



SHENZHEN KTC TECHNOLOGY GROUP

HUIZHOU KTC TECHNOLOGY CO., LTD.

Operation Instructions

Product Name: 24D1S

Prepared by: Bingzhuang Deng

Examined by: _____

Approved by: _____


Date: 2019/10/6

KTC Operation Instructions

Station name	process the speakers		Model	24D1S M2C3 6A358	Station/NO.	Pre process 01	Document No.		Version	
							Effective from		Date Updated	

NO	Material number	Amount	Description	Working contents and requirements	Mark Figure	Tool parameter
1	7711-B28085-50000014	1	8Ω 5W 22D1/24D1 single inner magnetic horn, right horn	Put a pair of speakers on the table,check to be sure the speakers' lug plates are OK with one end wide the other narrow without oxidation.	Figure 1/2	
2	7711-B28085-50000024	1	8Ω 5W 22D1/24D1 single internal magnetic horn, left horn			
3	6149-450045-03X11203	1	450mm 3Pin (2Pin missing) red-black speaker wire	Put a red-black wire and a yellow-black wire them on the table,check OK.	Figure 3	
4	6149-200045-02101201	1	200mm 2Pin yellow-black speaker wire	Insert the red-black wire into the right speaker's lug plate as figure show.	Figure 4	○
5				Insert the yellow-black wire into the left speaker's lug plate as figure show.	Figure 4	○
6				Check if they are in place,drag gently to make sure no looseness.		
7				After self-check OK,put the OK products on the tray for standby.		

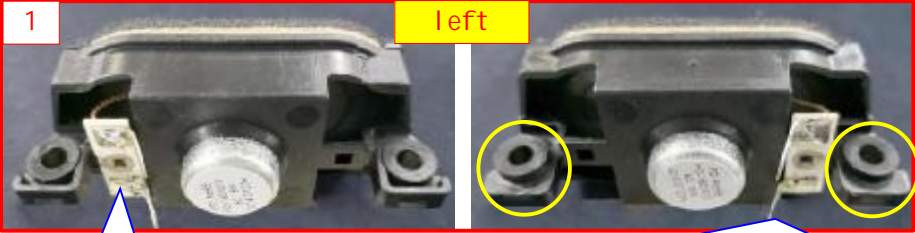
1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.



1

1

left

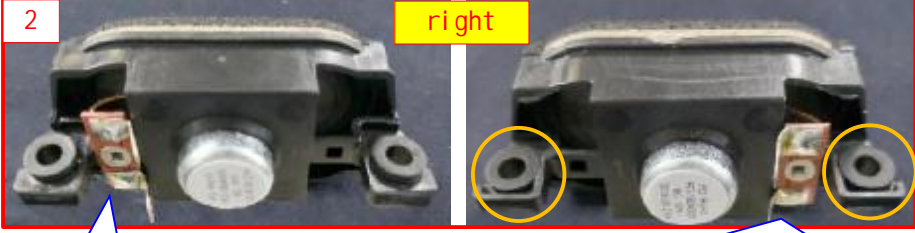


left speaker white terminal

1、 one wide one narrow;
2、 When the left speaker is placed as shown, the lug is flat surface and without bulge edge (yellow circle).

2


right



right speaker red terminal

1、 one wide one narrow;
2、 When the right speaker is placed as shown, the lug is not-flat surface and with bulge edge (orange circle).

3



4

left speaker white terminal

red-black speaker wire

The terminal should be snapped the speaker's lug plate.

yellow-black speaker wire

right speaker red terminal

1.Insert speaker's wire in the lug plate of speaker in place completely.
2.After inserted speaker's wire,maek the sleeve wrap the metal part of connector. Not allow naked metal part on terminal wire.
3.After inserted speaker's wire,gently drag wire to check whether its wire is inserted in place completly.

NG

Not insert in place.

Engineering controlled seal

Modify records		Please read and understand the operating instructions carefully	Prepare	Verify	Approve
			Bingzhuang Deng		



KTC Operation Instructions

Station name	process the remote receive window+keypad		Model	24D1S M2C3 6A358	Station/NO.	Pre process 02	Document No.		Version	
							Effective from		Date Updated	

NO	Material number	Amount	Description	Working contents and requirements	Mark Figure	Tool parameter
1	9015-112000-01031011	1	40D1 remote control receiver board assembly	Take 1PCS remote receive board and 1PCS keypad,check no cold solder.If NG ,put in the NG box.	Figure 1/2	
2	9014-11232C-00003011	1	32C1 model five-way navigation button board assembly			
3	6141-580263-09112301	1	580mm three-terminal 9pin, 4pin, 5pin motherboard to keypad / remote control receiving wire	Insert 1PCS three terminals wire into corresponding sockets of remote receive board and keypad as figure show.	Figure 1/2/3	
4				After self-check OK,put the OK products on the tray for standby.		

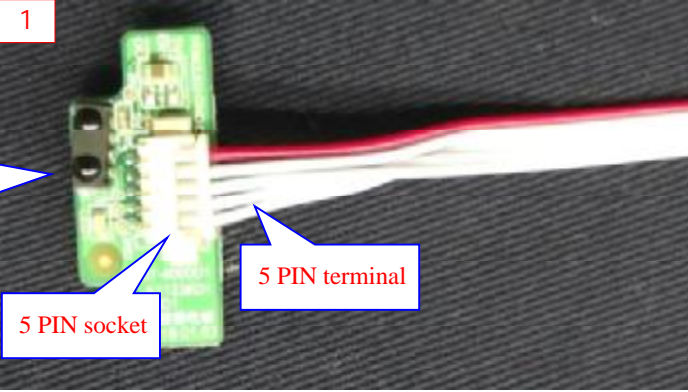
Notices

1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.

2

1

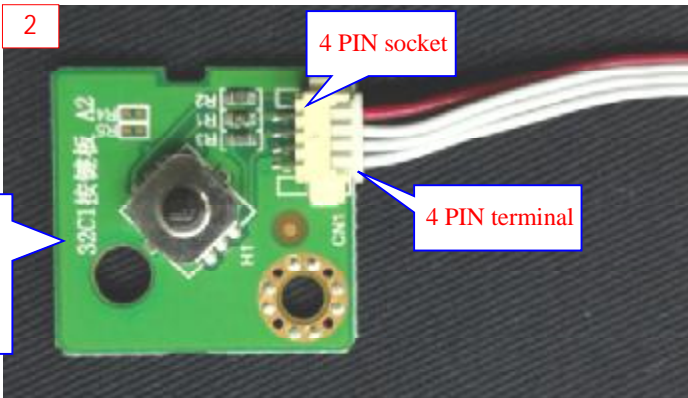


remote control receiver board assembly

5 PIN socket

5 PIN terminal

2

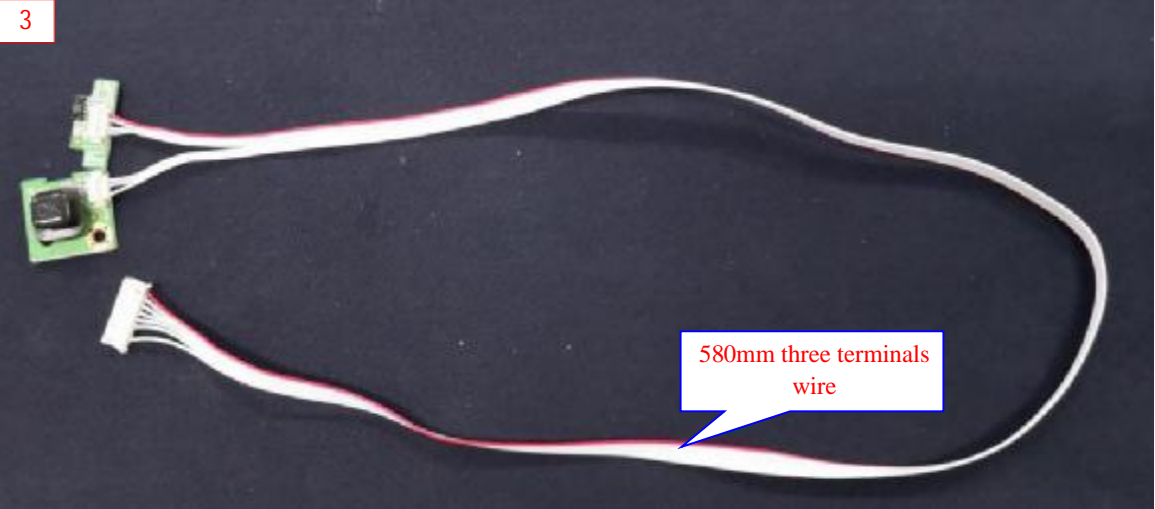


five-way navigation button board assembly

4 PIN socket

4 PIN terminal

3



580mm three terminals wire

Modify records

Please read and understand the operating instructions carefully

Prepare

Bingzhuang Deng

Verify

Approve


Engineering controlled seal

KTC Operation Instructions

Station name	process the lower back cover-paste EVA dust-proof pad		Model	24D1S M2C3 6A358	Station/NO.	Pre process 03	Document No.		Version	
							Effective from		Date Updated	


NO	Material number	Amount	Description	Working contents and requirements	Mark Figure	Tool parameter
1	7002-2400D1-XD000001	1	24D1 Plastic back cover_D	Take out the lower back cover from the carton,remove its packing bag.Check the appearance .Not allow dirt,scratch,deformation. Put NG back cover in the NG box.	Figure 1	
2	7912-311074-0060R501	2	74 × 6mm × 0.5mm 38 degree EVA			
3	7912-322030-0060R511	2	30mm*6mm*0.5mm 38°EVA			
4	7912-322090-0060R511	1	90mm*6mm*0.5mm 38°EVA	Take EVA dustproof pad,and cut it into appropriate length and then paste it on the front edge of lower back cover..	Figure 2	
5						
6				After self-check OK,deliver the OK products to next station.		

1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.

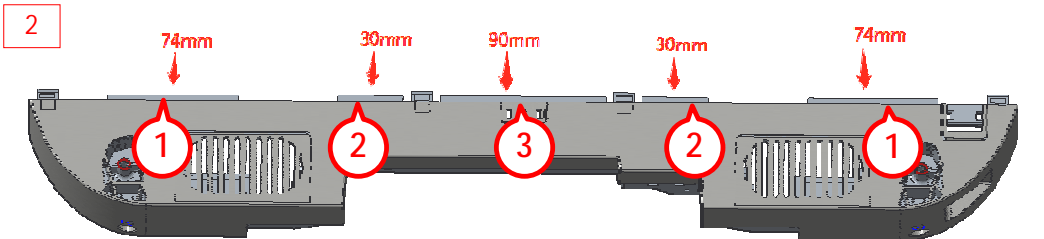


3

1



2



EVA dust-free pad length:

1: 74 × 6mm × 0.5mm

2: 30mm*6mm*0.5mm


3: 90mm*6mm*0.5mm

press the pad with finger to avoid peeling off.

operations:

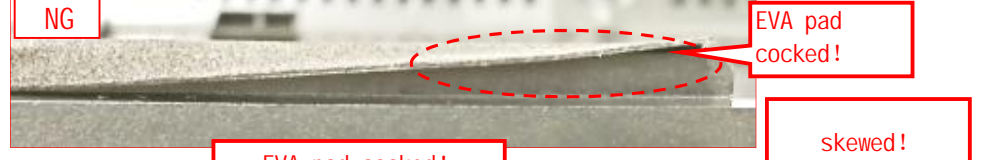
1 person for taking back cover and appearance inspection., 2 persons for pasting EVA dust-proof pad.

