Product End-of-Life Disassembly Instructions

Product Category: Personal Computers

Marketing Name / Model
[List multiple models if applicable.]

HP ENVY 27 All-in-One PC

Purpose: The document is intended for use by end-of-life recyclers or treatment facilities. It provides the basic instructions for the disassembly of HP products to remove components and materials requiring selective treatment, as defined by EU directive 2002/96/EC, Waste Electrical and Electronic Equipment (WEEE).

1.0 Items Requiring Selective Treatment

1.1 Items listed below are classified as requiring selective treatment.
1.2 Enter the quantity of items contained within the product which require selective treatment in the right column, as applicable.

<table>
<thead>
<tr>
<th>Item Description</th>
<th>Notes</th>
<th>Quantity of items included in product</th>
</tr>
</thead>
<tbody>
<tr>
<td>Printed Circuit Boards (PCB) or Printed Circuit Assemblies (PCA)</td>
<td>With a surface greater than 10 sq cm</td>
<td>1</td>
</tr>
<tr>
<td>Batteries</td>
<td>All types including standard alkaline and lithium coin or button style batteries</td>
<td>1</td>
</tr>
<tr>
<td>Mercury-containing components</td>
<td>For example, mercury in lamps, display backlights, scanner lamps, switches, batteries</td>
<td>0</td>
</tr>
<tr>
<td>Liquid Crystal Displays (LCD) with a surface greater than 100 sq cm</td>
<td>Includes background illuminated displays with gas discharge lamps</td>
<td>1</td>
</tr>
<tr>
<td>Cathode Ray Tubes (CRT)</td>
<td></td>
<td>0</td>
</tr>
<tr>
<td>Capacitors / condensers (Containing PCB/PCT)</td>
<td></td>
<td>0</td>
</tr>
<tr>
<td>Electrolytic Capacitors / Condensers measuring greater than 2.5 cm in diameter or height</td>
<td></td>
<td>0</td>
</tr>
<tr>
<td>External electrical cables and cords</td>
<td>Power code</td>
<td>1</td>
</tr>
<tr>
<td>Gas Discharge Lamps</td>
<td></td>
<td>0</td>
</tr>
<tr>
<td>Plastics containing Brominated Flame Retardants weighing &gt; 25 grams (not including PCBs or PCAs already listed as a separate item above)</td>
<td></td>
<td>0</td>
</tr>
<tr>
<td>Components and parts containing toner and ink, including liquids, semi-liquids (gel/paste) and toner</td>
<td>Include the cartridges, print heads, tubes, vent chambers, and service stations.</td>
<td>0</td>
</tr>
<tr>
<td>Components and waste containing asbestos</td>
<td></td>
<td>0</td>
</tr>
<tr>
<td>Components, parts and materials containing refractory ceramic fibers</td>
<td></td>
<td>0</td>
</tr>
</tbody>
</table>
2.0 Tools Required

List the type and size of the tools that would typically be used to disassemble the product to a point where components and materials requiring selective treatment can be removed.

<table>
<thead>
<tr>
<th>Tool Description</th>
<th>Tool Size (if applicable)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Electric Screwdriver #1</td>
<td>Cross and Flathead and Hex</td>
</tr>
<tr>
<td>Electric Screwdriver (S-4000MS) #2</td>
<td>Bits Type: T15, φ=5mm, L=60mm</td>
</tr>
<tr>
<td>Electric Screwdriver (XW0318LS) #3</td>
<td>Bits Type: Flathead, T=2.0mm</td>
</tr>
<tr>
<td>Heater #4</td>
<td>--</td>
</tr>
</tbody>
</table>

3.0 Product Disassembly Process

3.1 List the basic steps that should typically be followed to remove components and materials requiring selective treatment:

1. Follow steps described in Disassembly instruction (file attached)
2. If parts can be removed without using a tool, remove it first
3. Use correct screwdriver and torque value before unlock the screw.
4. 
5. 
6. 
7. 
8. 
9.

