

## E6533 Process Flow Chart

Rev.no.00

| Sr.No.         | Stage  | MES Stages          | Manpower  |
|----------------|--|---------------------|-----------|
| 1              | Main PCBA visual check and input & fix the connector sealing rubber  |                     | 1         |
| 2              | Thermal silica gel pasting on PCBA IC part @3 (Size different)   |                     | 1         |
| 3              | Fix front camera   |                     | 1         |
| 4              | Fix rear main camera and rear secondary camera   |                     | 1         |
| 5              | Paste motherboard sink copper foil   |                     | 1         |
| 6              | Paste the motherboard graphite paper(Black - Color) on shielding cover   |                     | 1         |
| 7              | Paste ground conductive sponge on shielding cover @3 & Water Label   |                     | 1         |
| 8              | Paste earpiece FPC on main pcba housing  |                     | 1         |
| 9              | Paste fingerprint connector foam and earpiece conductive sponge on main pcba housing   |                     | 1         |
| 10             | Front housing input & Visual Check, and side key FPC pasting   |                     | 1         |
| 11             | Battery compartment adhesive pasting @3  |                     | 1         |
| 12             | fix front camera sleeve,Clean the front camera hole with ionizer & Tear off the front camera and fix the camera in <b>Clean Room</b>               |                     | 1         |
| 13             | sensor sleeve fixing ,pcba binding and Fix the main pcba ,   | AS01                | 1         |
| 14             | Main Board screwing @2 (Silver) - 0.6 Kg/Cm2   |                     | 1         |
| 15             | Tear the LCD adhesive release paper and fix LCD FPC  |                     | 1         |
| 16             | Receiver fixing (Leg should be downward)   |                     | 1         |
| 17             | Paste LCD FPC Mylar on Both side of LCD FPC (Both Mylar different)   |                     | 1         |
| 18             | Tear the motor adhesive release paper and Install the motor & paste conductive tape on front camera  |                     | 1         |
| 19             | Paste the speaker FPC  |                     | 1         |
| 20             | Paste horn sealing foam and Tear the adhesive release paper  |                     | 1         |
| 21             | Sub -pcba input and install the earphone sleeve  |                     | 1         |
| 22             | Paste the earphone Mylar and fix the sub -pcba   |                     | 1         |
| 23             | RF cable Connector fixing and routing (From up to down side )  |                     | 1         |
| 24             | Tear the battery compartment adhesive release paper and fix the battery  |                     | 1         |
| 25             | fix the battery connector and LCD- battery binding   | AS02                | 1         |
| 26             | Main FPC Connector fixing main PCBA to sub PCBA  |                     | 1         |
| 27             | LQC-1  | AS06                | 1         |
| 28             | Fix Speaker in horn bracket and horn bracket fixing and screwing @1 (Silver - Manually)- 0.8 Kg/Cm2  |                     | 1         |
| 29             | Current testing via Current testing Jig  |                     | 1         |
| 30             | Peel off the rear camera & Sealing foam fixing on deputy rear camera and main-pcba middle housing fixing in <b>Clean Room</b>                      |                     | 1         |
| 31             | Tear the blue protective film of the rear camera decoration ,After cleaning with an ion air gun paste the camera lens in <b>Clean Room</b>         |                     | 1         |
| 32             | Manual Screwing top@1 qps (Silver)- 0.8 Kg/Cm2   |                     | 1         |
| 33             | Camera Lens/Battery Pressing via Pressing jig  |                     | 1         |
| 34             | Main-pcba middle housing screwing @6 (Black)- 0.8 Kg/Cm2   |                     | 1         |
| 35             | Rear housing screwing @8(Silver)- 0.8 Kg/Cm2   |                     | 1         |
| 36             | Yellow mylar pasting on top side of main board rear housing  |                     | 1         |
| <b>Testing</b> |  |                     |           |
| 37             | Auto testing (**#1923#**)  | AS03                | 8         |
| 38             | Paste the screw label @2   |                     | 1         |
| 39             | Battery Cover Visual Check & 3 Antenna pasting (Main antenna, diversity antenna and WBG/ Three in one antenna) on battery cover                    |                     | 2         |
| 40             | Battery graphite pasting on back cover   |                     | 1         |
| 41             | IMEI label printing & Pasting  |                     | 1         |
| 42             | Back Cover Fixing  |                     | 1         |
| 43             | RF test  | AS04                | 1         |
| 44             | Device on & Manual Camera testing & Recording  |                     | 1         |
| 45             | factory code dial(**#180180#**) & Camera calibration & Validation via jigs   |                     | 1         |
| 46             | Coupling & Pack Input Scan and Dial Aging Code   | AS04 & ST15         | 1         |
| 47             | After Aging , Device retest with the help of (**#1929#**) on sampling basis  |                     | 1         |
| 48             | IMEI Writing with MES  | ST01                | 1         |
| 49             | IMEI Comparing with MES  | ST02                | 1         |
| 50             | Welcome mode check /Device off/Sim Tray insertion  |                     | 1         |
| 51             | LQC-2  | ST14                | 1         |
| <b>Packing</b> |  |                     |           |
| 52             | GB Visual Check & Open/Accessory,UM,screenguard Placement/Tray fixing  |                     | 2         |
| 53             | Piggy printing & pasting   | ST04                | 1         |
| 54             | Charger binding and Device Cleaning  | ST05                | 1         |
| 55             | Lamination pasting in back cover   |                     | 1         |
| 56             | Device wrapping with the help of jig   |                     | 1         |
| 57             | Piggy validation   | ST06                | 1         |
| 58             | LQC-3 & GB Closing   |                     | 1         |
| 59             | GB Weighing & MRP pasting  | ST13                | 1         |
| 60             | GB Seal pasting @2Qps  |                     | 1         |
| 61             | GB Variant Sticker pasting according to the RAM/ROM at the back side of gift Box   |                     | 1         |
| 62             | GB Shrink Wrap   |                     | 1         |
| 63             | Carton Preparation, Model label pasting , GB Scanning, GB placing in carton, Carton Label pasting , IN logo seal & Tape pasting & Carton Wrapping. | ST07                | 2         |
| <b>Gluing</b>  |  |                     |           |
| 64             | TP testing with the help of Jig and Tool   |                     | 1         |
| 65             | Front housing visual checking & Receiver Net & adhesive Pasting at the top of front housing  |                     | 1         |
| 66             | Paste light-sensitive diffusion film in the corresponding slot on the top of the front shell & remove the double sided Receiver net adhesive paper |                     | 1         |
| 67             | Front housing gluing   |                     | 1         |
| 68             | LCD attachment in front housing  |                     | 1         |
| 69             | LCD pressing & fix into bottom side  |                     | 1         |
| 70             | Visually Check , fix into fixture & lock it  |                     | 1         |
| 71             | Put into the trolley for drying the gluing @2hrs   |                     | 1         |
| 72             | Open it & check it visually  |                     | 1         |
| 73             | SAP  |                     | 1         |
| 74             | TRC  |                     | 1         |
| Prepared by.   |  | Total Manpower = 84 |           |
| Checked by.    |  | QA Head             | Prod Head |
| Approved by.   |  |                     |           |