OK

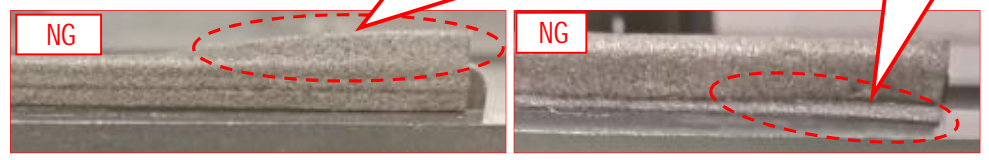


Engineering controlled seal

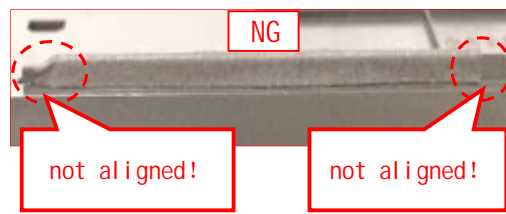
NG




NG



NG



NG



Modify records

Please read and understand the operating instructions carefully





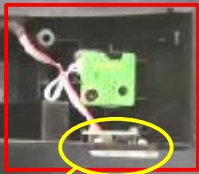

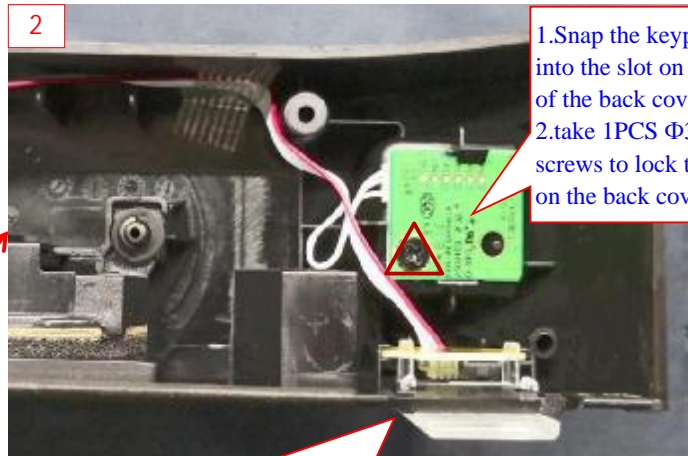
Prepare

Bingzhuang Deng



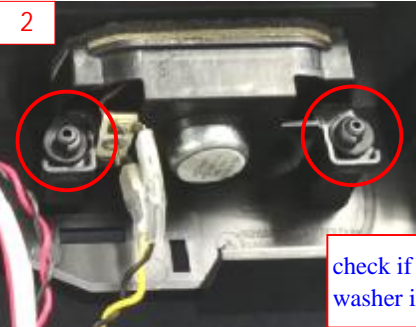
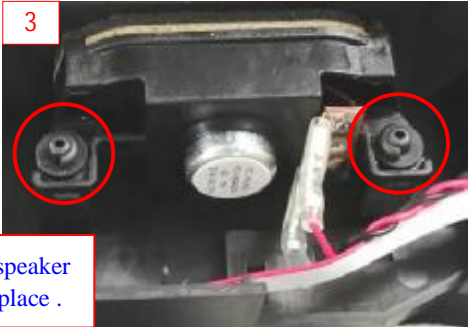

Verify

Approve




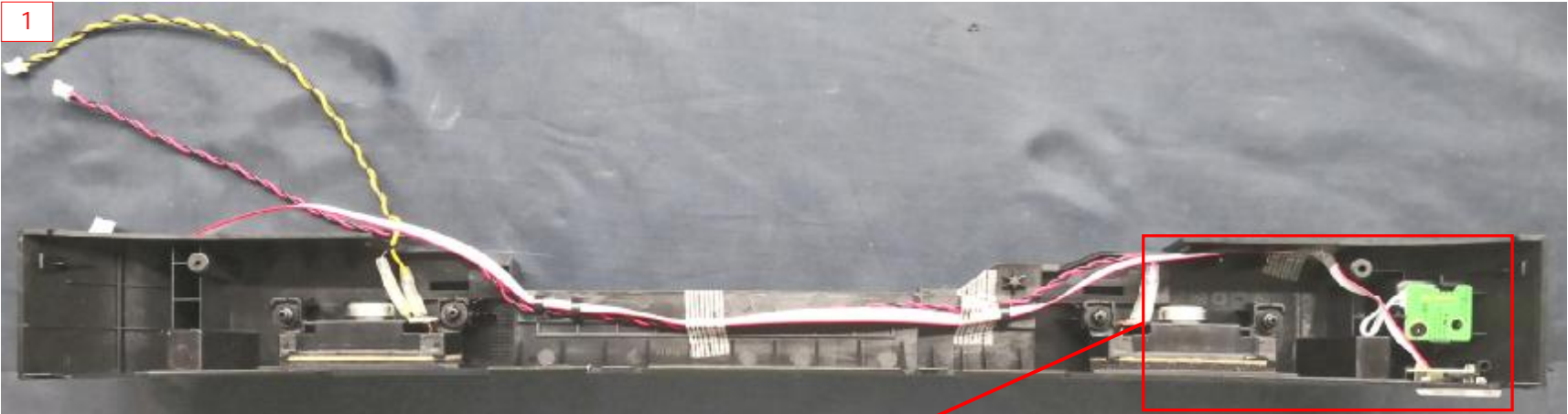
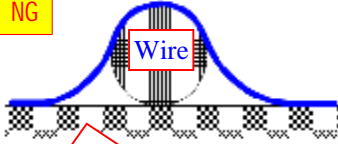
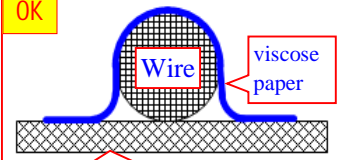
KTC Operation Instructions

Station name	process the lower back cover-remote receive board+keypad assembly			Model	24D1S M2C3 6A358	Station/NO.	Pre process 04	Document No.		Version		
								Effective from		Date Updated		
N0	Material number	Amount	Description			Working contents and requirements			Mark Figure	Tool parameter		
4	7030-3200C1-44B11211	1	32C1 injection molding 26074 black five-way button			Take 1PCS five-way key and install it into the keypad and then snap the assembly into the corresponding slot.			Figure 1/2	electric driver		
5	7034-4000D1-X0000001	1	40D1 remote control receiving window						4±1kgfcm			
6	7B11-030616-00105421	1	Φ3×6mm flat head black zinc self-tapping screws			Take 1PCS Φ3×6mm screw to lock the keypad on the back cover.			Figure 1/2	△		
7	/	1	remote receive board+keypad assembly			After the remote receive board is snapped into the bottom slot of back cover,snap the remote receive window into the bottom hole of back cover.			Figure 1/2			
8												
9						After self-check OK,deliver the OK products to next station.						
Notices						1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.						
<div><div><div>1</div><div></div><div><div>Snap the five-way key into the keypad in place.</div><div></div><div></div><div><div>Snap the remote receive window into the slot on the bottom of the back cover in place.</div><div></div></div><div><div>operations: 1 person for processing remote receive board,1 persons for processing keypad assembly.</div></div></div><div><div>2</div><div></div><div><div>1.Snap the keypad assembly into the slot on the bottom of the back cover in place.; 2.take 1PCS Φ3×6mm screws to lock the keypad on the back cover.</div><div><div>3.Snap the remote receive board assembly into the slot on the bottom of the back cover in place. 4.Snap the remote receive window into from the bottom of the back cover and make the remote receive board get stuck.</div></div></div></div><div>Engineering controlled seal</div></div></div>												
Modify records	Please read and understand the operating instructions carefully					Prepare	Verify	Approve				
						Bingzhuang Deng						

KTC Operation Instructions


Station name	process the lower back cover-install the speakers		Model	24D1S M2C3 6A358	Station/NO.	Pre process 05	Document No.		Version									
							Effective from		Date Updated									
NO	Material number	Amount	Description		Working contents and requirements			Mark Figure	Tool parameter									
1	/	1	well preprocessed left speaker module		Take the red-black wire speaker and yellow-black wire speaker assemblies to check whether the speaker wires are inserted well.													
2	/	1	well preprocessed right speaker module															
3					The red-black speaker assembly is on the right,the yellow-black speaker assembly is on the left.			Figure 1										
4																		
5					After self-check OK,deliver the OK products to next station.													
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.								<div style="border: 1px solid blue; border-radius: 50%; width: 40px; height: 40px; display: flex; align-items: center; justify-content: center; margin: 0 auto;">5</div>								
<div style="display: flex; justify-content: space-between;"> <div style="width: 48%;"> <p>1</p>  </div> <div style="width: 48%;"> <div style="display: flex; justify-content: space-around;"> <div style="width: 45%;"> <p>2</p>  </div> <div style="width: 45%;"> <p>3</p>  </div> </div> <div style="width: 45%;"> <p>NG</p>  </div> </div> </div>																		
Modify records		Please read and understand the operating instructions carefully				Prepare	Verify	Approve	Engineering controlled seal									
						Bingzhuang Deng												

KTC Operation Instructions

Station name	process the lower back cover-wire arrangement 1		Model	24D1S M2C3 6A358	Station/NO.	Pre process 06	Document No.		Version	
							Effective from		Date Updated	
NO	Material number	Amount	Description		Working contents and requirements			Mark Figure	Tool parameter	
1	7912-723110-015R1514	1	0.15mm×15mm×110m viscose paper (length: 30mm)		Wiring as figure show.			Figure 1	tape machine	
2					Take 1PCS 30mm fiber tape to fix the wire as figure show.			Figure 2 		
3										
4										
5					After self-check OK,put the OK products on the material shelf for standby.					
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.								
		2.Viscose paper must be attached in the shape of “Ω”, without edges and corners curling up.								
<div style="display: flex; justify-content: space-between;"> <div style="width: 70%;">  <div style="position: absolute; top: 368px; left: 38px; border: 1px solid red; padding: 2px;">1</div> <div style="position: absolute; top: 668px; left: 298px; border: 1px solid red; padding: 2px;">2</div> <div style="position: absolute; top: 688px; left: 558px; border: 1px solid red; padding: 2px;">Do not exceed back cover</div> </div> <div style="width: 28%;"> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <p>Illustration for sticking viscose paper</p> <p>NG</p>  <p>Viscose paper will easily come off over time if not sticked in place</p> </div> <div style="border: 1px solid red; padding: 5px;"> <p>OK</p>  <p>Stick viscose paper as illustrated</p> </div> </div> </div>										
Engineering controlled seal										
Modify records	Please read and understand the operating instructions carefully				Prepare	Verify	Approve			
					Bingzhuang Deng					


KTC Operation Instructions

Station name	process the lower back cover-wire arrangement 2 (EMC)		Model	24D1S M2C3 6A358	Station/NO.	Pre process 07	Document No.		Version	
							Effective from		Date Updated	

NO	Material number	Amount	Description	Working contents and requirements	Mark Figure	Tool parameter
1	7912-723110-015R1514	1	0.15mm×15mm×110m viscose paper (length: 50mm)	Wiring as figure show.	Figure 1	tape machine
2	7909-1B0R11-03508021	1	35mmW×80mmL×0.1mmT Aluminum foil	Take 1PCS 50mm fiber tape to fix the wire as figure show.	Figure 1 	
3				Take 1PCS aluminum foil to fix the wire as figure show.	Figure 2/3	
4						
5				After self-check OK,put the OK products on the material shelf for standby.		