3.2 Optional Graphic. If the disassembly process is complex, insert a graphic illustration below to identify the items contained in the product that require selective treatment (with descriptions and arrows identifying locations).
# MANUFACTURING PROCESS INSTRUCTIONS

## MECHANICAL ASSEMBLY

### MODEL: Schumi27

<table>
<thead>
<tr>
<th>Sub-assembly name:</th>
<th>Schumi27 DISASS'Y SOP</th>
</tr>
</thead>
<tbody>
<tr>
<td>Document No.:</td>
<td>Schumi27 DISASS'Y SOP</td>
</tr>
<tr>
<td>Written by:</td>
<td>Ethan Lai</td>
</tr>
<tr>
<td>Date:</td>
<td>2016/7/15</td>
</tr>
<tr>
<td>Revision:</td>
<td>1.00</td>
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</tbody>
</table>

### A. Current station version list:

<table>
<thead>
<tr>
<th>Station</th>
<th>Version</th>
<th>Station</th>
<th>Version</th>
<th>Station</th>
<th>Version</th>
<th>Station</th>
<th>Version</th>
<th>Station</th>
<th>Version</th>
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</table>

### B. Version Modify list:

<table>
<thead>
<tr>
<th>Date</th>
<th>Station</th>
<th>Content</th>
<th>Ver.</th>
<th>Design</th>
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<tbody>
<tr>
<td>2016/7/15</td>
<td>ALL</td>
<td>First version</td>
<td>1.**</td>
<td>Magic Zhang</td>
</tr>
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</table>

Auditor: Ethan Lai  Tabulator: Xin-Xin Chen
Standard Operation Procedure

Document No. : Schumi27 DISASS'Y SOP  Operation Name : Take out Stand Bottom Cover_1
Station : 1(1/1)  Ver. : 1.00  Date : 2016/7/12

Steps :

1. Put the machine on the working table (Fig. 1).
   - Place the machine as illustrated.

2. Unscrew (Cross × 11) all joints to take out Stand Bottom Cover_1 (Fig. 2, 3).
   - Finally loosen the set screw × 2, so that the cover is bounced.
   - Torsion: 4.0 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.

Glove Requirements: Half-finger gloves

Fixtures:

<table>
<thead>
<tr>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Electric Screwdriver (S-4000MS)</td>
<td>1</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Bits Type: T15, φ=5mm, L=60mm</td>
<td>1</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Bits Type: #2, Cross</td>
<td>1</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Working Table</td>
<td>1</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Note: If finding anything uncommon, notice foreman or assistant at once.

Tabulator : Xin-Xin Chen  Auditor : Ethan Lai  Issue Department : NPSU-PPE
Standard Operation Procedure

Document No.: Schumi27 DISASS'Y SOP
Operation Name: Take out Stand Bottom Cover_2
Station: 2(1/1)
Ver.: 1.00
Date: 2016/7/12

Steps:

1. Unscrew (Cross × 6) all joints to take out Stand Bottom Cover_2 (Fig. 1).
   - Torsion: 4.0 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.

2. Disconnect all the cables from the following connectors (Fig. 2).
   - Connectors: Speaker, Sub-battery, Scalar-1, Scalar-2, Scalar-3, FAN, WLAN card (need to tear off the acetate tapes), HDD, Volume Dial/B.

Glove Requirements: Half-finger gloves

<table>
<thead>
<tr>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Electric Screwdriver (S-4000MS)</td>
<td>1</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Bits Type: #2, Cross</td>
<td>1</td>
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<td></td>
</tr>
</tbody>
</table>

Note: If finding anything uncommon, notice foreman or assistant at once.
Standard Operation Procedure

Document No. : Schumi27 DISASS’Y SOP
Operation Name : Take out Speaker

Steps:

1. Unscrew (Torx Pin-Head × 2) the both screws (Fig. 1, 2).
   - Torsion: 4.0 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.

2. Take out Speaker (Fig. 3).
   - Be careful not to damage the hook of the underside of Speaker.
   - Be careful not to collide the components of M/B.

Glove Requirements: Half-finger gloves

<p>|</p>
<table>
<thead>
<tr>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Electric Screwdriver (S-4000MS)</td>
<td>1</td>
<td>Bits Type: T15, φ=5mm, L=60mm</td>
<td>1</td>
</tr>
</tbody>
</table>

Note: If finding anything uncommon, notice foreman or assistant at once.

