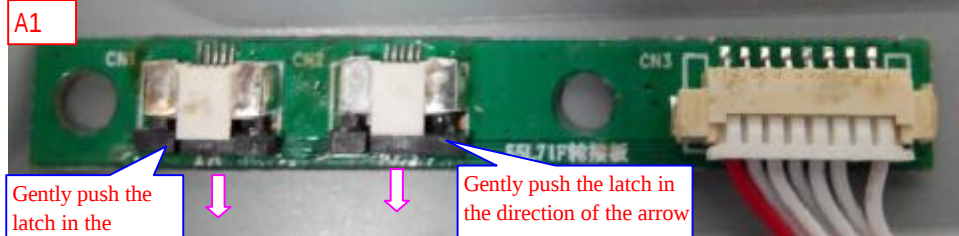
3

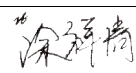
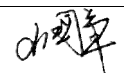
Process Requirements:

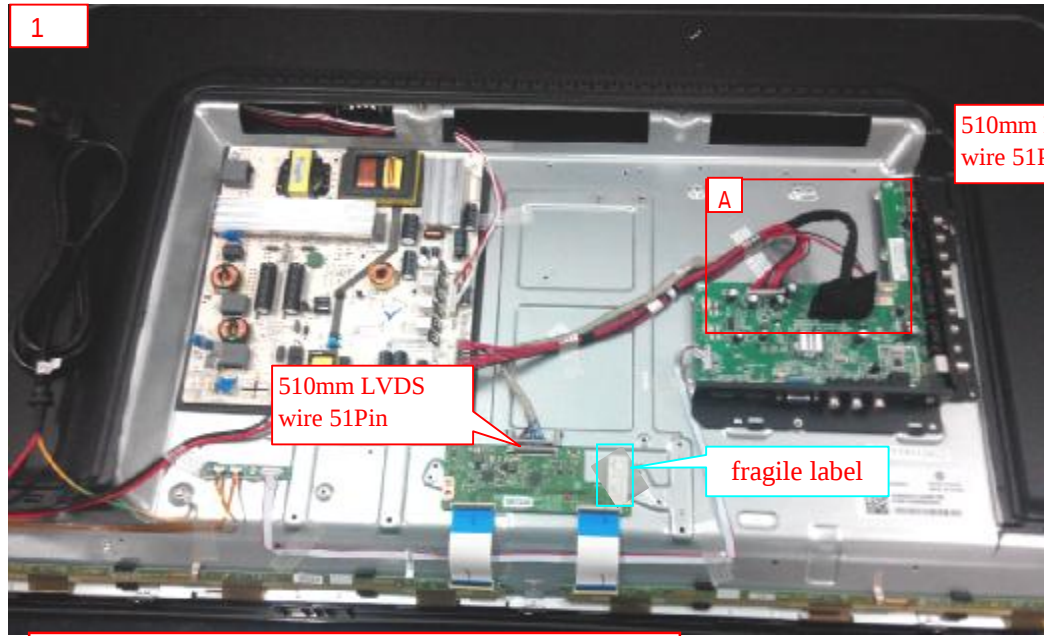
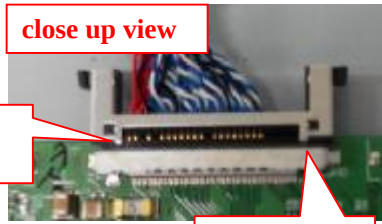
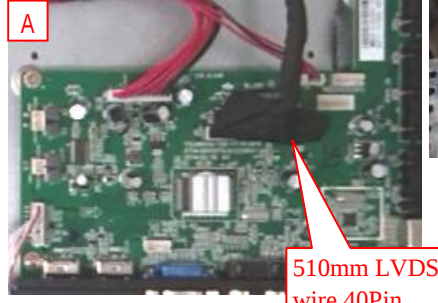
1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them everywhere.

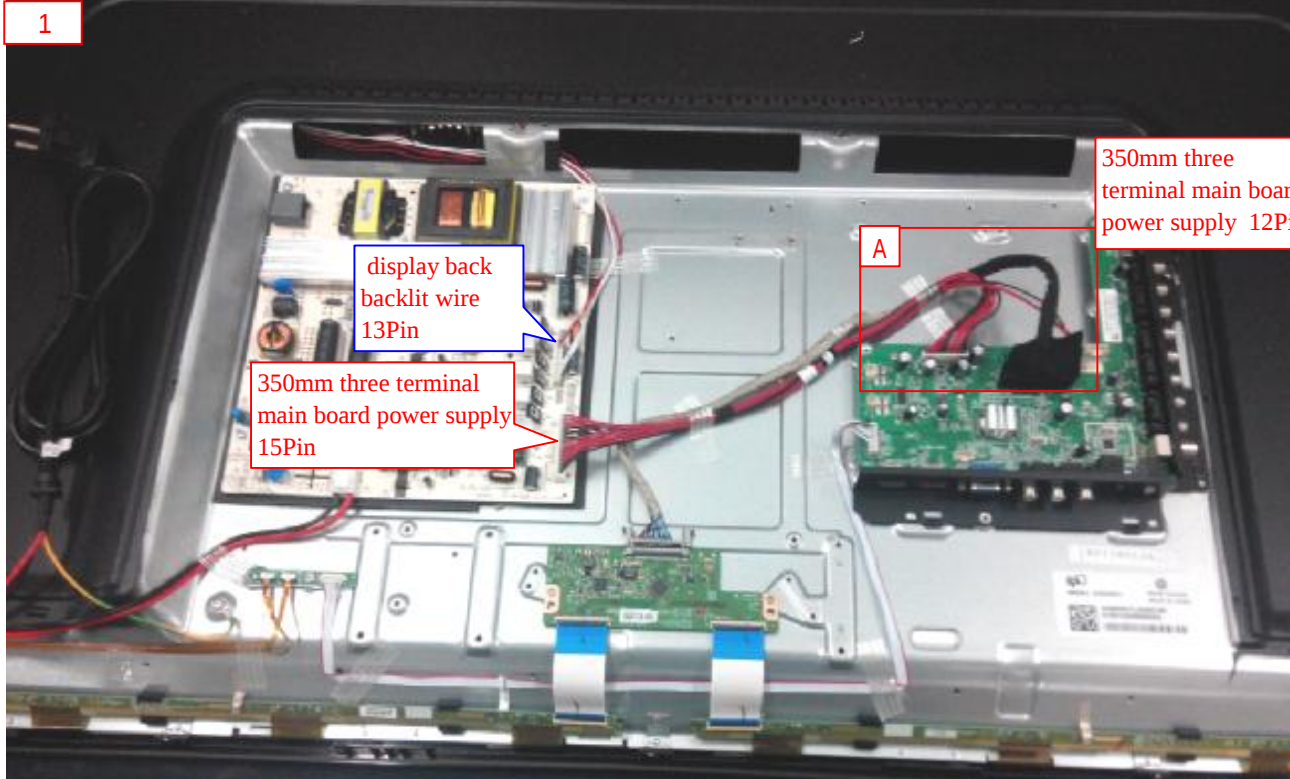
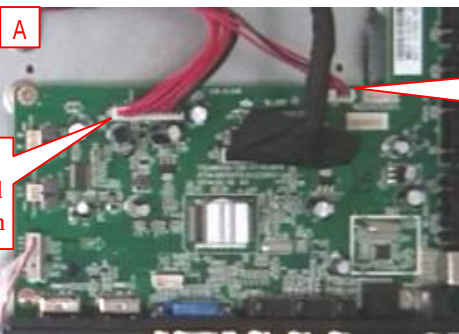
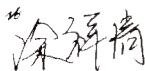
Modify records	Please read and understand the operating instructions carefully	Prepared by	Verify	Approve	Engineering controlled seal
		Liu Xiaoju			

Station name		Inserting Wire -A		Model	49L71F	Series/NO.	Machine assemble 09	Document NO.	ITA460209	Version	v5.0
				Program	T8 V59	Working hrs	27s	Effective date	2014/9/15	Update date	2014/9/15
NO	Material number	Amount	Description	Working contents and requirements						Mark figure	Tool parameter
1				push key board wire inserted interface FFC socket buckle out gently, , do not push too hard to avoid buckle loosen.						figure A1	
2				insert lower left side display back key board FFC wire (with white point) on interface board “Key” socket, plug buckle tightly to inside socket direction.						figure A2	
3				insert lower left corner display back remote control board FFC wire (no white point) on interface board “IR” socket , lock buckle tightly.						figure A2	
4				click foot switch to let it flow to the next station after self check OK.							
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.									
		2.Insert wire in the right place, it should not be msinsertions , skew , not in place									
		3.Wear static ring during operation.									