Notices

1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.
2.Viscose paper must be attached in the shape of “Ω”, without edges and corners curling up.

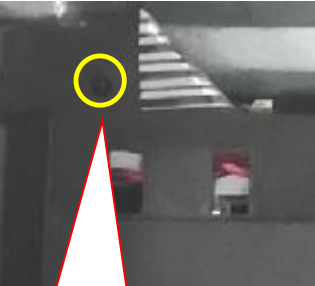


7

1




tightly paste




Note that the tape should not exceed the back cover joint face and should avoid the screw hole

2




The aluminum foil attaches the mainboard to the keypad board, the remote receiver board wire and the red and black horn wire together on the back cover.

3



Note that the aluminum foil must be partially glued to the back cover joint, ensure sufficient effective adhesion area,but not beyond the joint.

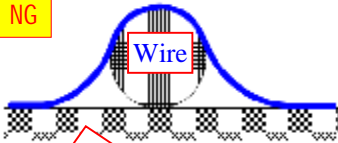
NG



The aluminum foil effective adhesion area is too small, easy to fall off

Illustration for sticking viscose paper

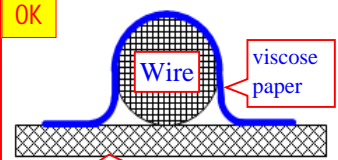
NG



Wire

Viscose paper will easily come off over time if not stuck in place

OK



Wire




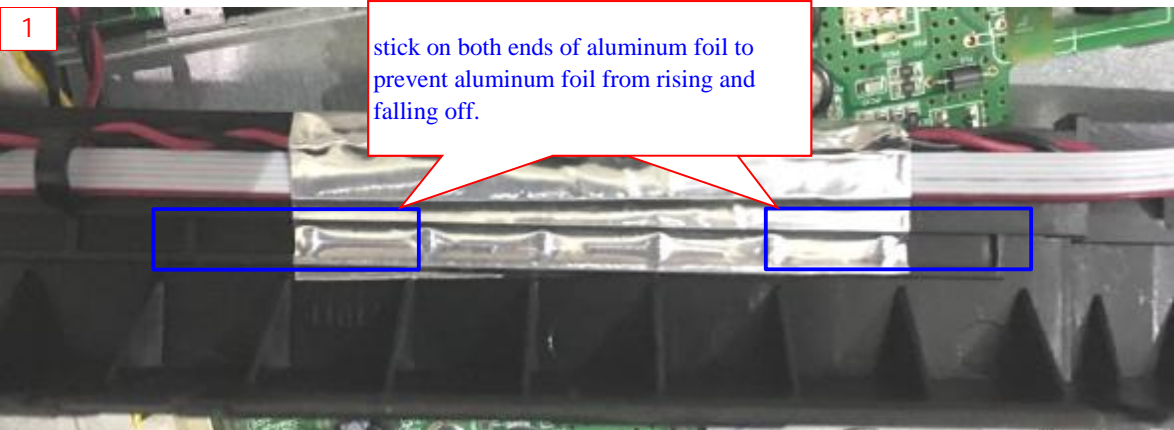

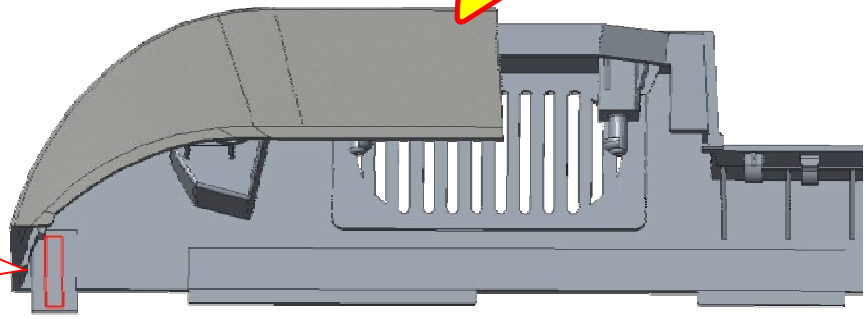
viscose paper

Stick viscose paper as illustrated

Engineering controlled seal


Modify records		Please read and understand the operating instructions carefully	Prepare	Verify	Approve
			Bingzhuang Deng		

KTC Operation Instructions

Station name	process the lower back cover-wire arrangement 3 (EMC)		Model	24D1S M2C3 6A358	Station/NO.	Pre process 08	Document No.		Version							
							Effective from		Date Updated							
NO	Material number	Amount	Description		Working contents and requirements			Mark Figure	Tool parameter							
1	7912-723110-015R1514	2	0.15mm×15mm×110m viscose paper (length: 50mm)		Take 2PCS 50mm fiber tape to fix the aluminum foil as figure show.			Figure 1 	tape machine							
2	7912-111015-0031R801	1	15 ×3 ×1.8mm Shock-proof silicone pad		Take 1PCS silicone pads and attach them to the back of the clasp on the left side of the back cover.			Figure 2 								
3																
4																
5					After self-check OK,put the OK products on the material shelf for standby.											
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.														
		2.Viscose paper must be attached in the shape of “Ω”, without edges and corners curling up.														
<div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="text-align: center;">  <p>1</p> <p>stick on both ends of aluminum foil to prevent aluminum foil from rising and falling off.</p> </div> <div style="text-align: center;">  <p>2</p> </div> </div> <div style="text-align: center; margin-top: 20px;">  <p>Stick the silicone pad on the back side of the clasp on the left side of the back shell, pay attention to align the buckle edge of the card. After it is pasted, press it with appropriate strength to make the silicone pad stick firmly.</p> </div>																
Modify records		Please read and understand the operating instructions carefully				Prepare	Verify	Approve	Engineering controlled seal							
						Bingzhuang Deng										

KTC Operation Instructions


Station name	process the lower back cover-stick wifi antenna		Model	24D1S M2C3 6A358	Station/NO.	Pre process 09	Document No.		Version	
							Effective from		Date Updated	

NO	Material number	Amount	Description	Working contents and requirements	Mark Figure	Tool parameter
1	6150-350001-2195XK01	1	350mm wifi antenna	Tear off the centrifugal paper on the back of the WIFI antenna and stick it in the back shell on the side without button plate,as shown in the figure.	Figure 1/2/3	tape machine
2	7912-723110-015R1514	2	0.15mm×15mm×110m viscose paper (length: 30mm)			
3				Take 2PCS 30mm fiber tape to fix the wire as figure show.	Figure 3 	
4						
5				After self-check OK,put the OK products on the material shelf for standby.		

Notices

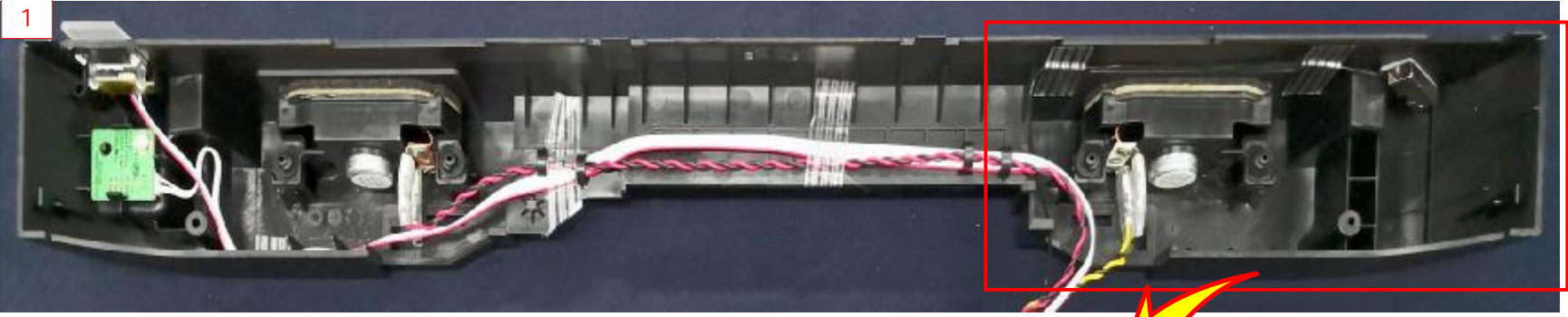
1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.

2.Viscose paper must be attached in the shape of “Ω”, without edges and corners curling up.

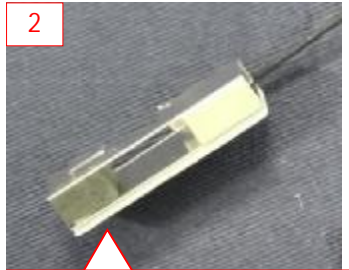


9

1

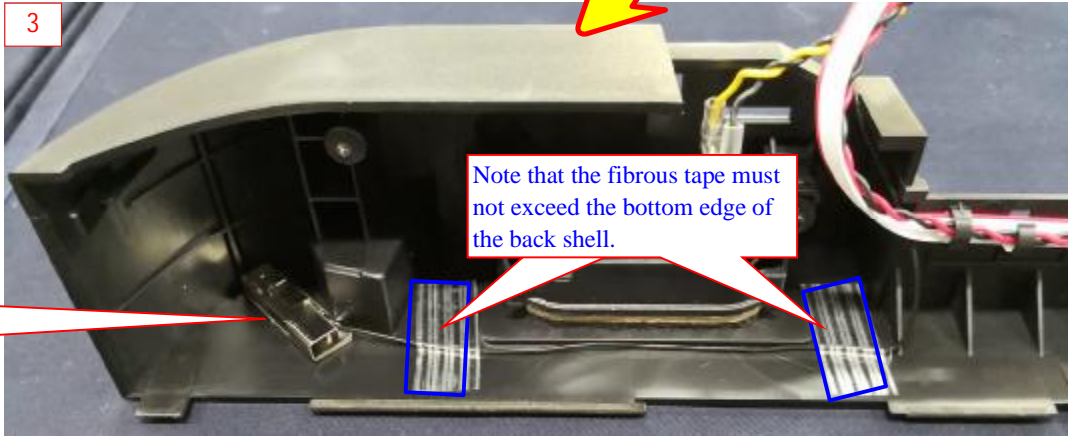


2



Tear off the centrifugal paper on the back of the WIFI antenna and stick it in the back shell on the side without button plate,as shown in the figure.

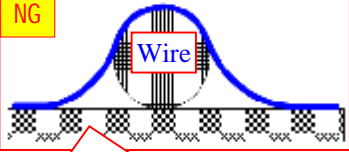
3



Note that the fibrous tape must not exceed the bottom edge of the back shell.