Tabulator: Xin-Xin Chen  Auditor: Ethan Lai  Issue Department: NPSU-PPE
Glove Requirements: Half-finger gloves

Steps:

1. Unscrew (Cross × 3) all joints to take out FAN (Fig. 1).
   - Torsion: 4.0 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.

2. Take out Sub-battery (Fig. 2).
   - Tear off Sub-battery from M/B directly.

Note: If finding anything uncommon, notice foreman or assistant at once.

<table>
<thead>
<tr>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Electric Screwdriver (S-4000MS) Bits Type: #2, Cross</td>
<td>1</td>
<td></td>
<td>1</td>
</tr>
</tbody>
</table>
Standard Operation Procedure

Document No. : Schumi27 DISASS’Y SOP  
Operation Name : Take out SSD, WLAN, DDR and CPU  
Ver. : 1.00  
Date : 2016/7/12  
Station : 5(1/1)

Steps:

1. Unscrew (Cross × 1) one screw to take out SSD (Fig. 1).
   - Torsion: 2.0 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.

2. Unscrew (Cross × 1) one screw to take out WLAN card (Fig. 2).
   - Torsion: 2.0 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.

3. Take out DDR (Fig. 3).
   - Expand the springs on the both sides of the DDR socket.

4. Take out CPU (Fig. 4).
   - Open the bracket by pulling off the link and take out CPU.
   - For with GPU machine, need to loosen two screws (Cross × 2) marked in green circles with torsion: 3.0 ± 0.5 kgf.cm (Fig. 5).

Fixure list (Specification)  
<table>
<thead>
<tr>
<th>Qty.</th>
<th>Fixtrue list (Specification)</th>
<th>Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Electric Screwdriver (S-4000MS)</td>
<td>1</td>
</tr>
<tr>
<td>1</td>
<td>Bits Type: #1,Cross</td>
<td>1</td>
</tr>
</tbody>
</table>

Glove Requirements: Half-finger gloves

Note: If finding anything uncommon, notice foreman or assistant at once.
Standard Operation Procedure

Document No. : Schumi27 DISASS’Y SOP
Operation Name : Take out Thermal Module

Steps :
1. Unscrew five screws (× 5) to take out the Thermal Module w/o GPU part (Fig. 1); unscrew nine screws (× 9) to take out the Thermal Module with GPU part (Fig. 2).

   - Torsion: 4.0 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.
   - Unscrew the screw #1 half, then unscrew the others, and finally unscrew the #1 to prevent deformation of Thermal Module.

Glove Requirements: Half-finger gloves

Fixtures list (Specification) | Qty. | Fixtures list (Specification) | Qty.
--------------------------------|------|--------------------------------|------
Electric Screwdriver (S-4000MS) | 1    | Bits Type: T15,φ=5mm,L=60mm   | 1    
Bits Type: #2,Cross            | 1    |                                |      

Note: If finding anything uncommon, notice foreman or assistant at once.

Tabulator : Xin-Xin Chen        Auditor : Ethan Lai    Issue Department : NPSU-PPE
Steps:

1. Unscrew the hexagonal Stand-off screw × 4 (Fig. 1, 2).

- Torsion: 6.5 ± 0.5 kgf.cm
- Take the screwdriver vertically to the screw holes.

Note: If finding anything uncommon, notice foreman or assistant at once.

<table>
<thead>
<tr>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Electric Screwdriver (S-4000MS)</td>
<td>1</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Bits Type: Flathead</td>
<td>1</td>
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<td>1</td>
</tr>
</tbody>
</table>
Standard Operation Procedure

Document No. : Schumi27 DISASS’Y SOP  
Operation Name : Take out M/B  
Station : 8(1/1)  
Ver. : 1.00  
Date : 2016/7/12

Glove Requirements: Half-finger gloves

Steps:

1. Unscrew (Cross × 3) all joints to take out M/B (Fig. 1).

   - Torsion: 4.5 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.
   - Take out M/B obliquely upward from the opposite direction of the connector side of the cover.