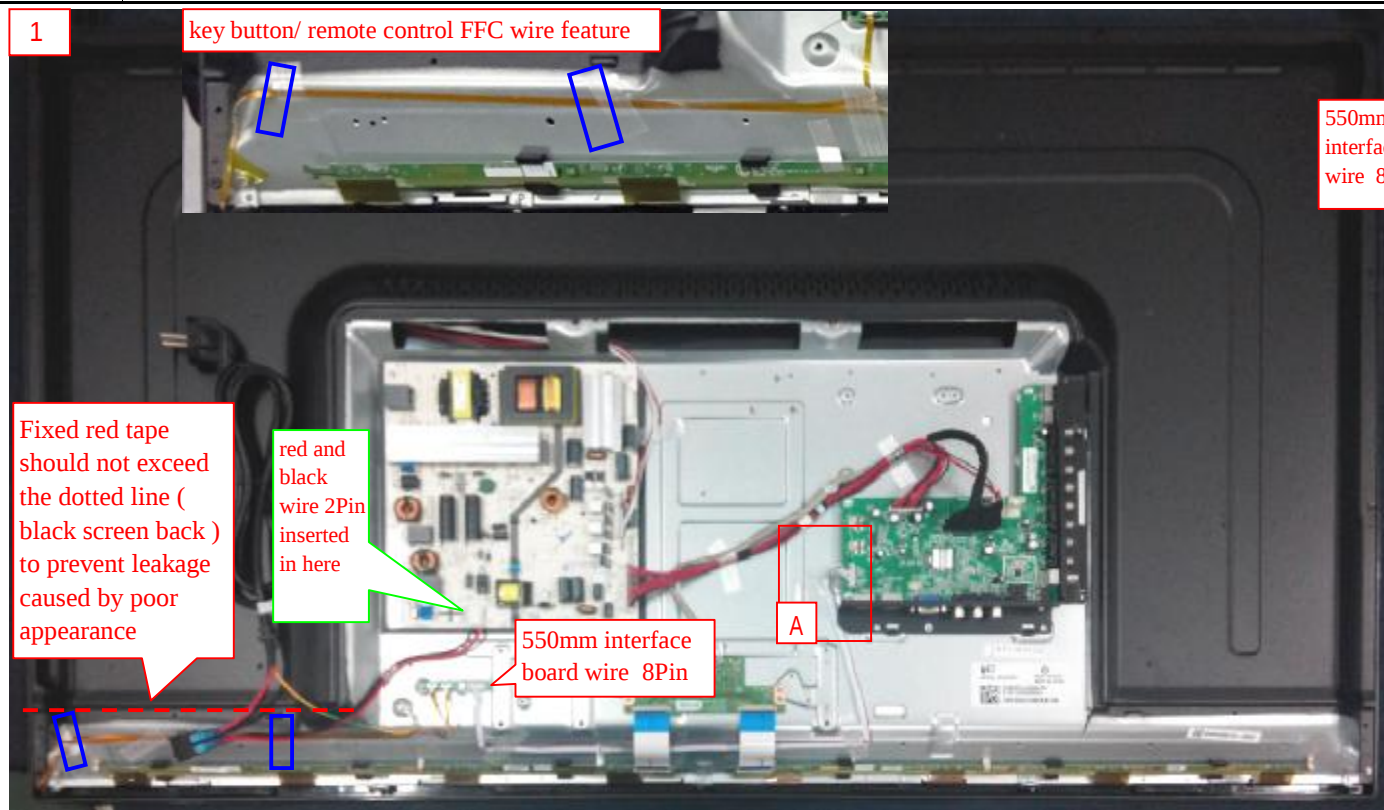


Modify records	Please read and understand the operating instructions carefully	Prepare	Verify	Approve
		Liu Xiaoju		

Station name	Wire Inserting-B			Model	49L71F	Series/NO.	Machine assemble 10	Document NO.	ITA460210	Version	v5.0
				Program	T8 V59	Working hrs	27s	Effective date	2014/9/15	Update date	2014/9/15
NO	Material number	Amount	Description	Working contents and requirements					Mark figure	Tool parameter	
1	6149-510063-517U1203	1	510mm 51pin,40pin LVDS two-terminal wire	take 510mm double terminal LVDS wire, insert 51Pin on driver board, 40Pin inserted on main board LVDS socket, white point to main board "1" or "△" inserting.					figure 1 	pen	
2	7373-000000-10000011	1	Paster	take fragile label, make mark, then stick on display driver board cover board screw.					figure 1 		
3			prevail with production order	click foot switch to let it flow to the next station after self check OK.							
Notices	1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.							 			
	2. Insert wire in the right place, it should not be misinsertions, skew, not in place										
	3. Wear static ring during operation.										
 1 510mm LVDS wire 51Pin 510mm LVDS wire 40Pin fragile label close up view  mental side up  hold PCBA board with one hand Note: The first data line vertically aligned plug socket interface, and then pressing a little hard data cable plug, the plug in the socket after closely plugged in, gently pull back a few times, check the data cable is plugged in. If not plugged in, with thumb and forefinger and hold the plug on both sides of the elastic snaps, and then remove the data cable, and then re-plugged LVDS Line Wire inserting process: 1. insert vertically, do not insert with wrong direction/wrong wire/missing insert, wire mistake proof and socket mistake proof connector should be consistent. 2. Insert with appropriate pressure to insert in the right place, keep away from power board (heat radiation and transformer) when PCBA board gap is large, hold it with one hand, insert wire with another hand in order to avoid pressing to break PCB. Fragile stickers do production date marking machine and display the warranty period (according to the work order request check code 13/15/18/24/36 warranty, the warranty is not unified tick in the margin, if the warranty code this is inconsistent with the number of groups, please write in the space provided on the specific code) and then mark affixed to the display driver board cover fixing screws 											
Modify records	Please read and understand the operating instructions carefully					Prepare	Verify	Approve			
						Liu Xiaojun					
Engineering controlled seal  											

Station name	Wire Inserting-C		Model	49L71F	Series/NO.	Machine assemble 11	Document NO.	ITA460211	Version	v5.0
			Program	T8 V59	Working hrs	26s	Effective date	2014/9/15	Update date	2014/9/15
NO	Material number	Amount	Description			Working contents and requirements			Mark figure	Tool parameter
1	6149-3500E5-15112301	1	350mm three-terminal wire			take 350mm terminal main board power wire insert 15Pin on main board 板15Pin socket ,12Pin and 3Pin inserted on main board 12Pin and 3Pin sockets as figure.			figure 1/A 	
2			prevail with production order			insert display back backlit wire 13Pin(lack 7Pin) on power board 13Pin socket.			figure 1/B 	
3						click foot switch to let it flow to the next station after self check OK.				
Notices	1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List. 2.Insert wire in the right place, it should not be msinsertions , skew , not in place 3.Wear static ring during operation.						 		11	
1  A  A  350mm three terminal main board power supply 3Pin 350mm three terminal main board power supply 12Pin Wire inserting process: 1.insert vertically, do not insert wiht wrong direction/wrong wire/missing insert,wire mistake proof and socket mistak proof connector should be consisten. 2.Inserti with appropriate pressure to insert in the right place, keep away from power board(heat radiation and transformaer) when PCBA board gap is large,hold it wiewh one hand, insert wire with another hand in order to avoid pressing to brake PCB.										
										Enginering controlled seal
Modify records	Please read and understand the operating instructions carefully				Prepare	Verify	Approve			
					Liu Xiaoju					

Station name		Inserting Wire -D		Model	49L71F	Series/NO.	Machine assemble 12	Document NO.	ITA460212	Version	v5.1
				Program	T8 V59	Working hrs	28s	Effective date	2014/9/15	Update date	2014/10/13
NO	Material number	Amount	Description		Working contents and requirements				Mark figure	Tool parameter	
1	6149-550063-08111201	1	550mm 8pin two-terminal wire		take 550mm double terminal wire, insert 8Pin on interface board 8Pin socket , another end to 8Pin socket (Key positon) as figure.				figure 1/A 		
2		1	pre process OK rocker switch + wire module		takepre process finished OK power wire module, insert 2 pin socket on power board 2 pin socket.				figure 1 		
3	7912-713050-015R1311	2	viscose paper (length: 50mm)		cut 2 viscose paper with length of 50mm, fix wire on display back as figure.				figure 1 		
4			prevail with production order		click foot switch to let it flow to the next station after self check OK.						
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.									12
		2.Insert wire in the right place, it should not be msinsertions , skew , not in place									
		3.Wear static ring during operation.									