Illustration for sticking viscose paper

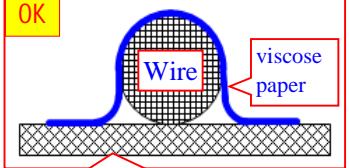
NG



Wire

Viscose paper will easily come off over time if not stuck in place

OK



Wire

viscose paper

Stick viscose paper as illustrated


Engineering controlled seal

Modify records		Please read and understand the operating instructions carefully	Prepare	Verify	Approve
			Bingzhuang Deng		

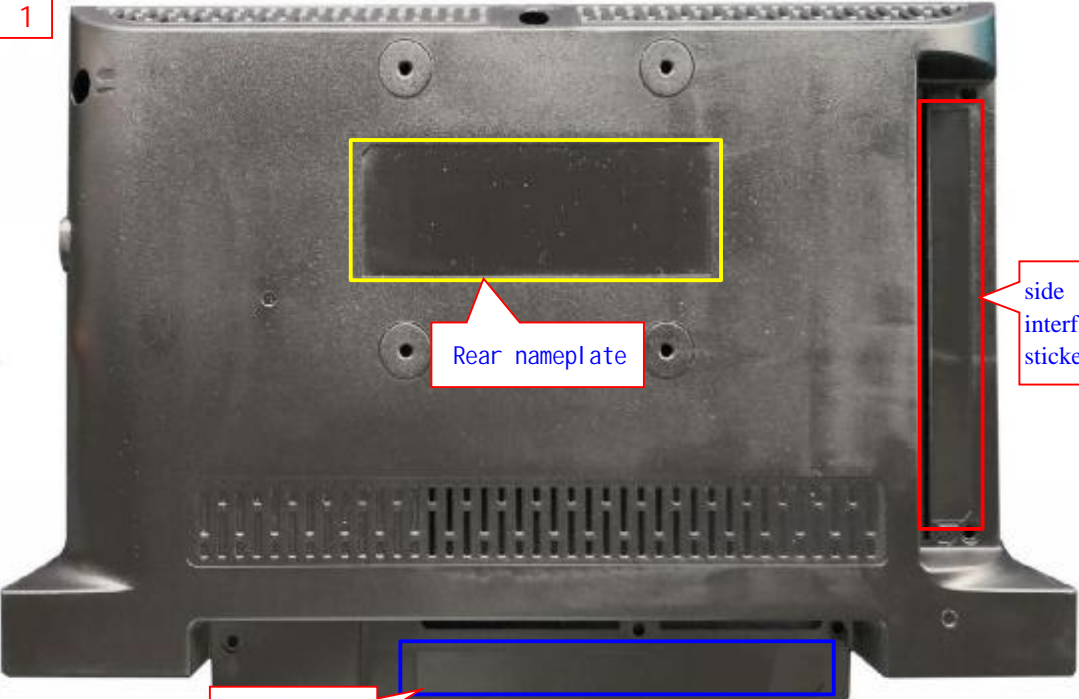
KTC Operation Instructions

Station name	process upper back cover-paste the stickers	Model	24D1S M2C3 6A358	Station/NO.	Pre process 10	Document No.		Version	
						Effective from		Date Updated	

NO	Material number	Amount	Description	Working contents and requirements	Mark Figure	Tool parameter
1	7002-2400D1-XU000001	1	24D1 Plastic back cover_U	Take out the upper back cover from the carton,remove its packing bag.Check the appearance .Not allow dirt,scratch,deformation. Put NG back cover in the NG box.	Figure 1	
2	7372-2400D1-22100041	1	24D1 main board side interface sticker			
3	7372-2400D1-12122001	1	24D1 main board lower interface sticker			
4	7371-2400D1-02MAA401	1	Rear nameplate	Respectively take 1PCS sticker to paste at the corresponding position.	Figure 1	
5						
6				After self-check OK,put the OK products on the material shelf for standby.		

Notices	1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.						<div style="border: 1px solid blue; border-radius: 50%; width: 40px; height: 40px; display: flex; align-items: center; justify-content: center;">10</div>
	2.Notice self check and recheck to avoid any defective product flow to next step.						

1



Rear nameplate

side interface sticker

lower interface sticker

operations:
 1 person for taking back cover and appearance inspection.,1 persons for pasting film.

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


KTC Operation Instructions

Station name	paste EVA pad on side baffle		Model	24D1S M2C3 6A358	Station/NO.	Pre process 11	Document No.		Version	
							Effective from		Date Updated	

NO	Material number	Amount	Description	Working contents and requirements	Mark Figure	Tool parameter
1	7111-4000D1-X00002F1	1	40D1 Hardware baffle plate	Take 2 PCS EVA dustproof dust and then paste it on the baffle side edge, it can not exceed the both sides of side baffle.	Figure 1	
2	7912-311130-0060R501	2	130 ×6mm ×0.5mm EVA			
3						
4						
5				After self-check OK, put the OK products on the material shelf for standby.		

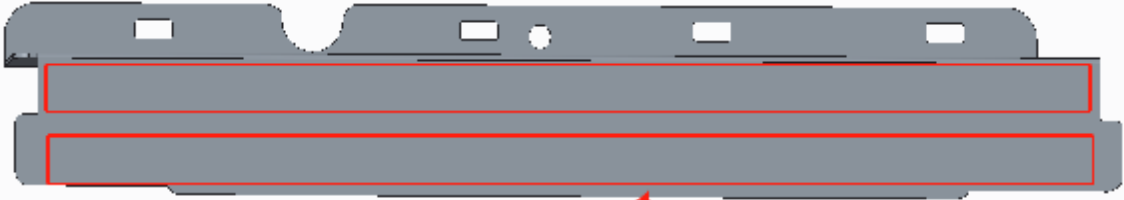
Notices

1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.
2. Notice self check and recheck to avoid any defective product flow to next step.




11

1



130mm 2pcs









Resonance countermeasures

EVA pad along the baffle side edge, it can not exceed the both sides of side baffle.





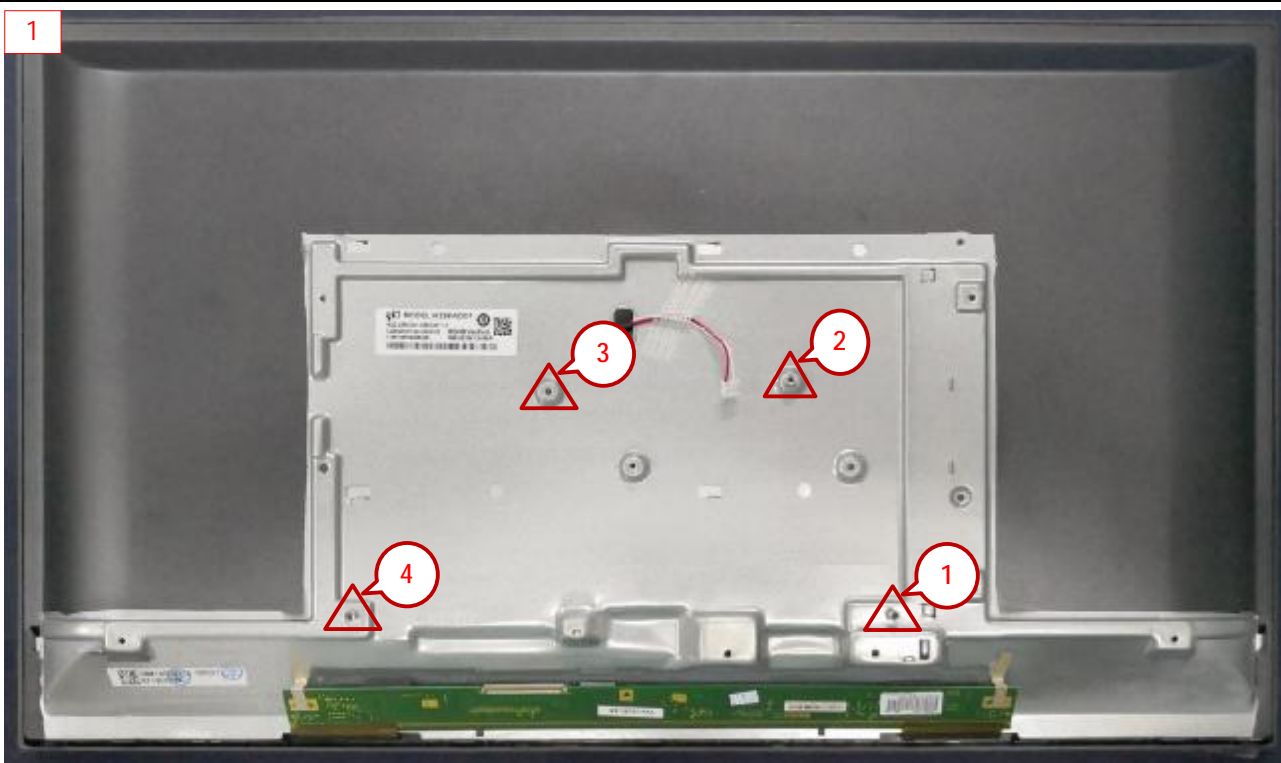
Engineering controlled seal

Modify records		Please read and understand the operating instructions carefully	Prepare	Verify	Approve
			Bingzhuang Deng		

KTC Operation Instructions

Station name	place the panel		Model	24D1S M2C3 6A358	Station/NO.	Machine assemble 01	Document No.		Version	
							Effective from		Date Updated	
NO	Material number	Amount	Description		Working contents and requirements			Mark figure	Tool parameter	
1	7422-2361NK-335AD101-F	1	23.6" TFT KTC K236WDD1-MH180A1 PANEL		Clean tooling plate and make sure no object on it, prevent damage or scratch panel.					
2										
3					Take backlight panel, remove packing protective device, and check its appearance.			Figure 1		
4					Grasp its metal frame. Not allow any object to touch display area.			Figure 2		
5					Make display downward and place on the tooling plate carefully.			Figure 3		
6					After self-check OK, tread foot switch to flow into next station..					
7										
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List. 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, cloth and shoes during operation, avoid static damage display.					  	<div style="border: 1px solid blue; border-radius: 50%; width: 40px; height: 40px; display: flex; align-items: center; justify-content: center; margin: 0 auto;">1</div>		
<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <div style="border: 1px solid red; padding: 2px; margin-bottom: 5px;">1</div>  </div> <div style="text-align: center;"> <div style="border: 1px solid red; padding: 2px; margin-bottom: 5px;">3</div>  </div> </div> <div style="display: flex; justify-content: space-between; margin-top: 20px;"> <div style="width: 30%;"> <div style="border: 1px solid red; padding: 2px; margin-bottom: 5px;">2</div>  <div style="border: 1px solid red; padding: 5px; margin-top: 10px; width: 80%;"> Remove its protection film and protection bag. Make sure display no scratch/dirty/Cracked screen </div> </div> <div style="width: 60%;"> <div style="border: 1px solid red; padding: 5px; margin-top: 10px;"> Display operation process requirements: 1. catch display plastic frame during operation, 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. </div> </div> </div>										
Modify records		<div style="border: 1px solid yellow; padding: 5px; text-align: center;">Please read and understand the operating instructions carefully</div>			Prepare	Verify	Approve	Engineering controlled seal		
					Bingzhuang Deng					