<table>
<thead>
<tr>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Electric Screwdriver (S-4000MS)</td>
<td>1</td>
<td>Bits Type: #2, Cross</td>
<td>1</td>
</tr>
</tbody>
</table>

Note: If finding anything uncommon, notice foreman or assistant at once.

Tabulator: Xin-Xin Chen  
Auditor: Ethan Lai  
Issue Department: NPSU-PPE
Glove Requirements: Half-finger gloves

Steps:

1. Tear off the acetate tapes and unscrew one screw (× 1) to take out Stand Top Cover ASS’Y (Fig. 1, 2).

   ▶ Torsion: 14.0 ± 0.5 kgf.cm
   ▶ Take the screwdriver vertically to the screw holes.

Note: If finding anything uncommon, notice foreman or assistant at once.

<table>
<thead>
<tr>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Electric Screwdriver (XW0318LS)</td>
<td>1</td>
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<tr>
<td>Bits Type: Flathead,T=2.0mm</td>
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</tr>
</tbody>
</table>

Tabulator: Xin-Xin Chen  Auditor: Ethan Lai  Issue Department: NPSU-PPE
Glove Requirements: Half-finger gloves

Steps:

1. Unscrew three screws ($\times$ 3) illustrated as Fig. 1, then unscrew four screws ($\times$ 4) illustrated as Fig. 2.
   - Torsion: $4.5 \pm 0.5$ kgf.cm
   - Take the screwdriver vertically to the screw holes.

2. Take out BRACKET and HINGE STAND (Fig. 3).
   - Pull out all the cables from BRACKET and HINGE STAND.

Note: If finding anything uncommon, notice foreman or assistant at once.

<table>
<thead>
<tr>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
</tr>
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<tbody>
<tr>
<td>Electric Screwdriver (S-4000MS)</td>
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<tr>
<td>Bits Type: T15,$\phi=5$mm,$L=60$mm</td>
<td>1</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
Glove Requirements: Half-finger gloves

Steps:

1. Tear off the shading sponge and unscrew (×2) all joints to take out Power/B (Fig. 1).
   - Torsion: 4.5 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.

2. First unscrew (×1) the joint, then slide upward HDD ASS’Y to take out (Fig. 2).
   - Torsion: 4.5 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.

3. First disconnect HDD cable, then unscrew (×4) all joints to separate HDD and HDD bracket (Fig. 3).
   - Torsion: 4.5 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.

Note: If finding anything uncommon, notice foreman or assistant at once.

<table>
<thead>
<tr>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
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</thead>
<tbody>
<tr>
<td>Electric Screwdriver (S-4000MS) Bits Type: #2,Cross</td>
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</table>
**Standard Operation Procedure**

Document No. : Schumi27 DISASS’Y SOP  
Operation Name : Take out M/B Shielding  

Ver. : 1.00  
Date : 2016/7/12

### Steps:

1. **Unscrew (× 3) all joints for M/B Shielding (Fig. 1).**
   - **Torsion:** 4.0 ± 0.5 kgf.cm
   - **Take the screwdriver vertically to the screw holes.**

2. **Tear off the acetate tape of Volume Dial/B cable and unfix the hooks (× 11) to obliquely take out M/B Shielding (Fig. 2, 3, 4).**

### Fixture list (Specification)

<table>
<thead>
<tr>
<th>Electric Screwdriver (S-4000MS) Bits Type: #2,Cross</th>
<th>Qty.</th>
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<tbody>
<tr>
<td></td>
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</table>

**Note:** If finding anything uncommon, notice foreman or assistant at once.

Tabulator : Xin-Xin Chen  
Auditor : Ethan Lai  
Issue Department : NPSU-PPE
Glove Requirements: Half-finger gloves

Steps:

1. Slide downward STAND ARM_REAR COVER and unscrew (T-20 x 1) the joint (Fig. 1).
   - Torsion: 14.0 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.

2. Unscrew the self tapping screw (x 1) to take out STAND ARM_FRONT COVER (Fig. 2).
   - Torsion: 2.5 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.