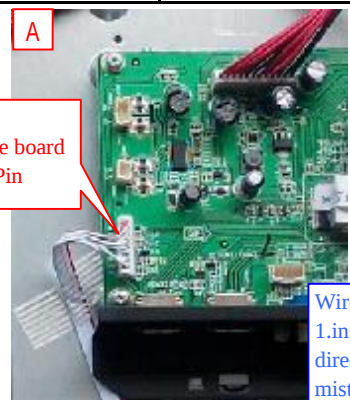
1 key button/ remote control FFC wire feature

Fixed red tape should not exceed the dotted line (black screen back) to prevent leakage caused by poor appearance

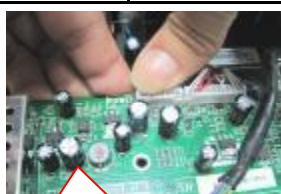
red and black wire 2Pin inserted in here

550mm interface board wire 8Pin

A



A 550mm interface board wire 8Pin



hold PCBA board with one hand

Wire inserting process:

1.insert vertically, do not insert wiht wrong direction/wrong wire/missing insert,wire mistake proof and socket mistak proof connector should be consisten.

2.Inserti with appropriate pressure to insert in the right place, keep away from power board(heat radiation and transformaer) when PCBA board gap is large,hold it wieh one hand, insert wire with another hand in order to avoid pressing to brake PCB.

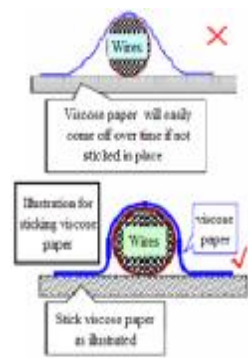
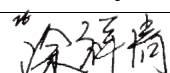
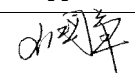
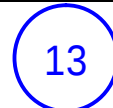


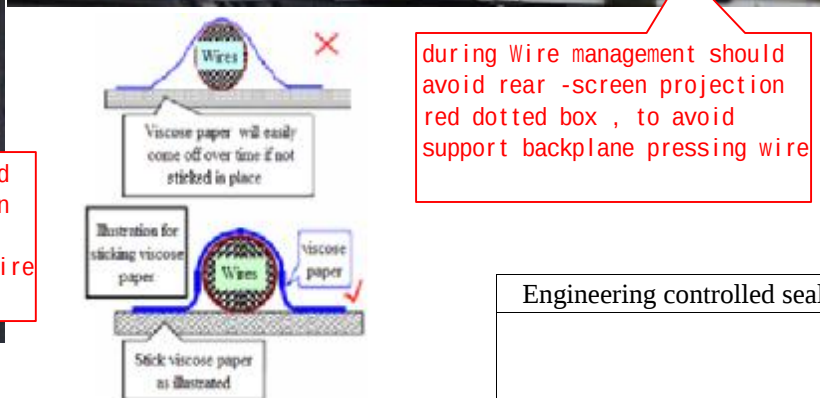
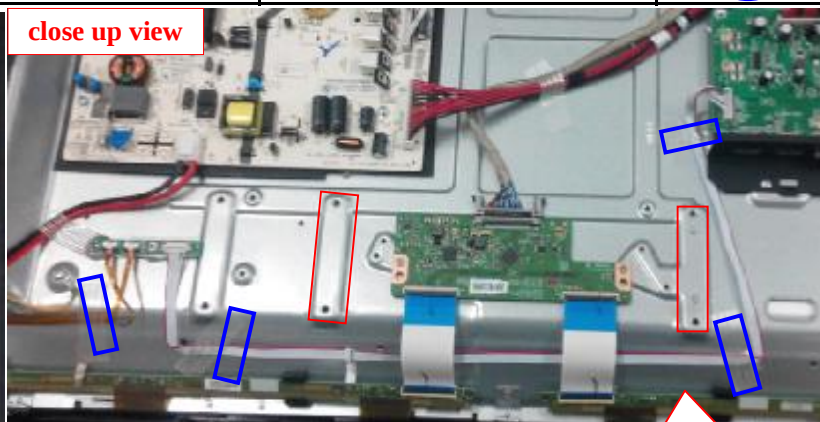
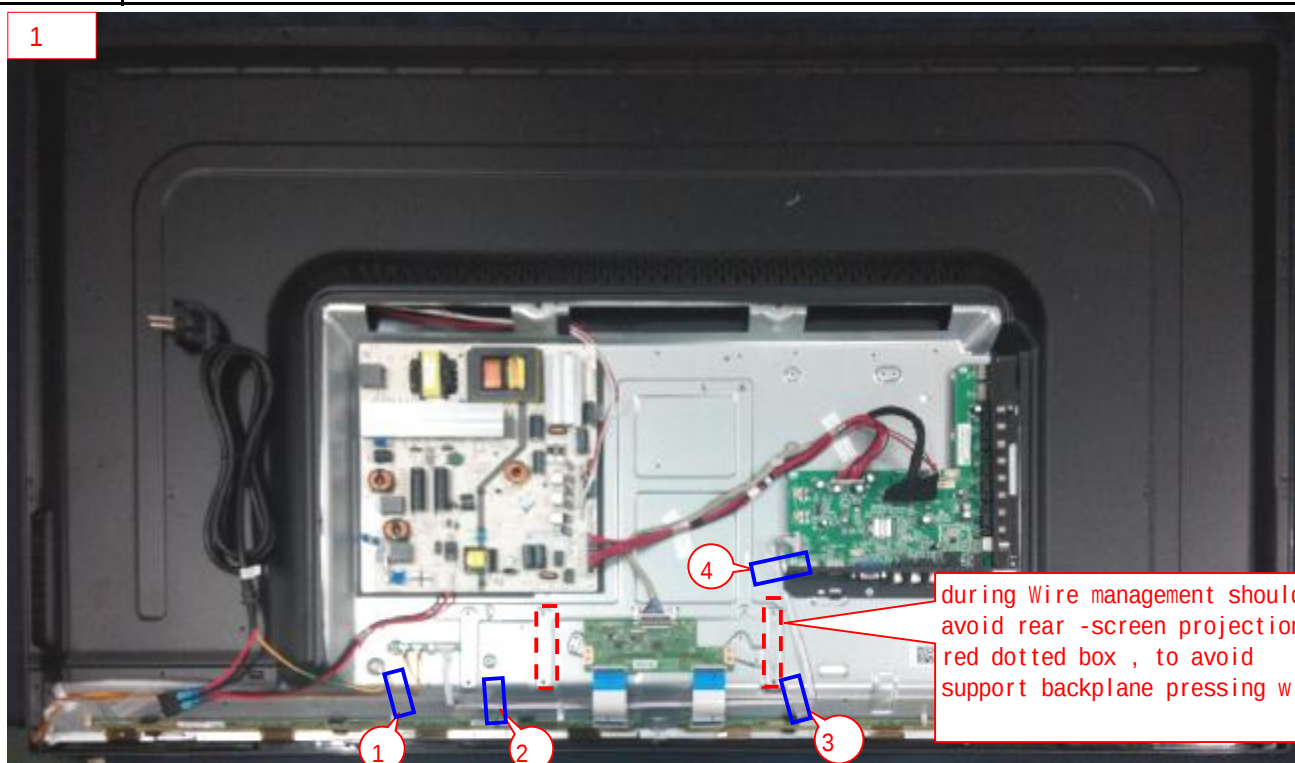
Illustration for sticking viscose paper

Stick viscose paper as illustrated

Engineering controlled seal

Modify records	Please read and understand the operating instructions carefully		Take only one screw at a time	Prepare	Verify	Approve
				Liu Xiaoju		

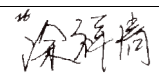
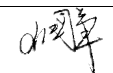
Station name		Arranging Wire—A			Model	49L71F	Series/NO.	Machine assemble 13	Document NO.	ITA460213	Version	v5.2
					Program	T8 V59	Working hrs	25s	Effective date	2014/10/13	Update date	2014/11/11
NO	Material number	Amount	Description				Working content and requirements			Mark figure	Tool parameter	
1	7912-713050-015R1311	4	viscose paper (length : 50mm)				cut 4 viscose paper with length of 50mm to fix wire on display back as figure.			figure 1 	tape machine	
2							click foot switch to let it flow to the next station after self check OK.					
3												
4												
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.										
		2. Viscose paper should be stuck in to “Ω” shape, it should be tight, flat, can not tilt.										
		3.Pay attention to self check and recheck to avoid any defective product flow to the next station. .										

