

[SWAN] Assembly process improvement

SH Son

Model Name: BFX-UA300

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• Screw torque

- I think it would be ok to adjust the screw torque as below
- Please review and feedback to us.

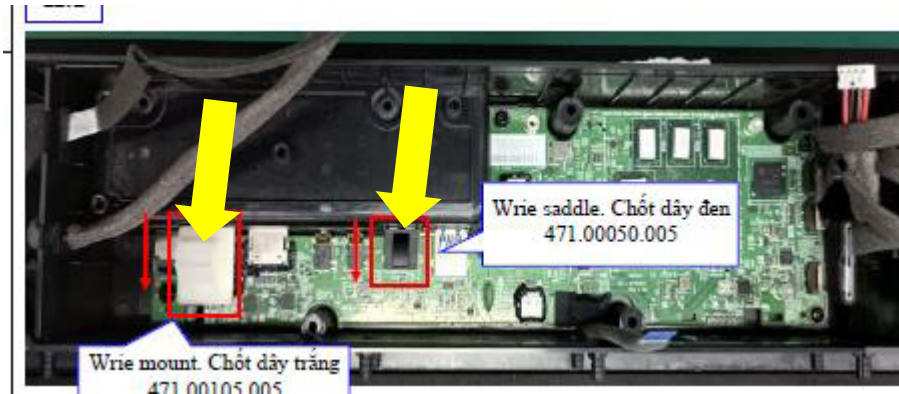
Assembly S OP	Page						
			as is	To be			q'ty
		5 speaker assembly	Locking torque: 4.0±0.5kgf*cm	Locking torque: 3.5±0.5 kgf*cm	401.01459.005	SCREW TAP PAN M3 10mm REV.01 GP	12
		6 Side led bracket assembly	Locking torque: 3.5-4.0 kgf*cm	Locking torque: 3.5±0.5 kgf*cm	401.01459.005	SCREW TAP PAN M3 10mm REV.01 GP	2
		7 side led pcab	Locking torque: 3.5-4.0 kgf*cm	Locking torque: 3.5±0.5 kgf*cm	401.01459.005	SCREW TAP PAN M3 10mm REV.01 GP	4
		8 deco bracket	Locking torque: 3.5-4.0 kgf*cm	Locking torque: 3.5±0.5 kgf*cm	401.01459.005	SCREW TAP PAN M3 10mm REV.01 GP	4
		12 Main PCBA with housing'	Locking torque: 2.8±0.5kgf*cm	Locking torque: 3.5±0.5 kgf*cm	401.01342.005	SCREW TAP PANWASHER M3 8mm REV.00 GP	5
		14 Heat spreader soc top	Locking torque: 3.5±0.5 kgf*cm	Locking torque: 3.5±0.5 kgf*cm	401.00634.005	SCREW MECH FLAT M2.5 5mm REV.A GP/HF	4
		15 LED PCBA with housing	Locking torque: 3.0±0.5kgf*cm	Locking torque: 3.5±0.5 kgf*cm	401.01460.005	SCREW TAP PAN M3 7mm REV.01 GP	6
		16 Heat spreader soc top / housing	Locking torque: 3.0±0.5kgf*cm	Locking torque: 3.5±0.5 kgf*cm	401.01460.005	SCREW TAP PAN M3 7mm REV.01 GP	4
		17 Heat spreader Amp top & Amp PCBA	Locking torque: 5±0.5kgf*cm	Locking torque: 5±0.5kgf*cm	401.00021.005	SCREW MECH PAN M3 6mm BLACK REV.A GP	8
		18 Button PCBA assembly	Locking torque: 3.0-4.0kgf*cm	Locking torque: 3.5±0.5 kgf*cm	401.01460.005	SCREW TAP PAN M3 7mm REV.01 GP	3
		18 Holder Mic assembly	Locking torque: 3.0-4.0kgf*cm	Locking torque: 3.5±0.5 kgf*cm	401.01342.005	SCREW TAP PANWASHER M3 8mm REV.00 GP	8
		19 Heat spreader Amp bottom	Locking torque: 3.0±0.5kgf*c	Locking torque: 3.5±0.5 kgf*cm	401.01460.005	SCREW TAP PAN M3 7mm REV.01 GP	5
		20 top / bottom assembly	Locking torque: 3.8-4.3kgf*cm	Locking torque: 3.5±0.5 kgf*cm	401.01468.005	SCREW TAP FLAT M3 12mm REV.00 GP	2
		21 top / bottom assembly	Locking torque: 3.8-4.3kgf*cm	Locking torque: 3.5±0.5 kgf*cm	401.01459.005	SCREW TAP PAN M3 10mm REV.01 GP	20
test SOP		6 Plate BTV logo	Lực bắt vít: 3±0.5 kgf*cm	Locking torque: 3±0.5 kgf*cm	401.01460.005	SCREW TAP PAN M3 7mm REV.01 GP	2

Fii-0615:

Update the SOP to factory to do the conterl run

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- Wire mount and wire saddle
 - can be replace 3M tape
 - Please review and feedback to us.

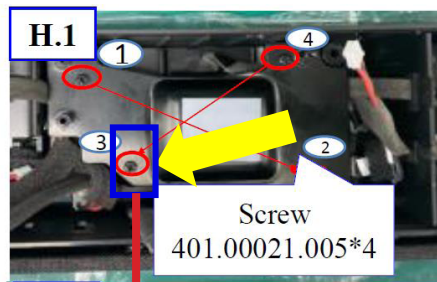


Fii-0615:

Update the SOP to factory to do the control run

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- Skip the screw 1 point due to FFC cable is pressed
 - Please review and feedback to us.



Fii-0615:

It's no use useful just skip the screw on this point, need to cut some metarials to avoid the FFC cable, deed to modify the tool.

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Thank you.

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