3. Pull out four cables to take out HINGE STAND ARM (Fig. 3).

Note: If finding anything uncommon, notice foreman or assistant at once.

<table>
<thead>
<tr>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Electric Screwdriver (S-4000MS)</td>
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<td>Bits Type: Hex.</td>
<td>1</td>
</tr>
</tbody>
</table>

Tabulator: Xin-Xin Chen  
Auditor: Ethan Lai  
Issue Department: NPSU-PPE
Steps:

1. Press the region of webcam to pull open Rear Cover (Fig. 1).

2. Use the stick to pull open the region of webcam for lever force to unfix the hooks between the Rear Cover and Middle Cover (Fig. 2, 3).

3. First hold the region of webcam, then insert fingers inside to upward pull open the inner hooks to take out Rear Cover (Fig. 4, 5).

   ➤ When pull out cables from Rear Cover, be careful not to scrape Rear Cover.

Note: If finding anything uncommon, notice foreman or assistant at once.

<table>
<thead>
<tr>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Plastic Stick</td>
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</tbody>
</table>

Tabulator: Xin-Xin Chen  
Auditor: Ethan Lai  
Issue Department: NPSU-PPE
Standard Operation Procedure

Document No. : Schumi27 DISASS'Y SOP Operation Name : Take out Scalar/B Shielding
Station : 15(1/1) Ver. : 1.00 Date : 2016/7/12

Glove Requirements: Half-finger gloves

**Steps:**

1. Unscrew (Cross x 5) all joints to take out Scalar/B Shielding (Fig. 1, 2).
   - Torsion: 2.0 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.

Fig. 1

Fig. 2

**Note:** If finding anything uncommon, notice foreman or assistant at once.

<table>
<thead>
<tr>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Electric Screwdriver (S-4000MS)</td>
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</tr>
<tr>
<td>Bits Type: #1, Cross</td>
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</tbody>
</table>
### Standard Operation Procedure

**Document No.:** Schumi27 DISASS’Y SOP  
**Operation Name:** Disconnect cables  
**Ver.:** 1.00  
**Date:** 2016/7/12

#### Fixture list (Specification) | Qty. | Fixture list (Specification) | Qty.
--- | --- | --- | ---

#### Gloves Requirements: Half-finger gloves

#### Steps:

1. Tear off the acetate tapes (× 2) and the heat sink (× 1) illustrated as figures.

2. Disconnect all the cables as below (Fig. 1, 2, 3).

- Cables: Scalar_1, Touch, WLAN Antenna, Back Light, LVDS 50Pin & 40Pin, Webcam, Holder Sensor.

![Fig. 1](image1)

![Fig. 2](image2)

![Fig. 3](image3)

- Heat Sink X 1
- WLAN Antenna
- Acetate Tape X 2
- Back Light
- LVDS Cable

**Note:** If finding anything uncommon, notice foreman or assistant at once.
Standard Operation Procedure

Document No. : Schumi27 DISASS'Y SOP
Operation Name : Take out Webcam ASS'Y

Steps :
1. Take out Springs (× 2) (Fig. 1).

2. Take out Door Lock and Holder Sensor Cable (Fig. 2).
   - Need to pry open the hook obliquely to take out Holder Sensor Cable.

3. Unscrew (× 1) to take out Reduction Gear (Fig. 2).
   - Torsion: 2.5 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.

4. Slide upward Webcam ASS'Y to take out from bracket (Base Pan) (Fig. 3).

Note: If finding anything uncommon, notice foreman or assistant at once.

<table>
<thead>
<tr>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
<th>Fixture list (Specification)</th>
<th>Qty.</th>
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<td>Bits Type: #1,Cross</td>
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</table>

Tabulator : Xin-Xin Chen        Auditor : Ethan Lai        Issue Department : NPSU-PPE
Steps:

1. Unscrew the screws (Torx Pin-Head × 8) illustrated as Fig. 1.

- Torsion: $4.5 \pm 0.5$ kgf.cm
- Take the screwdriver vertically to the screw holes.