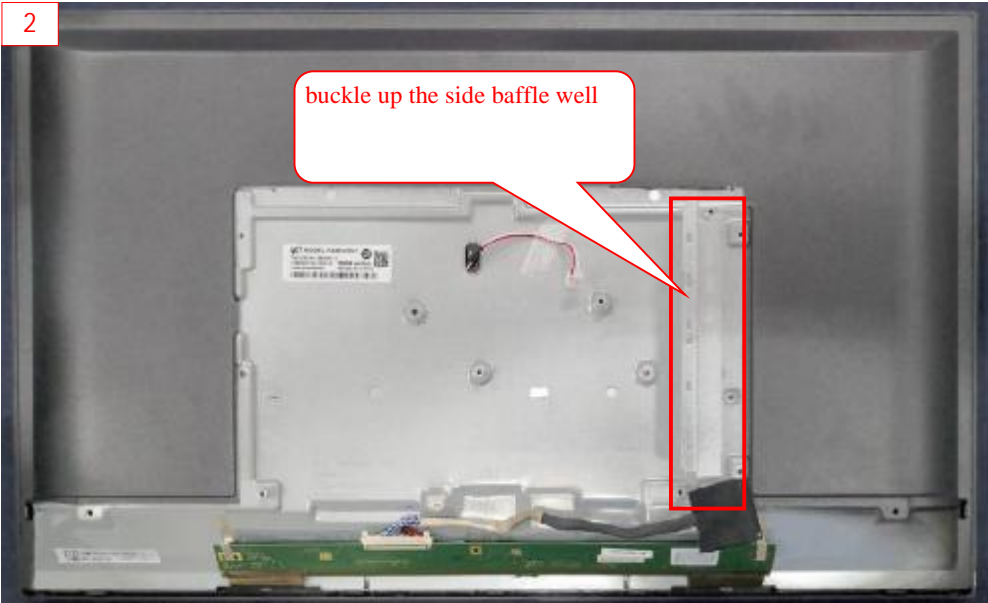
KTC Operation Instructions

Station name	lock hex screws		Model	24D1S M2C3 6A358	Station/NO.	Machine assemble 02	Document No.		Version	
							Effective from		Date Updated	
NO	Material number	Amount	Description		Working contents and requirements			Mark figure	Tool parameter	
1	7B11-0302F0-00102141	4	Φ3×2.5×7mm Screw		Take 4PCS Φ3×2.5×7mm screws to lock on the back plate in the order of 1			Figure 1 	electric driver	
2									4±1kgfcm	
3										
4										
5					After self-check OK, tread the foot switch to flow it into next station.					
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 and abnormalities such as screws being neglected, tilted and slipped are not allowed.								
		3. Wear static ring during operation.								
<div style="display: flex; justify-content: space-between; align-items: flex-start;"> <div style="width: 65%;">  </div> <div style="width: 30%; border: 1px solid blue; padding: 5px;"> <p>Process Requirements:</p> <ol style="list-style-type: none"> 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 at will. </div> </div>										
Modify records		<div style="border: 1px solid yellow; padding: 2px; display: inline-block;">Please read and understand the operating instructions carefully</div> <div style="border: 1px solid red; padding: 2px; display: inline-block; margin-left: 10px;">Take only one screw at a time</div>		Prepare	Verify	Approve	<div style="border: 1px solid black; padding: 5px;">Engineering controlled seal</div>			
				Bingzhuang Deng						





KTC Operation Instructions

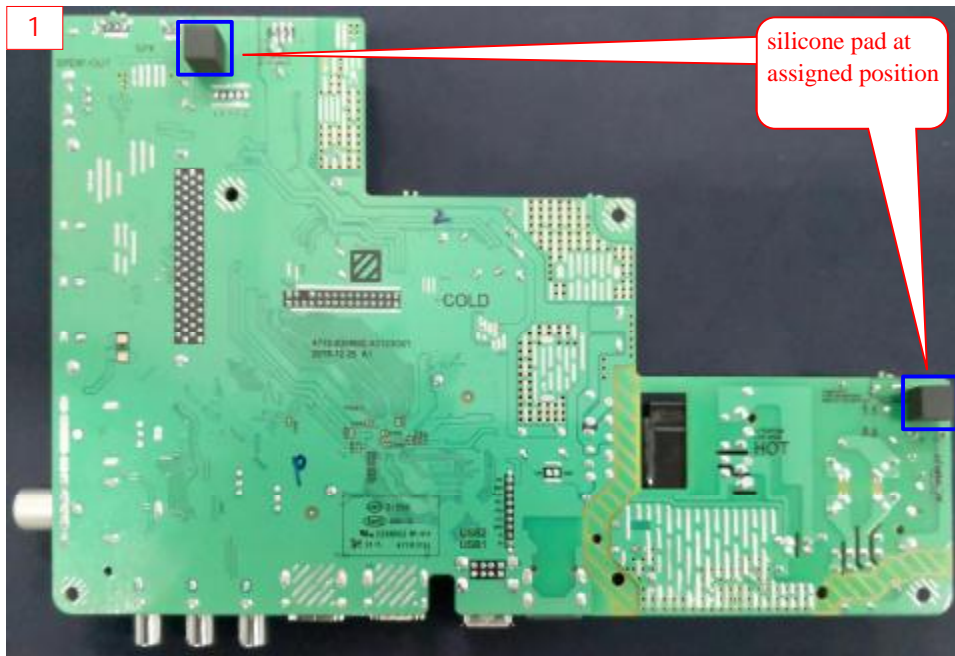
Station name	insert the wire-LVDS wire		Model	24D1S M2C3 6A358	Station/NO.	Machine assemble 03	Document No.		Version	
							Effective from		Date Updated	
NO	Material number	Amount	Description	Working contents and requirements				Mark figure	Tool parameter	
1	6149-210063-30R11203	1	210mm two-terminal LVDS wire	Take 1PCS LVDS wire and insert its metal terminal into the corresponding socket of PCB plate.Check in place.				Figure 1	tape machine	
2	7912-723110-015R1514	1	0.15mm×15mm×110m viscose paper (length: 50mm)							
3	7912-322020-017R0511	2	Single-sided adhesive black shading mylar (20*17*0.05mm)	Take 1 PCS 50mm fiber tape to fix the wire as figure show.				Figure 1		
4				Take 2PCS shading mylar to paste on the back plate as figure show.				Figure 1		
5				After self-check OK,tread the foot switch to flow it into next station.						
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 and abnormalities such as screws being neglected, tilted and slipped are not allowed. 3.Wear static ring during operation.						 	3	
<div> <div>1</div>  <div>detail 1</div>  <div>check to see if inserting in place</div> <div> <div>Illustration for sticking viscose paper</div> <div> <div>NG</div>  <div>Wire</div> <div>Viscose paper will easily come off over time if not stuck in place</div> </div> <div> <div>OK</div>  <div>Wire</div> <div>viscose paper</div> <div>Stick viscose paper as illustrated</div> </div> </div> </div>										
Modify records				Please read and understand the operating instructions carefully		Prepare	Verify	Approve	Engineering controlled seal	
						Bingzhuang Deng				

KTC Operation Instructions

Station name	install the side baffle		Model	24D1S M2C3 6A358	Station/NO.	Machine assemble 04	Document No.		Version	
							Effective from		Date Updated	
NO	Material number	Amount	Description		Working contents and requirements			Mark figure	Tool parameter	
1	/	1	well preprocessed hardware baffle plate		Take 1PCS well preprocessed hardware baffle plate and check whether the baffle is inserted well.After install it into the back plate.			Figure 1/2 		
2										
3										
4										
5					After self-check OK,tread the foot switch to flow it into next station.					
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.								
<div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="text-align: center;">  <p>1</p> <p>paste EVA pad well</p> </div> <div style="text-align: center;">  <p>2</p> <p>buckle up the side baffle well</p> </div> </div>										
								Engineering controlled seal		
Modify records			Please read and understand the operating instructions carefully		Prepare	Verify	Approve			
					Bingzhuang Deng					





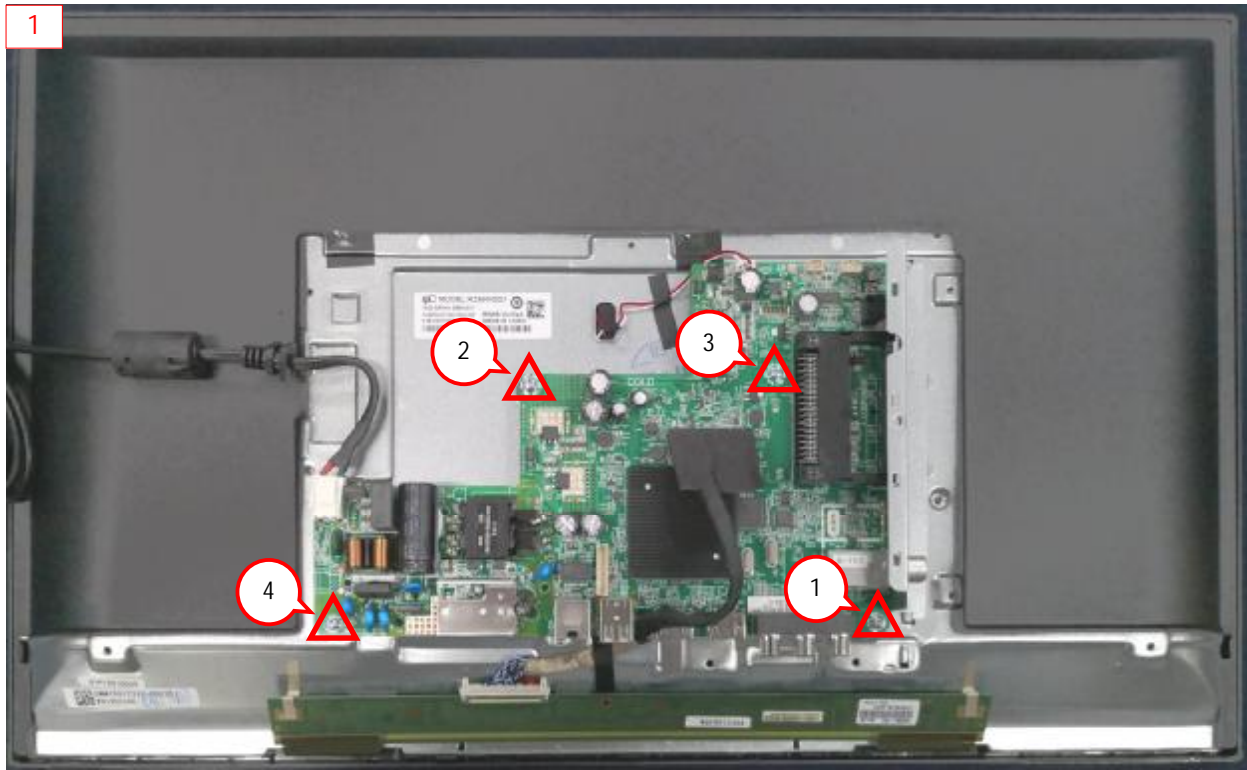
KTC Operation Instructions

Station name		process the main board		Model	24D1S	Station/NO.	Machine assemble 05	Document No.		Version	
					M2C3 6A358			Effective from		Date Updated	
NO	Material number		Amount	Description		Working contents and requirements				Mark figure	Tool parameter
1	9011-11C335-BR3B2341		1	MSD6A358AXOG-8-00FZ Mainboard		Take 1PCS mian board,check no cold solder.					
2	7912-113008-0089R511		2	8*8*9.5mm 70°silicone pad		Take 2PCS silicone pads and paste them on the assigned positions of the back of main board as figure show.				Figure 1	
3											
4						Then put the mainboard on back of display as figure 2 show.				Figure 2	
5						After self-check OK,tread the foot switch to flow it into next station.					
Notices	1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.										
	2.Take careful anti static measures, wear static ring during operation.										







