

LINEAR TRANSLATION STAGE

MSM-1001

Date Printed: 12/16/2008

Standardized Work Sheet

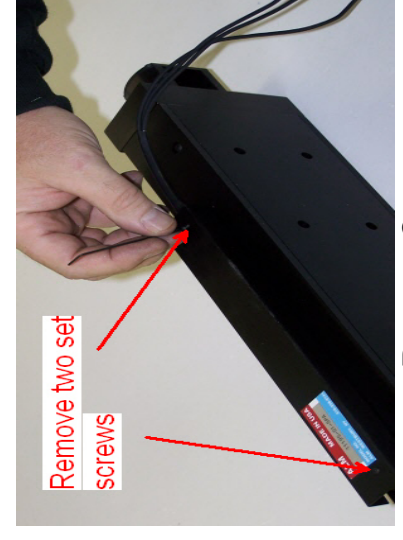


Part: MSM-1001	Sheet: 2
Operation: Station 1	Operation Cycle Time: 214
Version: 1	
Approval Date: 11/7/2008	
Approval By: Ryan O'Hagan	

Number	Rev	Description	Qty
HDW-0110	A	M5x14 Socket Head Cap Screw	4.00
HDW-0130	A	M2X8 Socket Head Cap Screw	2.00
HDW-0141	B	M3X8 Socket Head Cap Screw	4.00

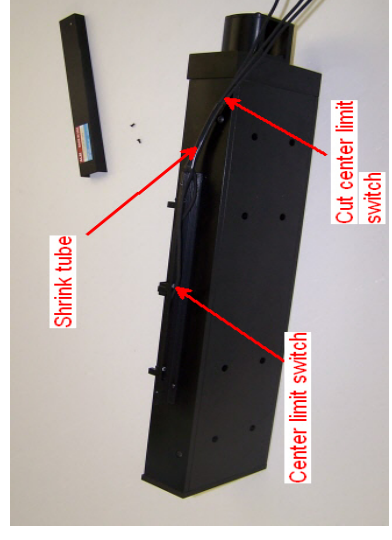
Figure(s)	Seq	Steps	Symbol	Manual Time	Waste Time	Cumulative Time
1 2	1	Linear Stage Prep	↗	10.00	3.00	13
3	2	Clip Center Limit	↗	9.00	2.00	24
4	3	Clip other two wires	↗	15.00	1.30	40.3
5	4	Strip Insulation	↗	23.00	0.00	63.3
6	5	White Wires	↗	15.00	0.00	78.3

Icon:	Safety	Instruction	Alert	Quality	Environmental	Objective	Scope	Flow
	STOP	↗	⚠	6σ	🌍	🎯	👂	📊