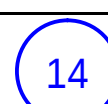


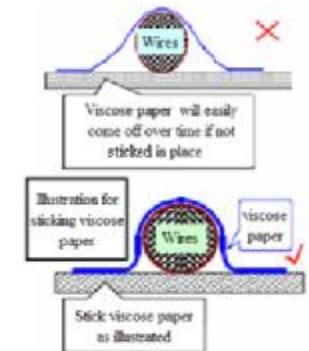
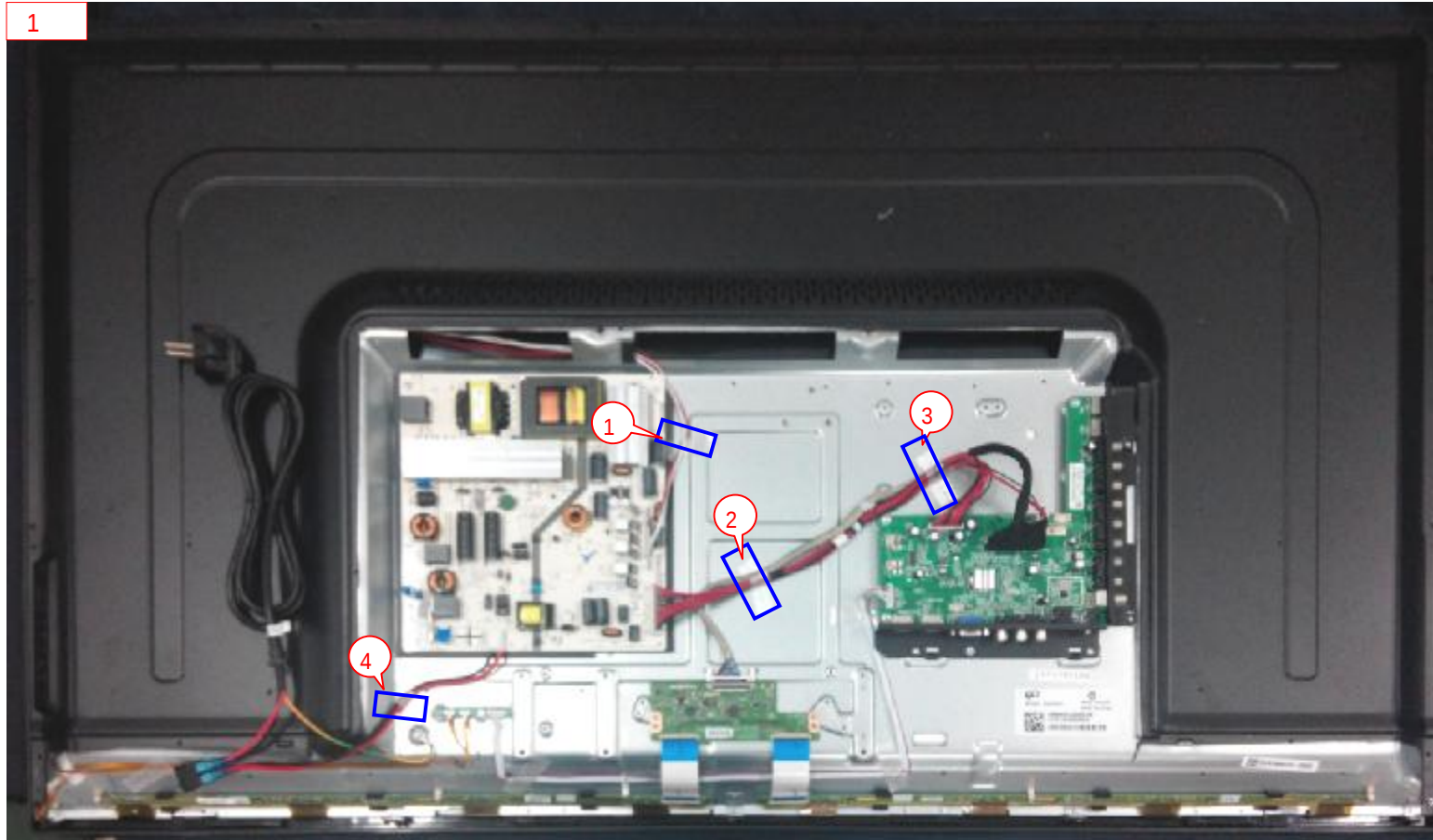
during Wire management should avoid rear -screen projection red dotted box , to avoid support backplane pressing wire

during Wire management should avoid rear -screen projection red dotted box , to avoid support backplane pressing wire

Engineering controlled seal

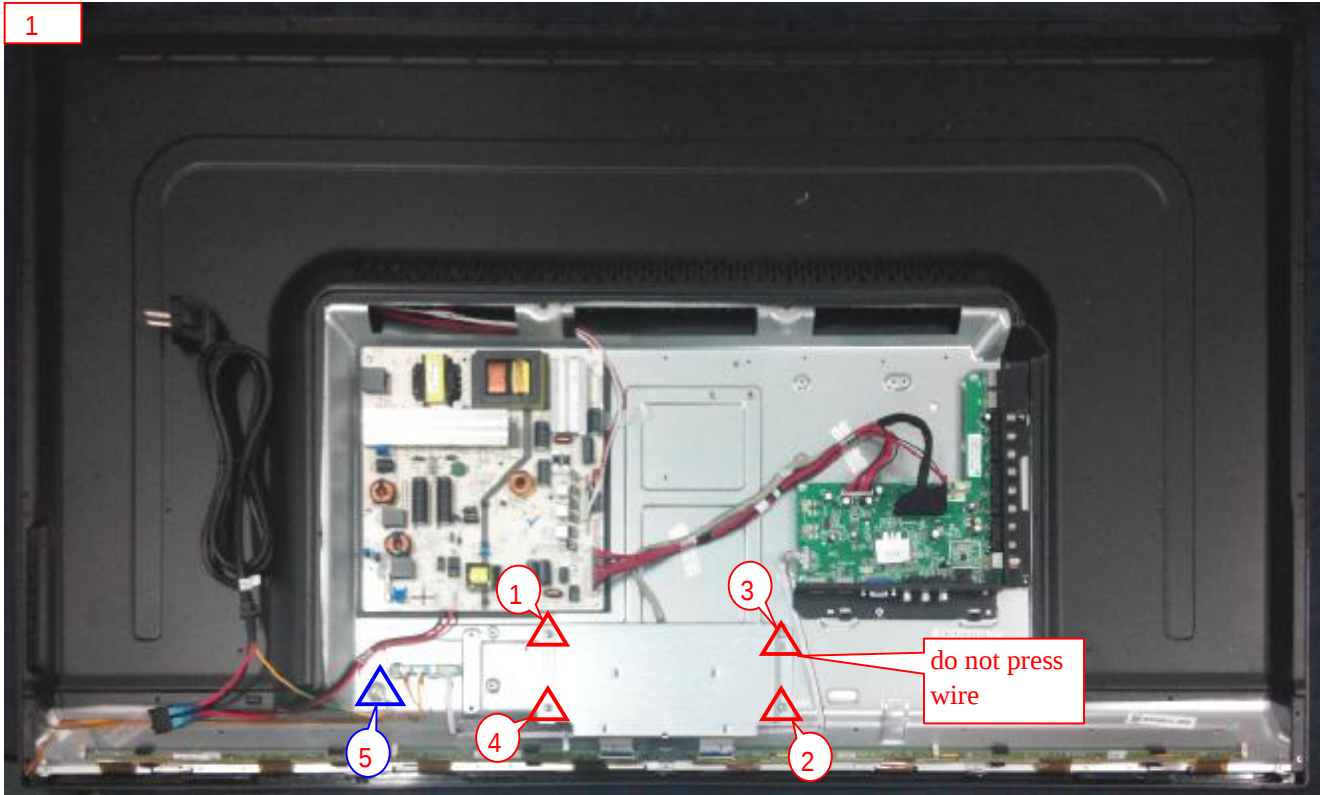
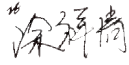
Modify records		Please read and understand the operating instructions carefully	Prepared by	Verify	Approval
			Liu Xiaoju		

Station name		Arranging Wire—B		Model	49L71F	Series/NO.	Machine assemble 14	Document NO.	ITA460214	Version	v5.2
				Program	T8 V59	Working hrs	25s	Effective date	2014/10/13	Update date	2014/11/11
NO	Material number	Amount	Description			Working contents and requirements			Mark figure	Tool parameter	
1	7912-713050-015R1311	4	viscose paper (length: 60mm)			cut 4 viscose paper with length of 60mm, fix wire on display back as figure.			figure 1 	tape machine	
2						click foot switch to let it flow to the next station after self check OK.					
3											
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.									
		2. Viscose paper should be stuck as requirements, it should be in “Ω” shape, tight, flat, can not tilt !									
		3. Wear static ring during operation.									