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

KTC Operation Instructions

Station name	lock the main board		Model	24D1S M2C3 6A358	Station/NO.	Machine assemble 06	Document No.		Version	
							Effective from		Date Updated	
NO	Material number	Amount	Description		Working contents and requirements			Mark figure	Tool parameter	
1	7B11-0307C2-50102114	4	M3×7mm P head with spring washer and flat pad blue zinc plating machine Screw		Take 4PCS M3×7mm screws to lock the main board on the back plate in the order of 1-4.			Figure 1 	electric driver 4±1kgfcm	
2										
3										
4					After self-check OK, read the foot switch to flow it into next station.					
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.					 			
		2. Pick screw one by one during blocking screws, there should not be missed lock, wrong direction block or strip etc.								
		3. Take careful anti static measures, wear static ring during operation.								
		Notice: cause mainboard holes are close to mainboard parts, notice not to damage any mainboard parts.								
<div style="display: flex; align-items: center;"> <div style="flex: 1;">  </div> <div style="flex: 1; border: 1px solid blue; padding: 10px; margin-left: 20px;"> <p>Process Requirements:</p> <ol style="list-style-type: none"> 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 at will. </div> </div>										
Modify records		Please read and understand the operating instructions carefully		Take only one screw at a time	Prepare Bingzhuang Deng	Verify	Approve	Engineering controlled seal		



KTC Operation Instructions

Station name	insert the wire&install the lower baffle		Model	24D1S M2C3 6A358	Station/NO.	Machine assemble 07	Document No.		Version	
							Effective from		Date Updated	

NO	Material number	Amount	Description	Working contents and requirements	Mark figure	Tool parameter
1	6110-150722-07461711	1	1.5M 0.075M /0.075M AC power cord	Take 1PCS power cord to insert the 2pin terminal into the main board power socket.	Figure 1 	
2	7111-2400D1-X0000071	1	24D1 lower IO baffle			
3				Insert backlight wire terminal into the main board socket.	Figure 1 	
4				Insert the LVDS wire terminal into the corresponding socket of main board.	Figure 1 	
5				Take 1PCS main board lower baffle to check its appearance without scratch/fade/burrs,etc. Snap the OK parts into the corresponding position of back plate.	Figure 1 	
6						
7						
8				After self-check OK,tread the foot switch to flow it into next station.		

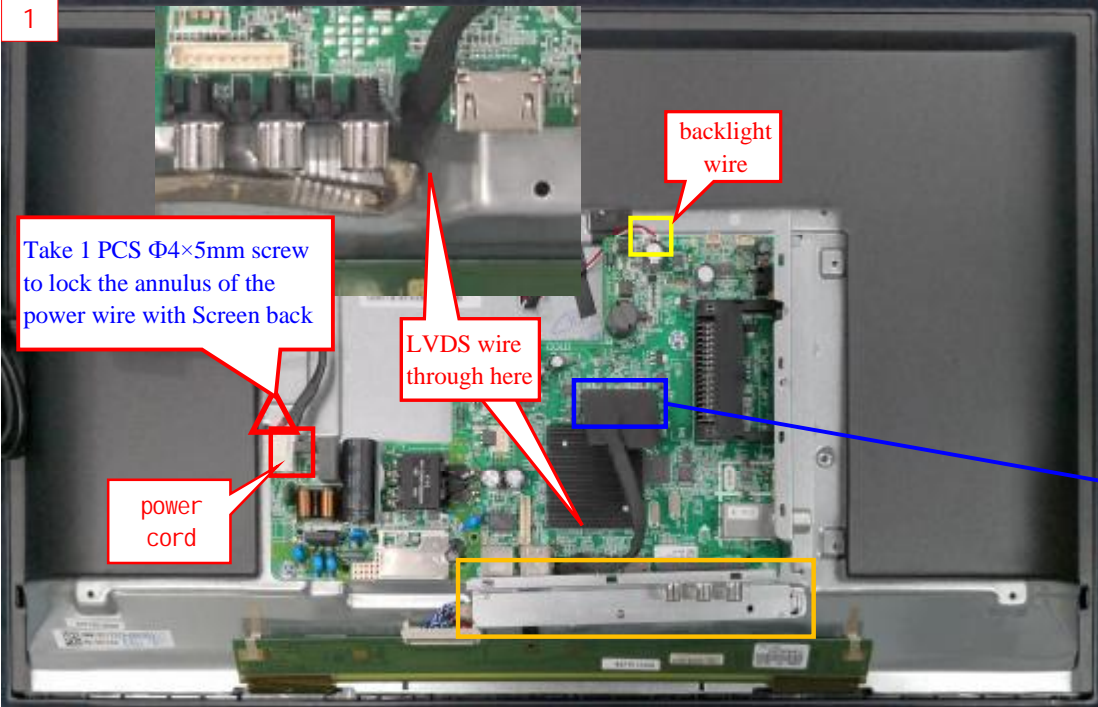
Notices


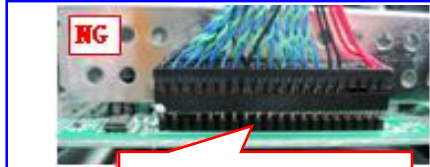

1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.
2.Insert wire in the right place, it should not be msinsertions or not in place.
3.Take careful anti static measures, wear static ring during operation.

7

1



Wire insert processing requiremnts:

1.insert wire vertically, without contrary direction insert\wrong insert\missing insert,wire fool proff jack and socket fool proof jack should be corepondence.
2.insert wire with a proper power, it should be inserti in the right position,and should be far from power board(heatsink and transformer)
3.when the insert position is far from PCBA, one hand holds up PCB, another hand inserts wire in order to avoid press PCB board or make it break.

Engineering controlled seal

Modify records

Please read and understand the operating instructions carefully



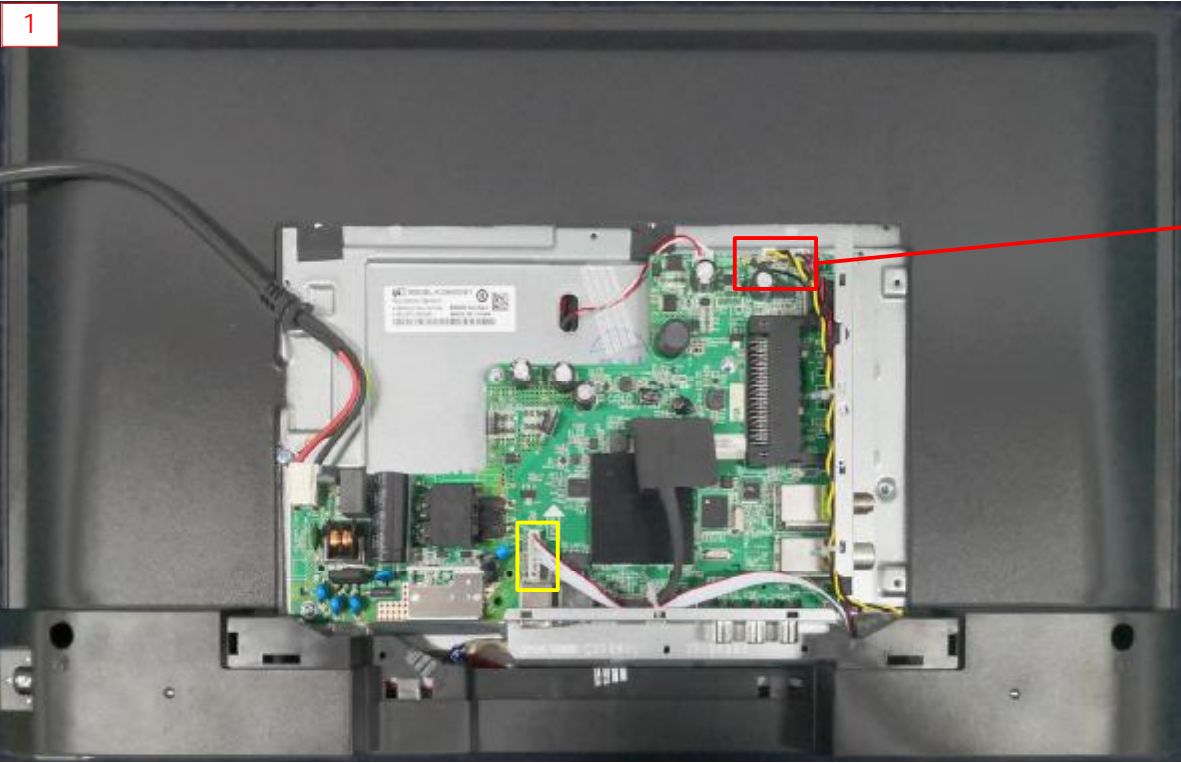
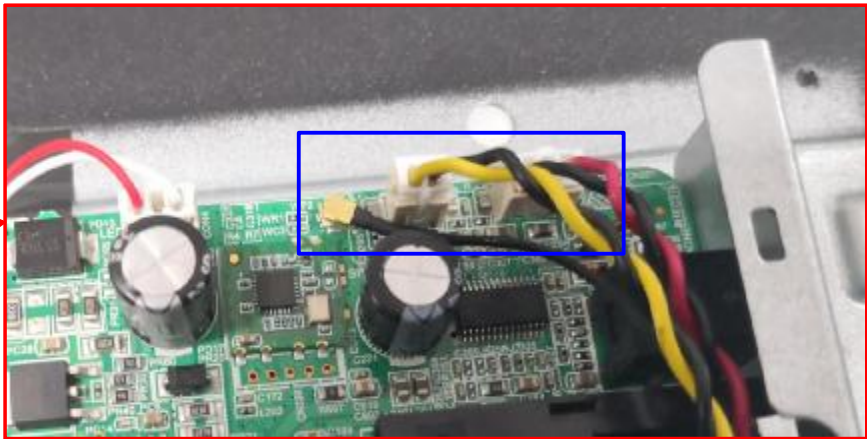
Prepare