1

Remove Cover



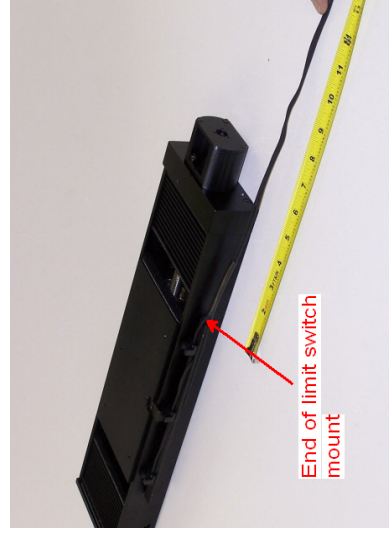
3

Center Limit Switch Cable



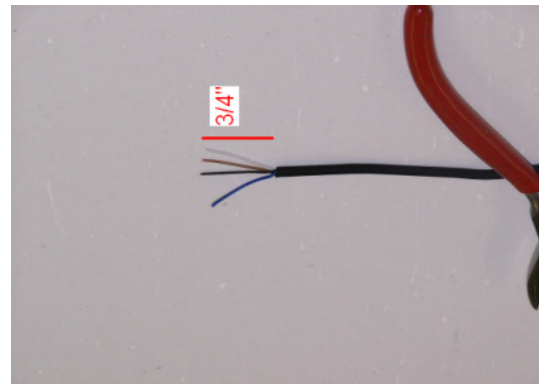
2

Limit Switch Cover Removed



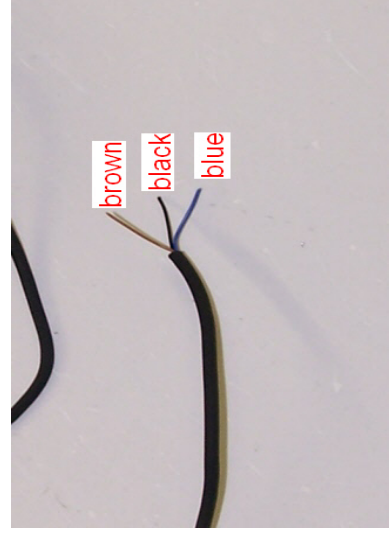
4

Cut Limit Switch Wires



5

Center Limit Switch Cable



6

Cut Limit Switch Wires

Standardized Work Sheet



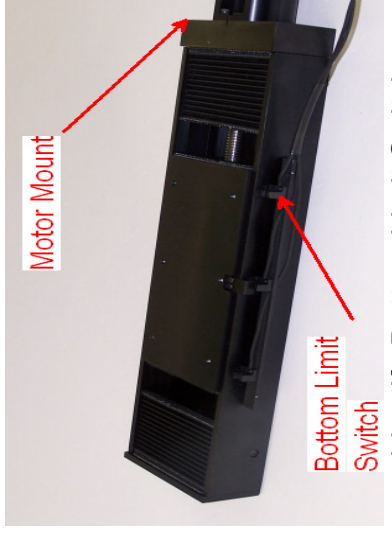
Steps

Figure(s)	Seq	Steps	Symbol	Manual Time	Waste Time	Cumulative Time
1 2	6	Mark Bottom Cable	6G	11.00	0.00	89.3
3	7	Solder Wire Pairs	↻	9.00	2.00	100.3
4 5	8	Crimp Pins	↻	11.00	6.70	118

Icon:	Safety	Instruction	Alert	Quality	Environmental	Objective	Scope	Flow
	STOP	↻	⚠	6G	🌍	🎯	📏	📄

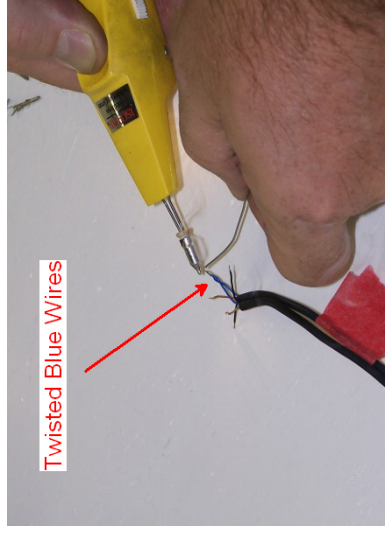
Part: MSM-1001	Sheet: 3
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1