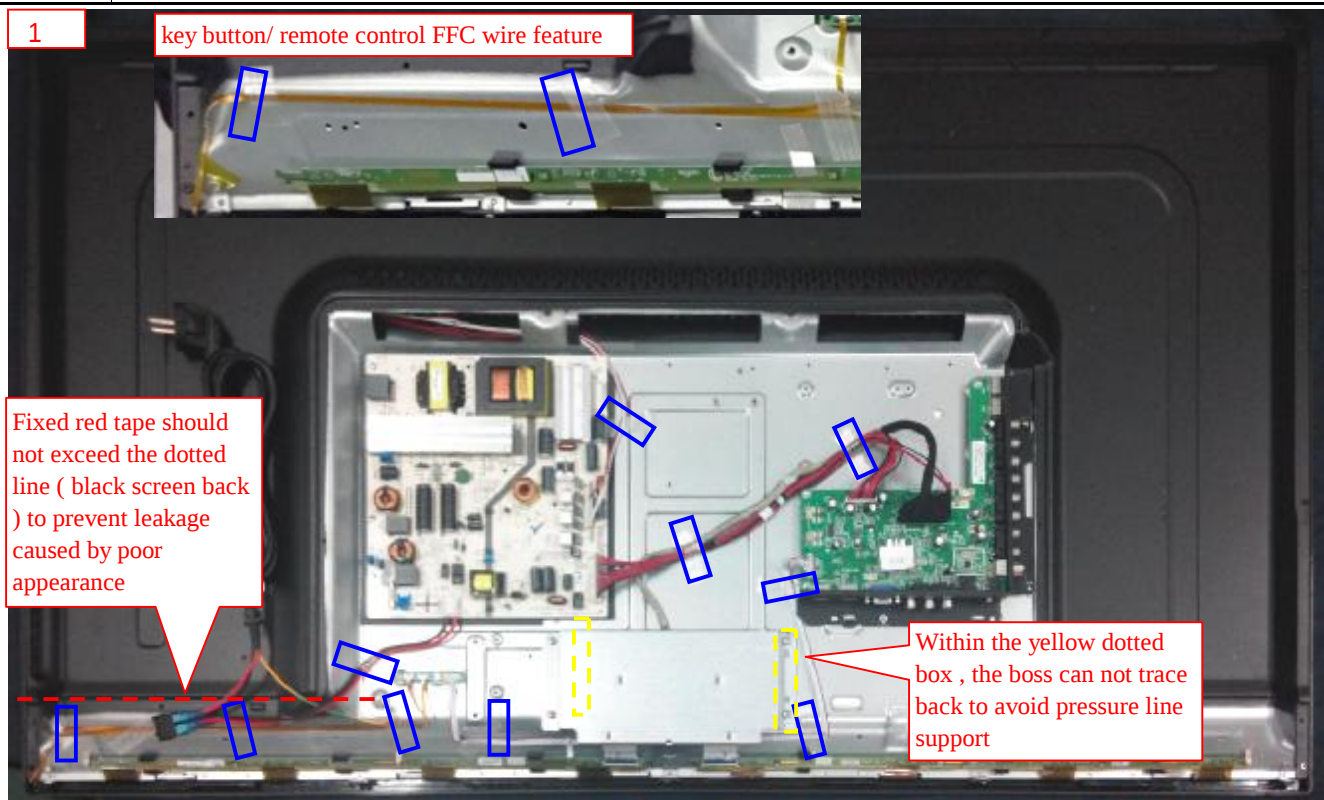


Engineering controlled seal

Modify records		Please read and understand the operating instructions carefully	Prepare	Verify	Approve
			Liu Xiaoju		

Station name	Locking Support Back Board		Model	49L71F	Series/NO.	Machine assemble 15	Document NO.	ITA460215	Version	v5.1
			Program	T8 V59	Working hrs	26s	Effective date	2014/9/15	Update date	2014/10/13
NO	Material number	Amount	Description	Working contents and requirements				Mark figure	Tool parameter	
1	7114-49L71F-42120001	1	Support back plate	take support back board, put it in the display back middle bottom, with holes aligned.				figure 1	electric driver	
2	7B11-0406D6-20101111	4	Φ4×6mm Screw	take Φ4×6mm screws *4PCS, use electric driver to lock support back board on display back as order 1-4				figure 1 ▲	6±1kgfcm	
3	7B11-0405D6-40102111	1	Φ4×5mm Screw	take Φ4×5mm screw *1PC, to lock grounding wire firmly.				figure 1 ▲		
4			prevail with production order	click foot switch to let it flow to the next station after self check OK.						
Notices	1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.						 	15		
	2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.									
	3. Wear static ring during operation.									
1  Process Requirements: 1. Check for rusted screws, missing slots or bad cross slot. 2. Check if the electric screwdriver torque force is within the specified requirements. 3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt). 4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw. 5. Put the defective screws in the defective product box and do not throw them everywhere.										
							Engineering controlled seal			
Modify records	Please read and understand the operating instructions carefully Take only one screw at a time			Prepare	Verify	Approve				
				Liu Xiaoju						

Station name		Process Check		Model	49L71F	Series/NO.	Machine assemble 16	Document NO.	ITA460216	Version	v5.2
				Program	T8 V59	Working hrs	27s	Effective date	2014/10/13	Update date	2014/11/11
NO	Material number	Amount	Description	Working contents and requirements						Mark figure	Tool parameter
1				check screw attachment situation .						figure 1	
2				check viscose paper attachment situation.						figure 1	
3				check wire attachment situation.						figure 1	
4				mark on flow card when there is any defect inside machine, handle it for maintenance.							
5				click foot switch to let it flow to the next station after self check OK.							
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.									
		2.The actual test standard refers to " LCD monitor test regulation" "Plastic products test regulation" and " production order notice".									
		3.Wear static ring during operation.									

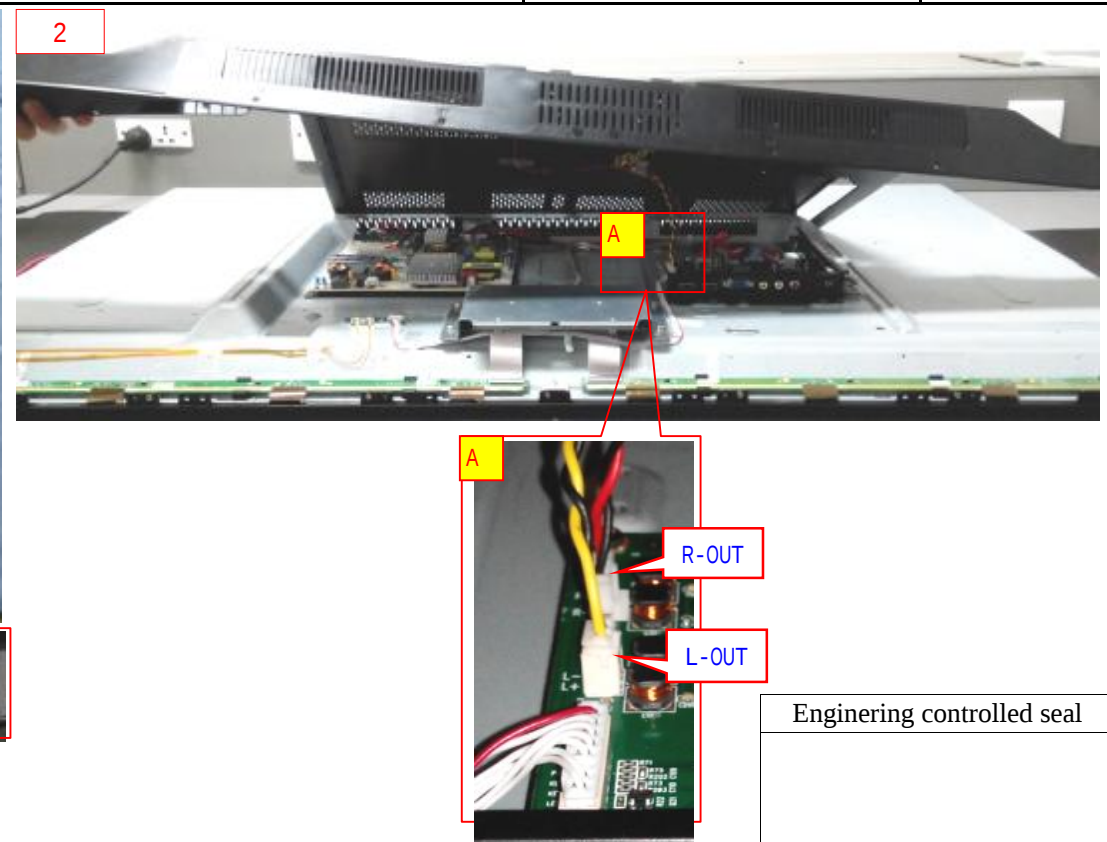
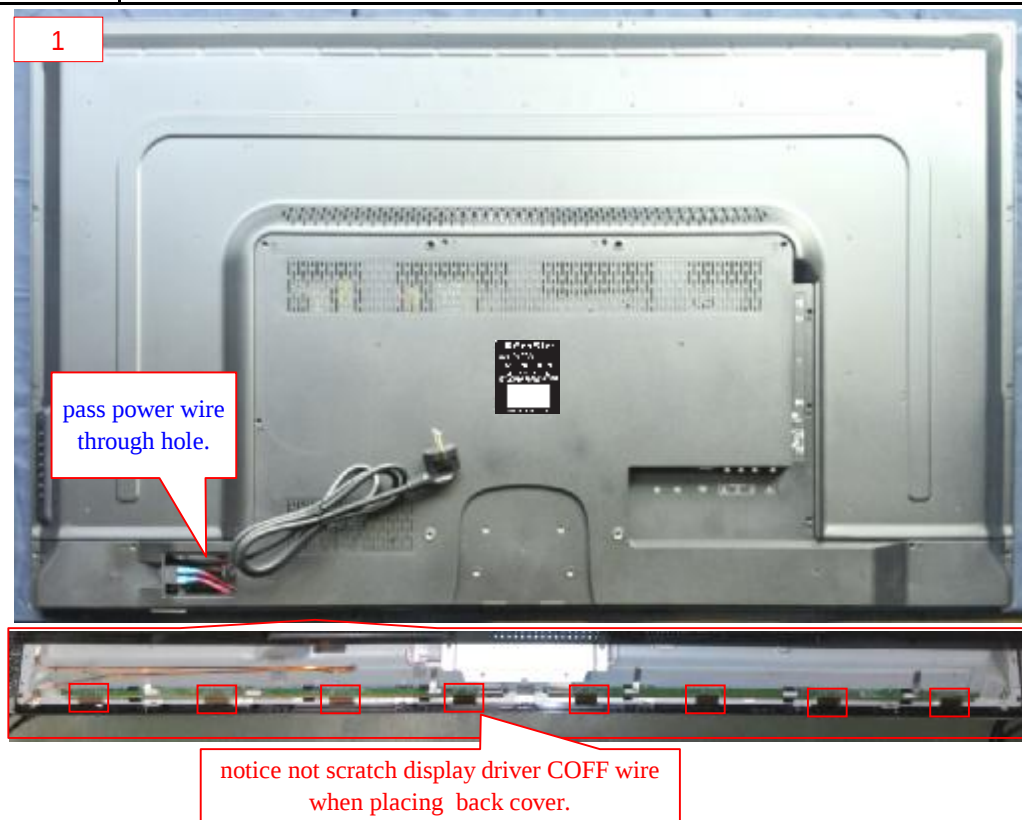