Verify






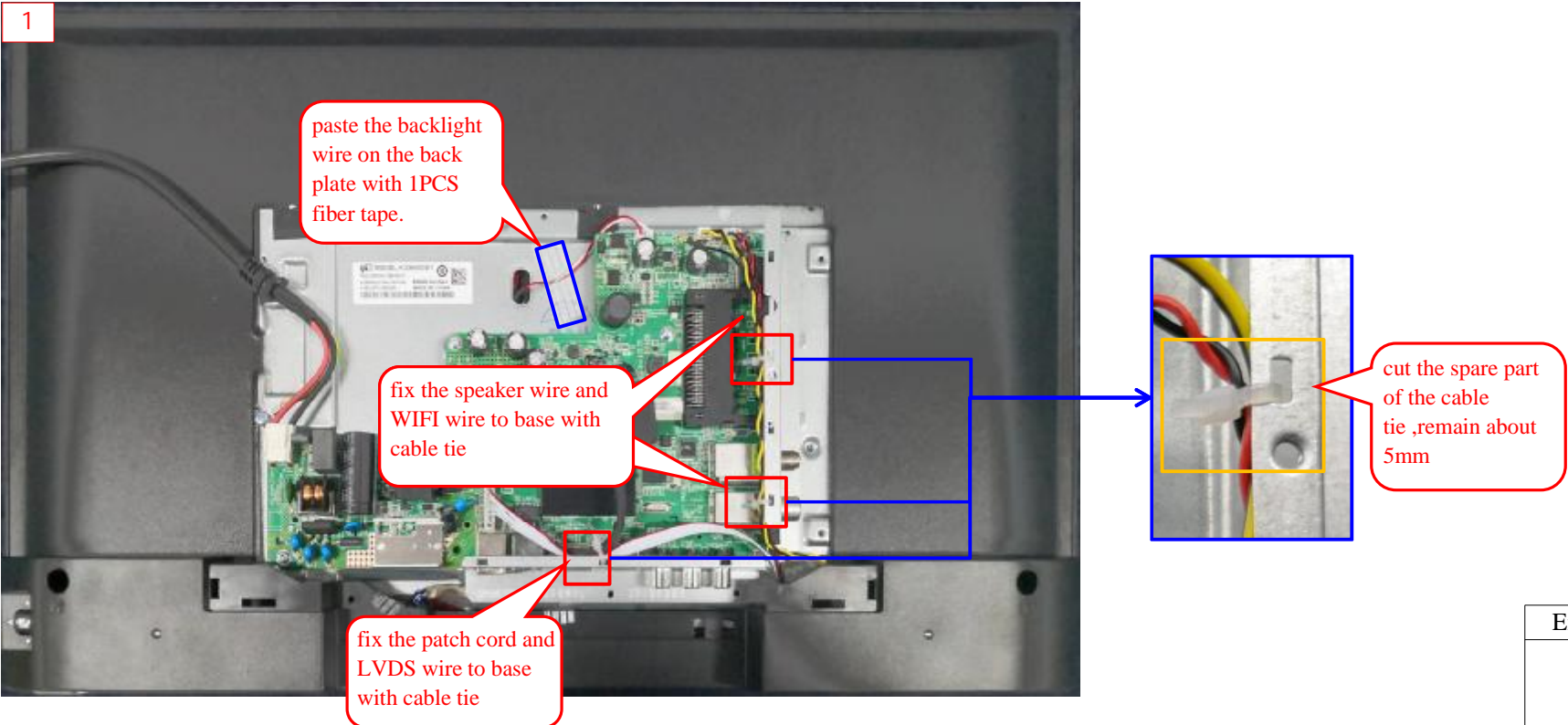
Approve

Bingzhuang Deng



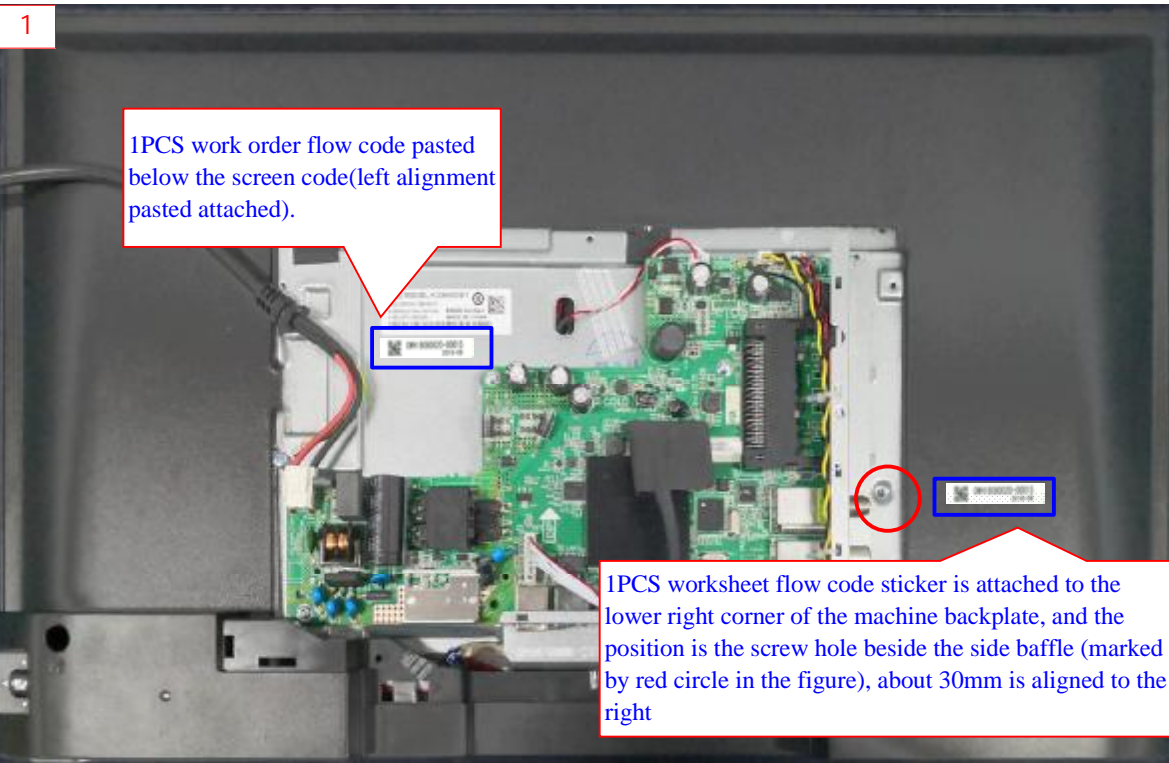
KTC Operation Instructions

Station name	isntall the back cover-1		Model	24D1S M2C3 6A358	Station/NO.	Machine assemble 08	Document No.		Version	
							Effective from		Date Updated	
NO	Material number	Amount	Description	Working contents and requirements				Mark figure	Tool parameter	
1	/	1	well preprocessed lower back cover assembly	Take 1PCS preprocessed OK lower back cover assembly and check whether the inner wiring is loose or not.				Figure 1		
2										
3				Insert the main board to keypad wire,WIFI wire and speaker wire into the corresponding positions.				Figure 1		
4										
5				Cover the back cover well.				Figure 1		
6				After self-check OK,tread the foot switch to flow it into next station.						
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 or not in place. 3.Wear static ring during operation.						 	<div>8</div>	
<div> <div>1</div>   </div>										
				Engineering controlled seal						
Modify records				Please read and understand the operating instructions carefully		Prepare	Verify	Approve		
						Bingzhuang Deng				

KTC Operation Instructions

Station name	wire arrangement		Model	24D1S M2C3 6A358	Station/NO.	Machine assemble 09	Document No.		Version									
							Effective from		Date Updated									
NO	Material number	Amount	Description		Working contents and requirements			Mark figure	Tool parameter									
1	7912-723110-015R1514	1	0.15mm×15mm×110m viscose paper (length: 50mm)		Take 1PCS 50mm fiber tape to arrange the wire as figure show.			Figure 1 	tape machine									
2	7907-0A0001-08000211	3	80 ×2 ×0.9mm Cable ties		Take 2PCS cable tie to arrange the wire as figure show.			Figure 1 	Diagonal cutting pliers									
3					use cutting pilers to cut the spare part of the cable tie ,remain about 5mm													
4					as figure show.													
5					After self-check OK,tread the foot switch to flow it into next station.													
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.																
<div data-bbox="165 587 1877 1385">  </div>																		
Modify records		Please read and understand the operating instructions carefully				Prepare	Verify	Approve	Engineering controlled seal									
						Bingzhuang Deng												

KTC Operation Instructions

Station name	scan and bind&process check		Model	24D1S M2C3 6A358	Station/NO.	Machine assemble 10	Document No.		Version	
							Effective from		Date Updated	
NO	Material number	Amount	Description	Working contents and requirements				Mark figure	Tool parameter	
1				Check the screw locking				Figure 1	MES industrial terminal	
2				check fiber tape sticking status				Figure 1		
3				Check the wire fully in place, after confirm OK,use pen to mark dot on wire plug				Figure 1		
4				the MES terminal is used to bind the barcode of mainboard, screen and worksheet flow code				Figure 1		
5										
6				After self-check OK,tread the foot switch to flow it into next station.						
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. Environment brightness requirement is between 600~1000lux.						 	<div>10</div>	
<div> <div>1</div>  <div>IPC work order flow code pasted below the screen code(left alignment pasted attached).</div> <div>IPC worksheet flow code sticker is attached to the lower right corner of the machine backplate, and the position is the screw hole beside the side baffle (marked by red circle in the figure), about 30mm is aligned to the right</div> </div> <div> Process Inspection Requirements: <ol style="list-style-type: none"> 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. </div>										
Modify records		Please read and understand the operating instructions carefully				Prepare	Verify	Approve	Engineering controlled seal	
						Bingzhuang Deng				



KTC Operation Instructions

Station name	install the back cover-2		Model	24D1S M2C3 6A358	Station/NO.	Machine assemble 11	Document No.		Version	
							Effective from		Date Updated	

NO	Material number	Amount	Description	Working contents and requirements	Mark figure	Tool parameter
1	/	1	well preprocessed upper back cover assembly	Take 1PCS preprocessed OK upper back cover assembly and check its appearance.	Figure 1	
2						
3				Plug power wire round corner installion in back cover.		
				Position the upper back cover assembly and install it on the back plate.		
4				After self-check OK,tread the foot switch to flow it into next station.		

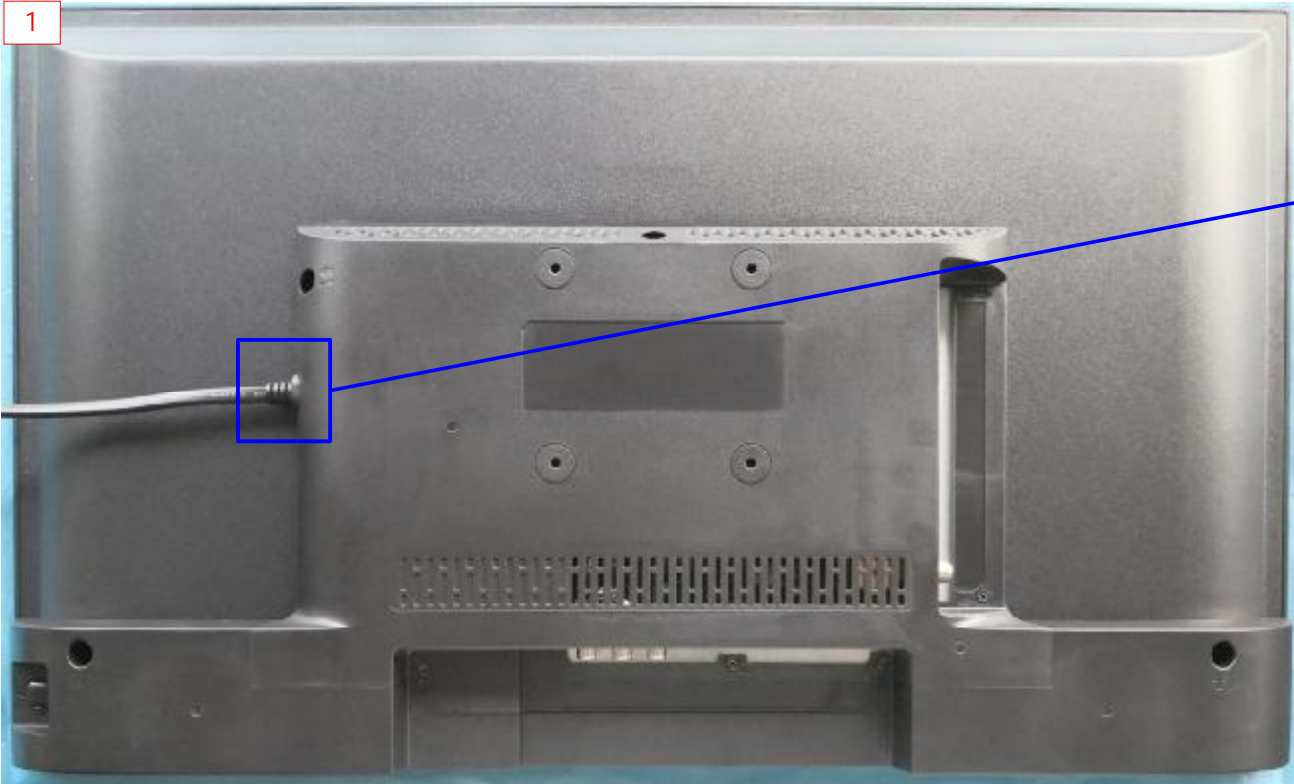
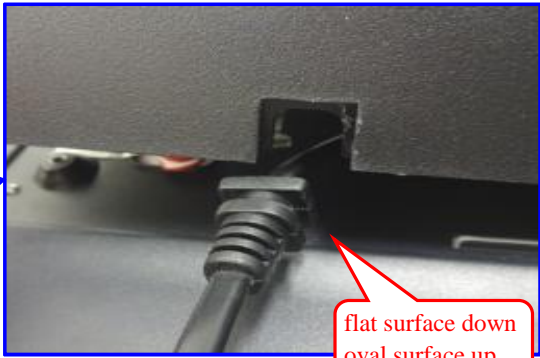
Notices

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.