Glove Requirements: Half-finger gloves

<table>
<thead>
<tr>
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Standard Operation Procedure

Document No. : Schumi27 DISASS’Y SOP  Station : 19(1/1)
Operation Name : Unscrew Base Pan  Ver. : 1.00  Date : 2016/7/12

Glove Requirements: Half-finger gloves

Steps:

1. Unscrew the screws (Torx Pin-Head × 11) illustrated as Fig. 1.
   - Torsion: 4.5 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.

Note: If finding anything uncommon, notice foreman or assistant at once.

<table>
<thead>
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</table>

Tabulator: Xin-Xin Chen  Auditor: Ethan Lai  Issue Department: NPSU-PPE
Standard Operation Procedure

Document No.: Schumi27 DISASS’Y SOP
Operation Name: Take out Base Pan & Middle Cover

Station: 20(1/1)
Ver.: 1.00
Date: 2016/7/12

Glove Requirements: Half-finger gloves

Steps:

1. Take out Panel (Fig. 1).

2. Unfix the hooks (×11) between the Base Pan and Middle Cover to take out Base Pan obliquely (Fig. 2, 3).

Note: If finding anything uncommon, notice foreman or assistant at once.

<table>
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</tbody>
</table>

Fig. 1

Be careful not to damage Panel

Fig. 2

Note cables

Take out obliquely

Fig. 3

Tabulator: Xin-Xin Chen  Auditor: Ethan Lai  Issue Department: NPSU-PPE
Steps:

1. Unscrew (x 3) all joints to take out Scalar/B (Fig. 2, 3).
   - Torsion: 4.5 ± 0.5 kgf.cm
   - Take the screwdriver vertically to the screw holes.

2. Tear off the acetate tape (x 1) and the heat sink (x 2) illustrated as Fig. 1.

3. Take out Scalar-2 and Scalar-3 cables from Scalar/B (Fig. 1).

Note: If finding anything uncommon, notice foreman or assistant at once.

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Tabulator: Xin-Xin Chen  Auditor: Ethan Lai  Issue Department: NPSU-PPE
### MANUFACTURING PROCESS INSTRUCTIONS
#### MECHANICAL ASSEMBLY

**MODEL : AIO Schumi27**

<table>
<thead>
<tr>
<th>Sub-assembly name:</th>
<th>Schumi27 Touch Glass DISASS'Y SOP</th>
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<tbody>
<tr>
<td>Document No.:</td>
<td>Schumi27 Touch Glass DISASS'Y SOP</td>
</tr>
<tr>
<td>Written by:</td>
<td>Ethan Lai</td>
</tr>
<tr>
<td>Date:</td>
<td>2016/5/5</td>
</tr>
<tr>
<td>Revision:</td>
<td>1.00</td>
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<tr>
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<td>1 of 1</td>
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#### A. Current station version list:

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#### B. Version Modify list:

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<th>Ver.</th>
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<td>ALL</td>
<td>First version</td>
<td>1.**</td>
<td>Blake Lin</td>
</tr>
</tbody>
</table>

Auditor: Ethan Lai  Tabulator: Xin-Xin Chen
Steps:

1. Switch on the heater to warm up (Fig. 1, 2).
   - Temperature: 80°C +/- 5°C
   - Warm-up Time: 5 minutes

2. Put the touch glass on the heater, cover the lid, and switch on the button (Fig. 3, 4).

Note: If finding anything uncommon, notice foreman or assistant at once.

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<td>Heater</td>
<td>1</td>
<td>Plastic stick</td>
<td>1</td>
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</table>

Tabulator: Xin-Xin Chen  
Auditor: Ethan Lai  
Issue Department: NPSU-PPE
**Steps:**

3. Switch off the power button when the red lamp lighted and the buzzer sounded (Fig. 5).

4. Take out the glass from the heater, and put the glass side facing up on the working table (Fig. 6).

5. Use the stick to slash the VHB glue between bracket and glass for lever force to separate, and insert the plates to the separated (Fig. 7).

6. Turn over the glass, take out the 4 brackets (Fig. 8, 9).

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**Note:** If finding anything uncommon, notice foreman or assistant at once.

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