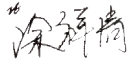
- Process Inspection Requirements:
1. Connection wires being missed to insert, misplaced, inserted reversely or inserted not in place are not allowed and also do not touch high-power components such as power board and mainboard.
 2. Screws can not be missed to install, tilted or made loose; do not drop any screw into PCB board or power board.
 3. Keyboard not locked into place or keys hard to be pressed is not allowed.
 4. Viscose paper must be attached in the shape of “Ω”, without edges and corners curling up.
 5. Connection wires in the machine must be strictly arranged according to the process requirements and keep all wires away from transformer and cushion.
 6. Is the connection wire properly inserted into power switch?
 7. Make sure no any sundries are left in the machine.
 8. Do not change the process and plan at will.
 9. Make sure no abnormalities occurs in the machine.

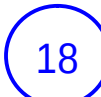
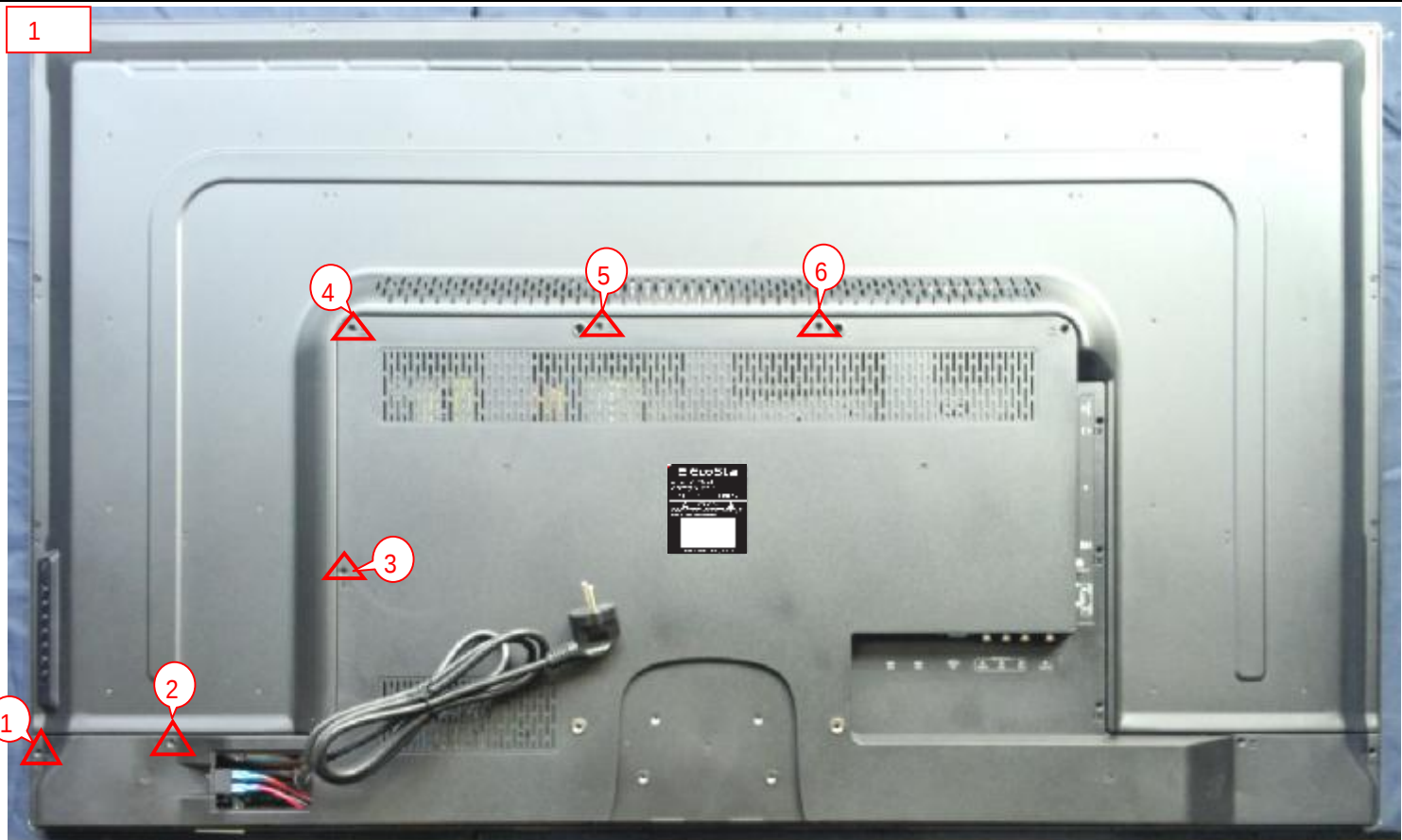
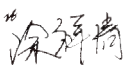
Engineering controlled seal

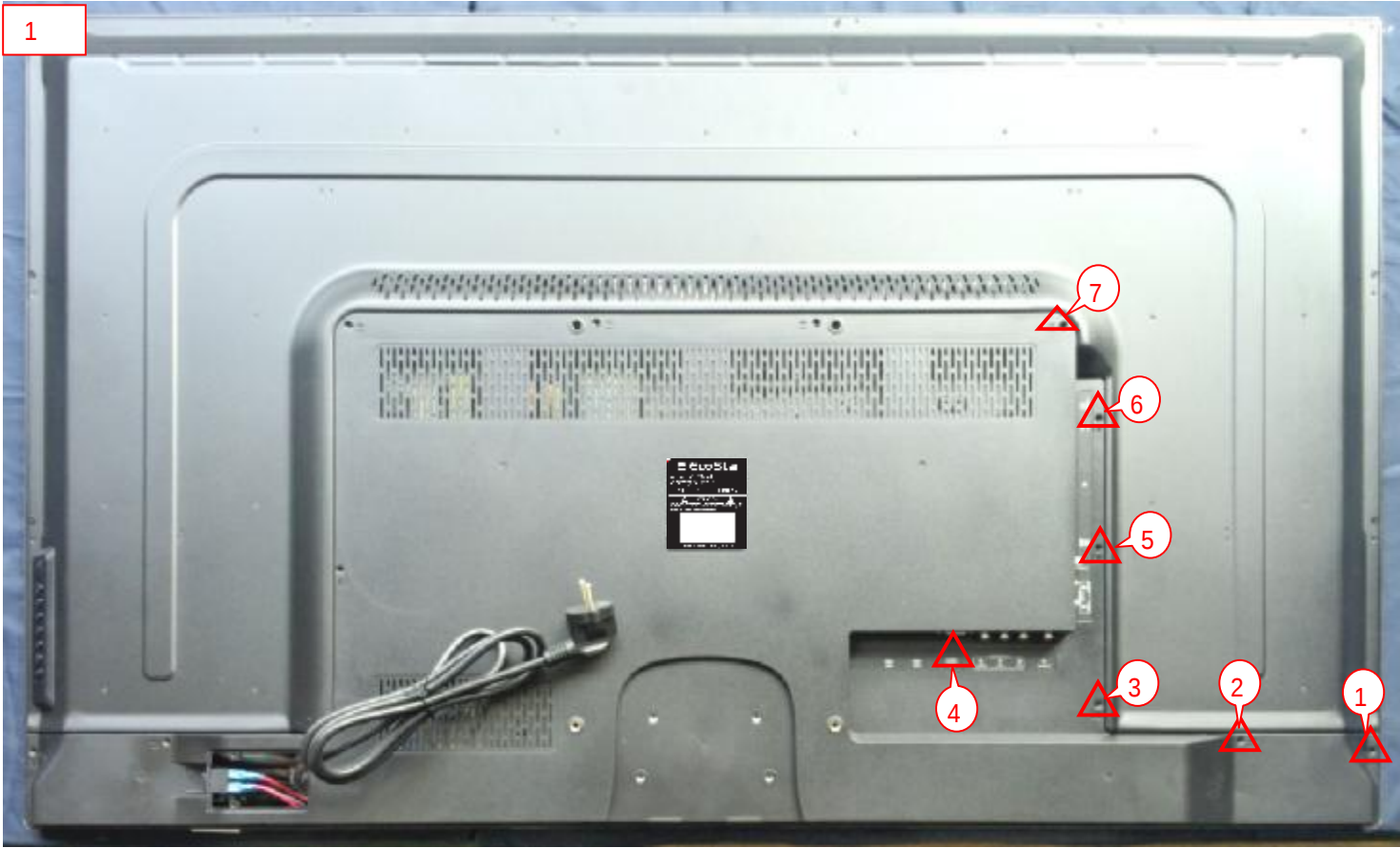
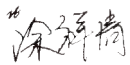
Modify records	Please read and understand the operating instructions carefully	Prepare	Verify	Approve
		Liu Xiaojun		