Identify Bottom Limit Switch

3

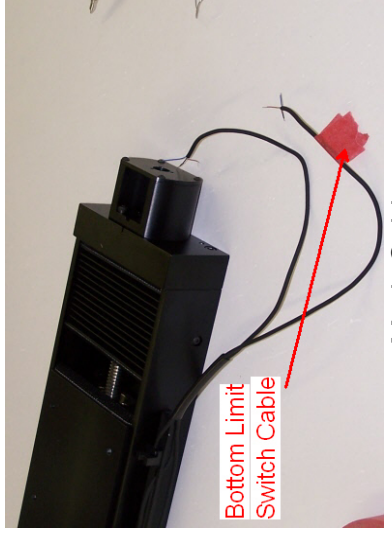


Solder Twisted Blue Wires

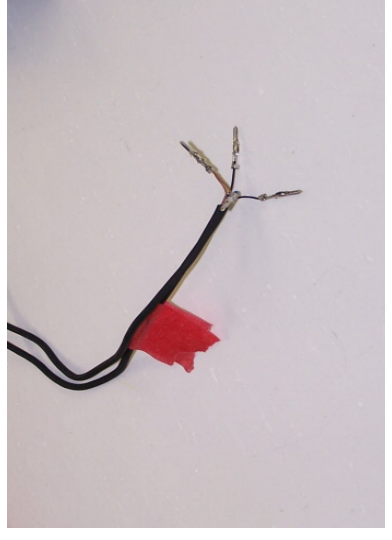
5



2



4



Standardized Work Sheet



Part: MSM-1001

Sheet: 4

Operation: Station 1

Operation Cycle Time: 214

Version: 1

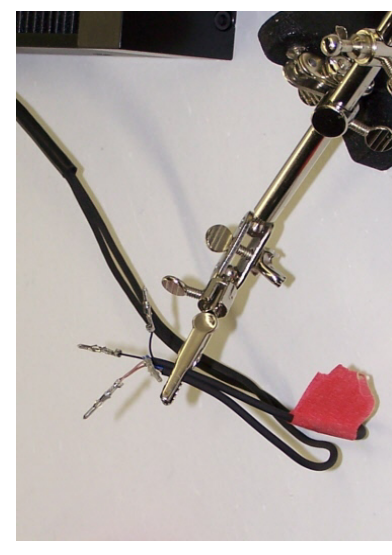
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Steps

Figure(s)	Seq	Steps	Symbol	Manual Time	Waste Time	Cumulative Time
1 2	9	Solder pins	↗	56.00	9.00	183
3	10	Electrical Plug	↗	17.00	0.00	200
4	11	Motor Mount Plate	6σ	14.00	0.00	214

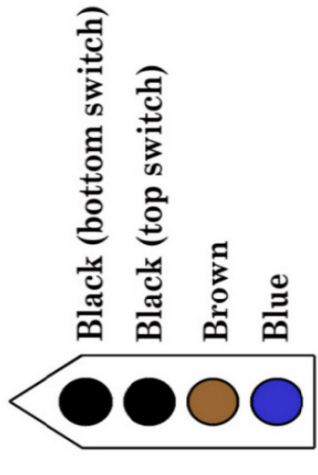
Icon:	Safety	Instruction	Alert	Quality	Environmental	Objective	Scope	Flow
	STOP	↗	⚠	6σ	🌍	🎯	👉	📄



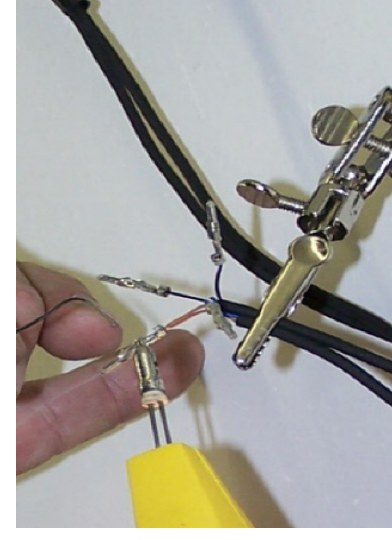
Secure the Wires

1

3



2



Solder Crimp Pins

4

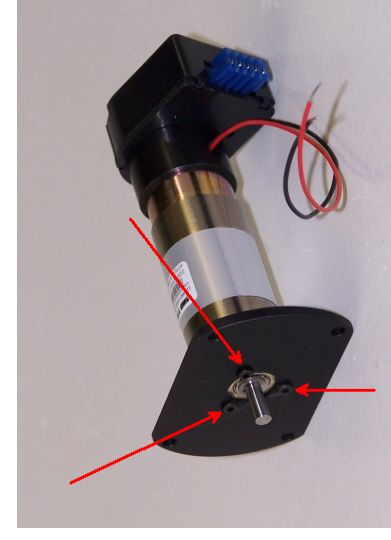


Plate Orientation