11

1






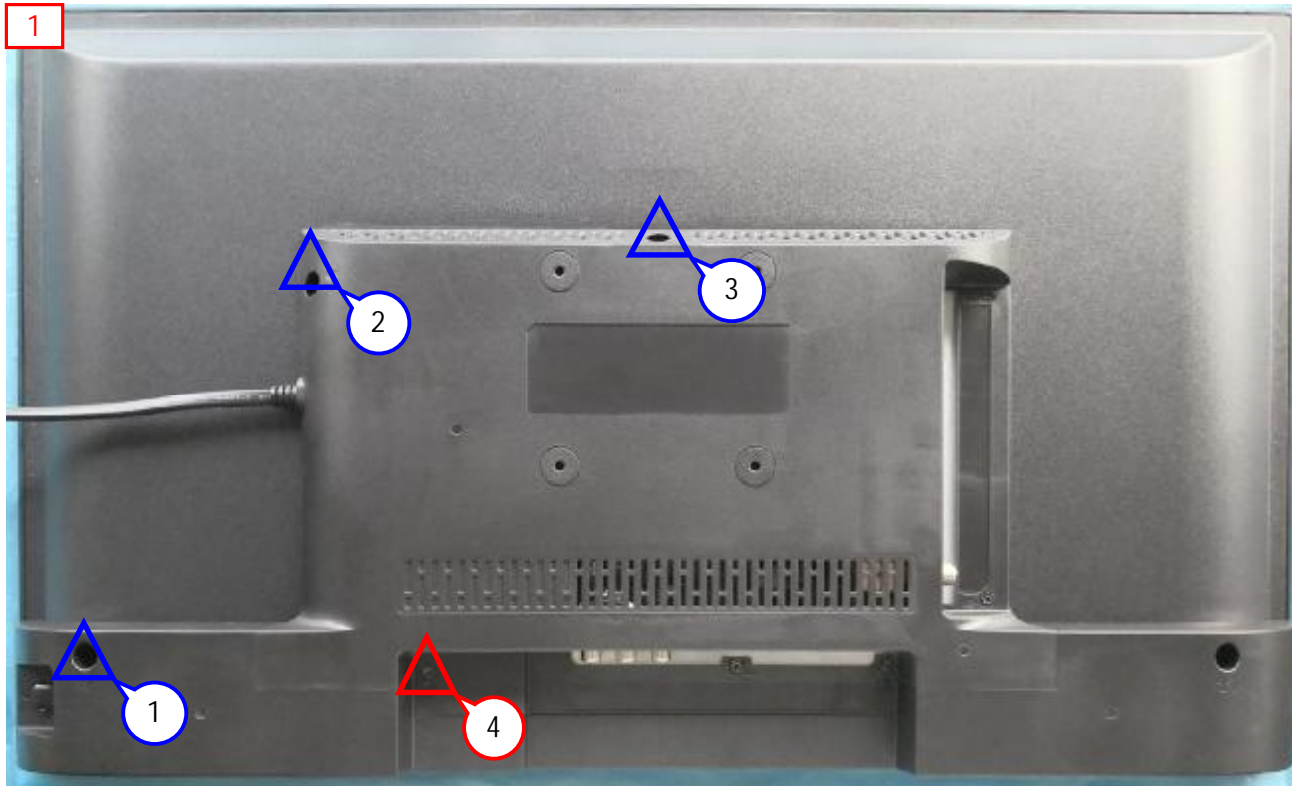



flat surface down
oval surface up





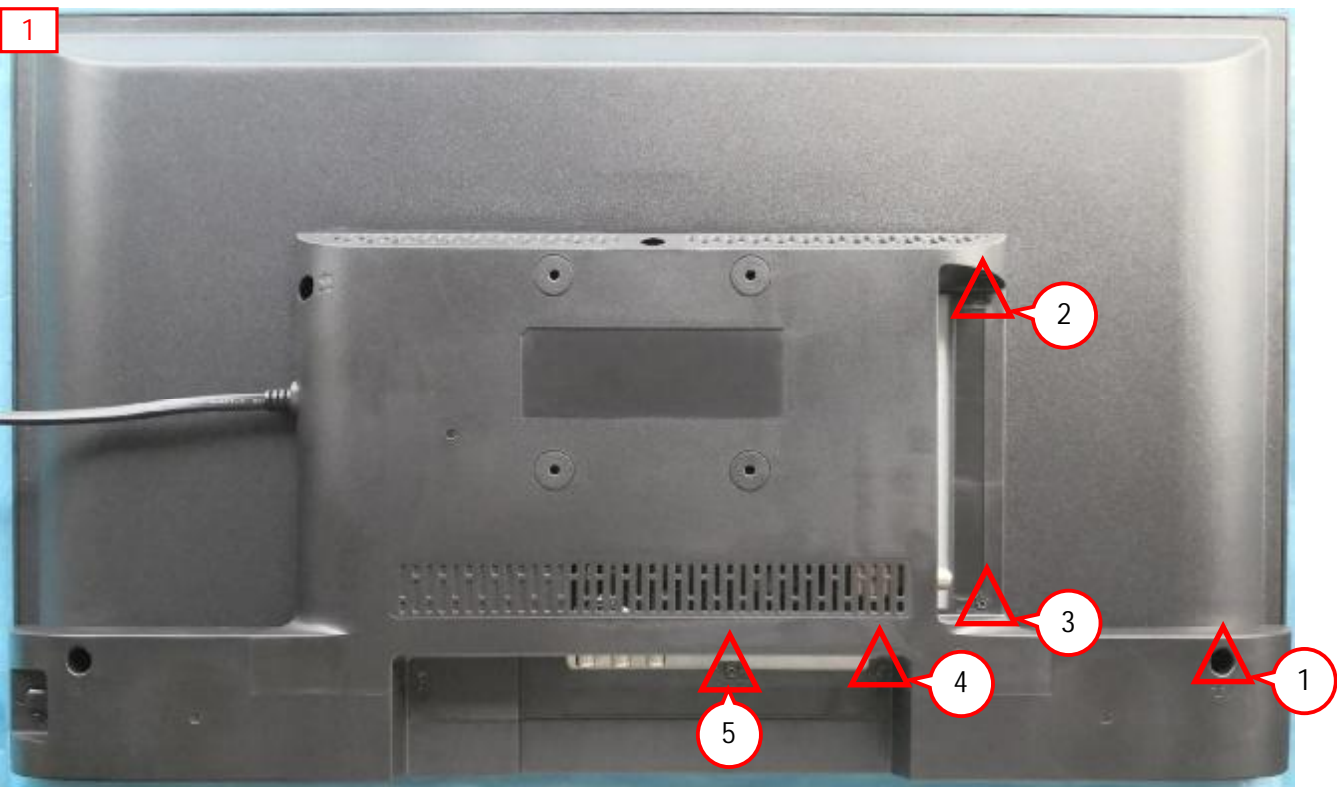
Engineering controlled seal

Modify records		Please read and understand the operating instructions carefully	Prepare	Verify	Approve	
			Bingzhuang Deng			






KTC Operation Instructions

Station name	lock the back cover-1		Model	24D1S M2C3 6A358	Station/NO.	Machine assemble 12	Document No.		Version	
							Effective from		Date Updated	
NO	Material number	Amount	Description	Working contents and requirements				Mark figure	Tool parameter	
1	7B11-0305A6-00105114	3	Φ3×5mm flat head black zinc mechanical screw	Take 3PCS Φ3×5mm flat head black zinc plated machine screws and lock the back cover in the order of 1-3.				Figure 1 	electric driver	
2	7B11-030616-00105421	1	Φ3×6mm flat head black zinc self-tapping screw							
3				Take 1PCS Φ3×6mm flat head black zinc plated self-tapping screws and lock at the position 4.				Figure 1 		
4										
5				After self-check OK, tread the foot switch to flow it into next station.						
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.								
		2. Pick screw one by one during blocking screws, there should not be missed lock, wrong direction block or strip etc.								
		3. Take careful anti static measures, wear static ring during operation.								
<div style="display: flex; justify-content: space-between;"> <div style="width: 65%;">  </div> <div style="width: 30%; border: 1px solid blue; padding: 5px;"> <p>Process Requirements:</p> <ol style="list-style-type: none"> 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 at will. </div> </div>										
Modify records		Please read and understand the operating instructions carefully		Take only one screw at a time		Prepare	Verify	Approve	Engineering controlled seal	
						Bingzhuang Deng				

KTC Operation Instructions

Station name	lock the back cover-2		Model	24D1S M2C3 6A358	Station/NO.	Machine assemble 13	Document No.		Version	
							Effective from		Date Updated	
NO	Material number	Amount	Description	Working contents and requirements				Mark figure	Tool parameter	
1	7B11-0305A6-00105114	5	Φ3×5mm flat head black zinc mechanical screw	Take 5PCS Φ3×5mm flat head black zinc plated machine screws and lock the back cover in the order of 1-5.				Figure 1 	electric driver	
2									4±1kgfcm	
3										
4										
5				After self-check OK, tread the foot switch to flow it into next station.						
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.								
		2. Pick screw one by one during blocking screws, there should not be missed lock, wrong direction block or strip etc.								
		3. Take careful anti static measures, wear static ring during operation.								
<div style="display: flex; justify-content: space-between;"> <div style="width: 70%;">  </div> <div style="width: 25%; border: 1px solid blue; padding: 5px;"> <p>Process Requirements:</p> <ol style="list-style-type: none"> 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 at will. </div> </div>										
Modify records			Please read and understand the operating instructions carefully		Take only one screw at a time		Prepare	Verify	Approve	Engineering controlled seal
							Bingzhuang Deng			

KTC Operation Instructions

Station name	isntall the base		Model	24D1S M2C3 6A358	Station/NO.	Machine assemble 14	Document No.		Version	
							Effective from		Date Updated	
NO	Material number	Amount	Description	Working contents and requirements				Mark figure	Tool parameter	
1	7003-2400D1-XL000021	1	24D1 Plastic base-L	Respectively take 1PCS -L/R base to check whether faulty.				Figure 1		
2	7003-2400D1-XR000021	1	24D1 Plastic base-R	Snap the OK base into the slot on the bottom of the back cover, and then take the base screws to lock it on the back cover.				Figure 1 		
3	7B11-041543-00105111	1	M4 ×15mm Screw Bag(2PCS screws)							
4										
5				After self-check OK, tread the foot switch to flow it into next station.						
Notices		1. Wastes produced by this station shall be placed in the assigned position. Refer to Waste Classification and Disposal List.						 	<div style="border: 1px solid blue; border-radius: 50%; width: 40px; height: 40px; display: flex; align-items: center; justify-content: center; margin: 0 auto;">14</div>	
<div style="display: flex; justify-content: space-between; align-items: flex-start;"> <div style="width: 45%;">   </div> <div style="width: 50%; border: 1px solid blue; padding: 5px;"> <p>Process Requirements:</p> <ol style="list-style-type: none"> 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 at will. </div> </div>										
Modify records			Please read and understand the operating instructions carefully		Take only one screw at a time		Prepare	Verify	Approve	
					Bingzhuang Deng					

Engineering controlled seal