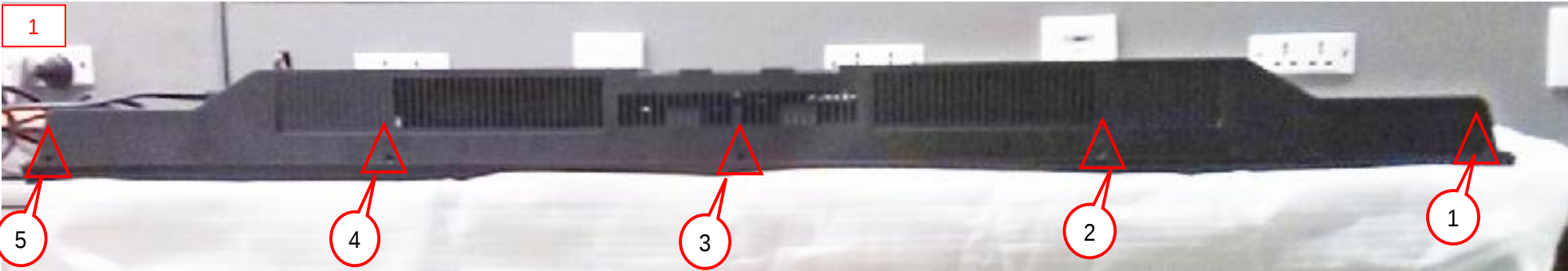
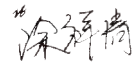
Station name		Back Cover Placement		Model	49L71F	Series/NO.	Machine assemble 17	Document NO.	ITA460217	Version	v5.0	
				Program	T8 V59	Working hrs	27s	Effective date	2014/9/15	Update date	2014/9/15	
NO	Material number	Amount	Description			Working contents and requirements				Mark figure	Tool parameter	
1		1	pre process OK back cover module			take back cover, check its appearance to make sure no damage or scratch etc.				figure 1		
2						pass powre wire from back cover hole open position , pass through to outside.				figure 1		
3			prevail with production order			insert back cover red and black speaker wire connecting wire on main board R-OUT socket, yellow and black speaker connecting wire inserted on mainboard L-OUT socket.				figure 2/A		
4						click foot switch to let it flow to the next station after self check OK.						
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.							 			
		2.Wear static ring during operation.										



Modify records		Please read and understand the operating instructions carefully	Prepare	Verify	Approve	Engineering controlled seal
			Liu Xiaojun			

Station name		Locking Back Cover-A			Model	49L71F	Series/NO.	Machine assemble 18	Document NO.	ITA460218	Version	v5.0			
					Program	T8 V59	Working hrs	27S	Effective date	2014/9/15	Update date	2014/9/15			
NO	Material number	Amount	Description				Working contents and requirements				Mark figure	Tool parameter			
1	7B11-030616-00105111	6	Φ3×6mm Screw				use 6PCS screws to lock back cover and surface frame together.				figure 1 	electric driver 4±1kgfcm			
2		prevail with production order				click foot switch to let it flow to the next station after self check OK.									
3															
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.													
		2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.													
		3. Wear static ring during operation.													
															
Process Requirements: 1. Check for rusted screws, missing slots or bad cross slot. 2. Check if the electric screwdriver torque force is within the specified requirements. 3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt). 4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw. 5. Put the defective screws in the defective product box and do not throw them everywhere.															
Engineering controlled seal															
Modify records					Please read and understand the operating instructions carefully		Take only one screw at a time		Prepare	Verify	Approve				
									Liu Xiaoju						

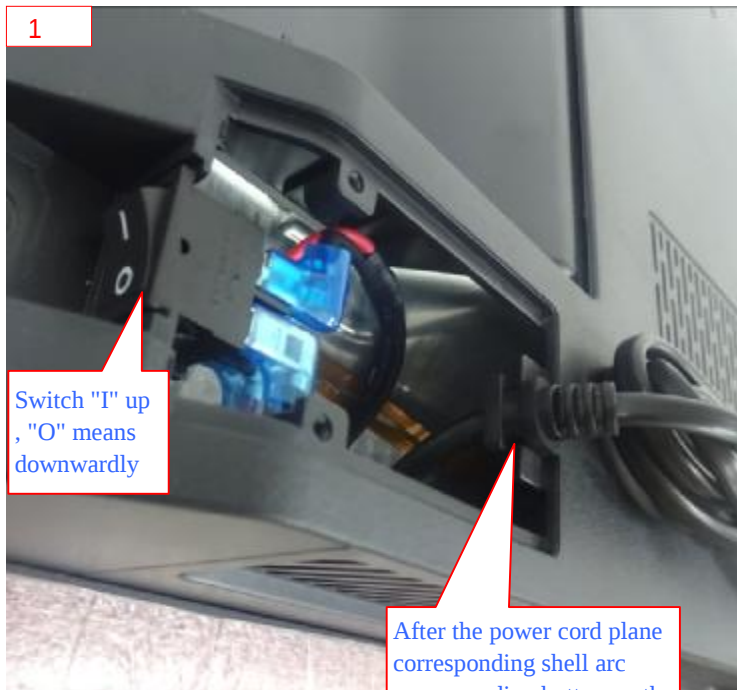
Station name	Locking Back Cover-B			Model	49L71F	Series/NO.	Machine assemble 19	Document NO.	ITA460219	Version	v5.0
				Program	T8 V59	Working hrs	28S	Effective date	2014/9/15	Update date	2014/9/15
NO	Material number	Amount	Description	Working contents and requirements					Mark figure	Tool parameter	
1	7B11-030616-00105111	7	Φ3×6mm Screw	use 7PCS screw to lock back cover and frame together.					figure 1 ▲	electric driver	
2			prevail with production order	click foot switch to let it flow to the next station after self check OK.						4±1kgfcm	
3											
Notices				1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List. 2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed. 3. Wear static ring during operation.					 	19	
1  Process Requirements: 1. Check for rusted screws, missing slots or bad cross slot. 2. Check if the electric screwdriver torque force is within the specified requirements. 3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt). 4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw. 5. Put the defective screws in the defective product box and do not throw them everywhere.											
Modify records				Please read and understand the operating instructions carefully		Take only one screw at a time		Prepare	Verify	Approve	Engineering controlled seal
								Liu Xiaoju			

Station name	Locking Back Cover-C			Model	49L71F	Series/NO.	Machine assemble 20	Document NO.	ITA460220	Version	v5.0
				Program	T8 V59	Working hrs	27S	Effective date	2014/9/15	Update date	2014/9/15
NO	Material number	Amount	Description	Working contents and requirements					Mark figure	Tool parameter	
1	7B11-0310A6-00105111	5	Φ3×10mm Screw	use 5PCS screw to lock back cover and frame together.					figure 1 ▲	electric driver	
2		prevail with production order		click foot switch to let it flow to the next station after self check OK.						4±1kgfcm	
3											
Notices				1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List. 2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed. 3. Wear static ring during operation.					 	20	
 Process Requirements: 1. Check for rusted screws, missing slots or bad cross slot. 2. Check if the electric screwdriver torque force is within the specified requirements. 3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt). 4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw. 5. Put the defective screws in the defective product box and do not throw them everywhere.											
				Modify records Please read and understand the operating instructions carefully Take only one screw at a time Prepare Verify Approve							
				Liu Xiaojun  							

