


Update Revision Record Information
Electronic record is the master - stored on Shared Drive

Revision Record Information

Level	Date	By	Changes made
0-Rel	10/8/2007	Thomas Grinton	Released for production
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Operator Instructions

	MOLD:		PART NUMBER:	400782
	CUST:	Digistar	PART NAME:	Housing
				Page 1 of 2

SPECIAL INSTRUCTIONS / HOUSEKEEPING & SAFETY

1. Keep Work Area Clean.
 2. Report any Safety issues immediately to your Supervisor.
- 1. Mantenga Area de Trabajo Limpia.*
2. El informe cualquier asuntos de la Seguridad inmediatamente a su Supervisor.

OPERATOR 1 INSPECTION INSTRUCTIONS

1. Visually inspect part according to First Piece and or any boundary samples for molding defects.
 2. Verify gates are trimmed off, flush on acceptable parts.
- 1. Inspeccione visualmente la parte según Primero Pedazo y o cualquier muestras de la frontera para moldear los defectos.*
2. Verifique puertas son cortadas, limpian en partes aceptables.

GENERAL GLOBAL INSTRUCTIONS

If there are 3 defects in a row / 5 defects within one (1) hour, notify Production Supervisor
Si hay 3 defectos en una fila/5 defectos dentro de uno (1) hora, notifica a Supervisor de Producción

Materials needed

Heated Cutters Razor Knife 6-32X.25 Insert (Sides A & B) 8-32X.312 Insert (Side C)
 48" X 40" Wooden Skid 20" X 28" X 22" Boxes

Operator



Allow mold to open, remove part, close door, inspect for Flash, Sinks, Short Shots, Splay. Re grind parts that do not pass inspection. *Permita el molde para abrir, quitar la parte, cierre puerta, inspecciona para el Destello, los Fregaderos, los Disparos Cortos, Derrame. Re grind despide eso no pasa la inspección.*













Remove large gate ends with heated cutters. Cut must be flush.
Quite talonario grande de puerta con cortadores calentados. ¡El corte debe ser parejo!




Trim excess flash off sides of part with razor knife. *Recorte el destello del exceso de lados de la parte con cuchillo de navaja.*



After trimming, place part on sonic welder. Place threaded insert in hole and press both buttons until insert is flush. Use wooden block to support part as shown. *Después de que recortar, coloque la parte en el soldador sónico. El lugar enhebró la adición en el hoyo y aprieta ambos botones hasta que la adición sea pareja. Utilice el bloque de madera para sostener la parte como mostrado.*

Personal Equipment Checklist	Eye Protection	Hand Protection	Ear Protection	Other	Key Symbol	Delta Critical	Quality Check	Mistake Proof Sheet	Visual Inspection	Secondary Equipment Required	LH/RH Separation Required
											
	X								X		X
Document						Revision Number 0			Date 10/8/2007		

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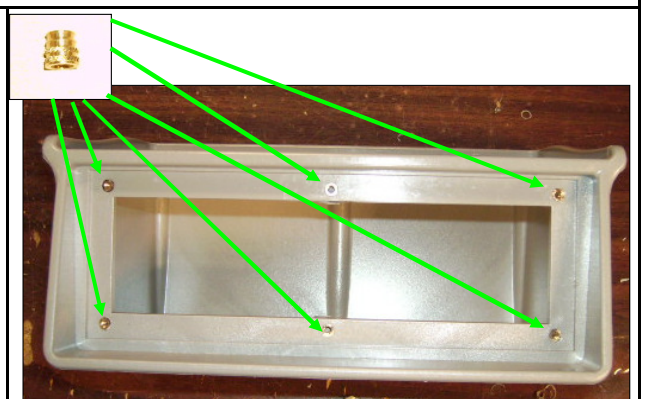
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Materials needed

Operator













Side B uses 6 of the 6-32X.25 insert. They go in the holes shown here. *El lado B utiliza 6 del 6-32X.25 la adición. Ellos entran los hoyos mostrados aquí.*

Side A uses 6 of the 6-32X.25 insert. They go in the holes shown here. *El lado A utiliza 6 del 6-32X.25 la adición. Ellos entran los hoyos mostrados aquí.*



Side C uses 3 of the 8-32X.312 insert. They go in the holes shown here. *El lado C utiliza 3 de la adición 8-32X.312. Ellos entran los hoyos mostrados aquí.*

Package parts as shown, 20 pieces per box. *El paquete despide como mostrado, 20 pedazos por caja.*

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