Station name	Locking Power Wire Cover	Model	49L71F	Series/NO.	Machine assemble 21	Document NO.	ITA460221	Version	v5.0
		Program	T8 V59	Working hrs	26S	Effective date	2014/9/15	Update date	2014/9/15

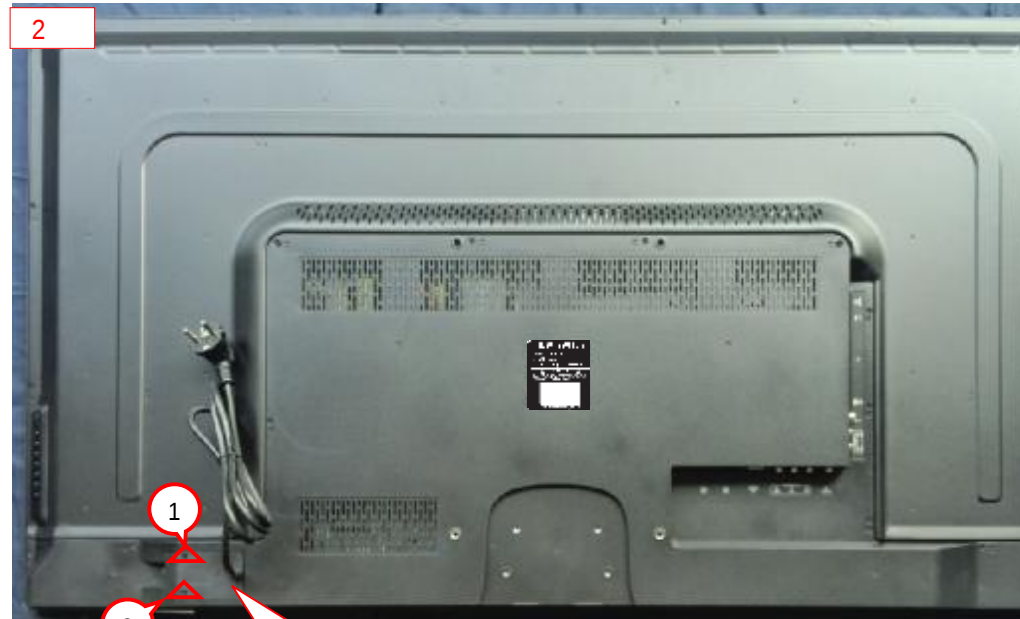
NO	Material number	Amount	Description	Working contents and requirements	Mark figure	Tool parameter
1				Install power wire buckle to back cover slot.	figure 1	Electric driver
2			prevail with production order	install rocker power switch to back cover slot.	figure 1	3±0.5kgfcm
3	7057-42L71F-44B01101	1	Cover plate for wire	take power wire cover, install it on back cover , use 2PCSΦ3×10mm screw to lock power wire cover on back cover.	figure 2 ▲	
4	7B11-031013-00105111	2	Φ3×10mm Screw	click foot switch to let it flow to the next station after self check OK.		

Notices	1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.				21
	2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.				
	3. Wear static ring during operation.				



Switch "I" up, "O" means downwardly

After the power cord plane corresponding shell arc corresponding button on the switch mounted on back cover

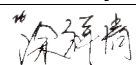
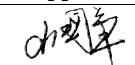


power wire cover

if customers have special requirements after conditioning to add bar code affixed to the screen at the back , can cover the power cord to move the packaging segment locked.

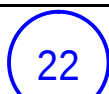
Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them everywhere.

Modify records	Please read and understand the operating instructions carefully	Take only one screw at a time	Prepare	Verify	Approve
			Liu Xiaojun		

Engineering controlled seal

KTC[®] Operating Instructions

Station name		Power On Machine		Model	49L71F	Series/NO.	Machine assemble 22	Document NO.	ITA460222	Version	v5.0
				Program	T8 V59	Working hrs	26s	Effective date	2014/9/15	Update date	2014/9/15
NO	Material number	Amount	Description	Working contents and requirements						Mark figure	Tool parameter
1				after check the last station operation OK, insert related power wire head to related tooling board power socket, turn on machine, power it on.						figure 1	
2				catch machine left and right side of frame and display back (do not touch display side) rotate machine,make display side up, back cover down put in the middle of tooling board ,apply tooling board bandage on machine as figure.						figure 1	
3				click foot switch to let it flow to the next station after self check OK. (aging)							
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.									
		2.Machine display side up put in the middle of tooling board with bandage applied well to avoid and damage during moving.									
		3.Wear static ring during operation.									



Engineering controlled seal

Modify records

Please read and understand the operating instructions carefully

Prepare

Liu Xiaojun

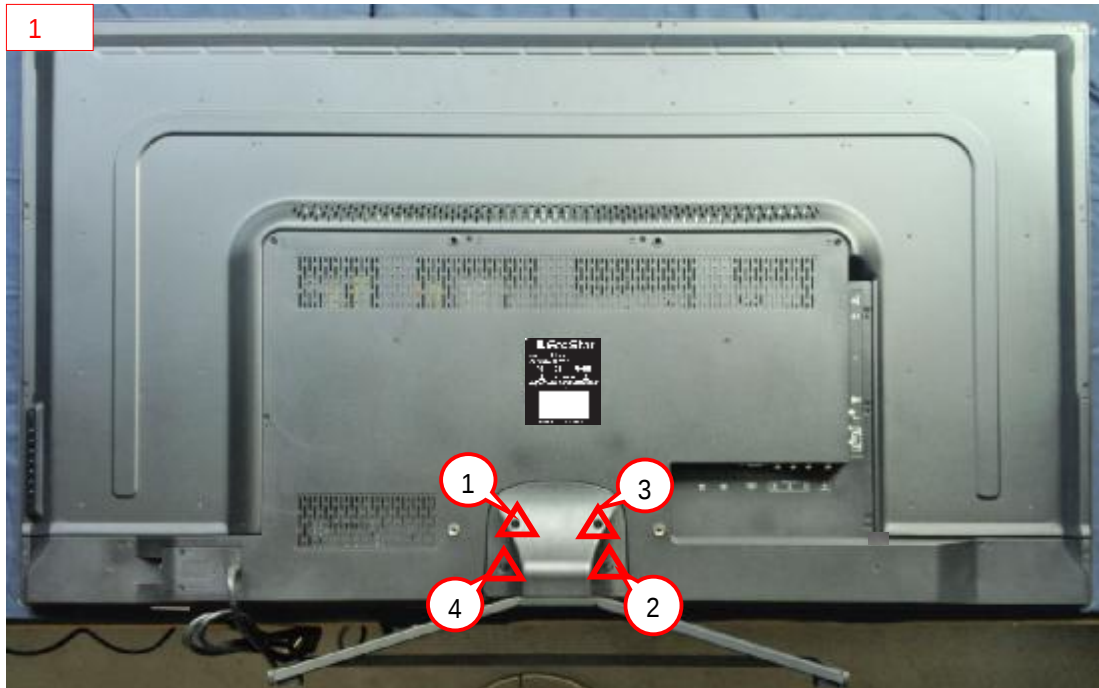
Verify

徐晓军

Approve

胡军

Station name		Locking Base		Model	49L71F	Series/NO.	Machine assemble 23	Document NO.	ITA460223	Version	v5.0
				Program	T8 V59	Working hrs	27s	Effective date	2014/9/15	Update date	2014/9/15
NO	Material number	Amount	Description		Working contents and requirements				Mark figure	Tool parameter	
1		1	process finished OK base		take 1PC finished base, check its appearance.				figure 1	electric driver 7±1kgfcm	
2	7B11-041696-20105111	4	Φ4×16mm Screw		install OK base on the bottom of machine.				figure 1		
3			prevail with production order		take 4PCS Φ4×16mm screw, lock them on support back board.				figure 1△		
4					after self check OK, catch two sides of frame with hands (do not touch any display part)set machine up, rotate it to make display side in fron of the operator, put the whole set in the middle of tooling board, click foot switch to flow it to next station.				figure 2		
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.									
		2. Install screws by the serial number (install one by one) and abnormalities such as screws being neglected, tilted and slipped are not allowed.									
		3.Wear static ring during operation.									



catch two side of frame, do not scratch any part of display

Process Requirements:

1. Check for rusted screws, missing slots or bad cross slot.
2. Check if the electric screwdriver torque force is within the specified requirements.
3. When installing screws, align the electric screwdriver and the screw to the screw hole vertically (do not tilt).
4. In the process of installing screws, properly exert pressure to make a close contact between electric screwdriver and screw slot to avoid slipped screw.
5. Put the defective screws in the defective product box and do not throw them everywhere.

Engineering controlled seal

Modify records		Please read and understand the operating instructions carefully	Take only one screw at a time	Prepare	Verify	Approve
				Liu Xiaoju	