

M1: SCM TLM LCM 3 Milestone**Product:** Jerry**LCM 3 Production Technology
Management**

Mr. Schulte

Date: _____

Sign: _____

**LCM 3 Production Technology
Management
Project Manager**

Dr. Hilker

Date: _____

Sign: _____

Herewith the M1 LCM 3 - Milestone isdeclared ☐declared with restrictions ☒is not declared ☐**LCM Lifecycle Management**Mr. Dörne
(or substitute)

Date _____

Sign _____

Short summary / comments / restrictions:make-or-buy decision for VF logo on battery cover still not fixed and has to be done before S15!
packaging concept not fixed**Distribution List:**

PL Project Manager

Mr. Bonde

CCQ Product Quality

Mr. Bartel
Mr. Sondergaard

BA C

Gao Jie (w/o attachments)

LCM1

Mr. Riedel

Attachment:

M1 PT

General Information

Milestones

	Target	Reached
M0	17.03.2006	27.02.2006
S0	17.03.2006	13.03.2006
M1	31.03.2006	
S15	25.04.2006	
S2	18.07.2006	
S25	18.07.2006	
SD-S3	17.08.2006	
S3	17.08.2006	
PS	08.09.2006	
DS	22.09.2006	
SD-S4	28.10.2006	
S4	01.11.2006	
SD-M3	tbd	
M3	01.12.2006	

Planned prototype runs

Tape out	Main	MMI	FPC
A1	01.03.2006	no MMI	
A1+	31.03.2006		
B1	05.05.2006		
B2	21.06.2006		
Pilot	tbd		
Prototype run	SMT	Assembly	
A1	09.03.2006	26.05.2006 17.07.2006	
A1+	12.04.2006		
B1	17.05.2006		
B2	03.07.2006		

Volumes / Sites

Site	Peak Vol.	RU Date	Transfer Date
Klf	not planned		
SSMC	50k	08.09.2006	22.09.2006
Man	not planned		
Zal			

Checklist acc. to MEP

	Yes	No
Project plan in Primavera on work-package level until M3 showing dedicated resources by name	*1 <input type="checkbox"/>	<input checked="" type="checkbox"/>
Milestone planning is in accordance with prototype runs, PTR, FRT, ramp up plan and ramp up volume	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Committed realization plan for new product technologies is available	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Committed realization plan for new production technologies is available	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Committed calculation for process times, special tooling cost and F1 hours are available	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Committed production process flow layout is available	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Committed production process quality targets are available	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Committed result out of production and test workshop is available	<input checked="" type="checkbox"/>	<input type="checkbox"/>
Part declaration PT is available	<input checked="" type="checkbox"/>	<input type="checkbox"/>
1) not all resources in BMS are available in Primavera; BMS has to finish planning until S15		

Checklist internal

Yes No

Availability of resources LCM 3 are secured until SD-S4

☒ ☐

List of restrictions, open points and action items have been defined

☒ ☐

Production targets in performance description included

☒ ☐

PT action items addressed to PD team are committed and listed in the PD team minutes

☒ ☐

Ramp up categorie is fixed and line set up time for new tasks is committed

☒ ☐

	ramp up categorie	days
SMT	2	5
SMT2		
Assembly		
A2T		
Config		

Info / Attachments

New Product Technologies

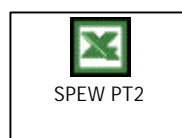
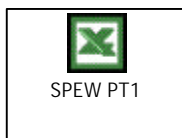
Technology	Status	Owner
Sliding switch for keypad lock	MR sensor on PCB with corresponding magnet in mounting frame (lower case)	MD (Christian Primdahl Nielsen)
On-Off key	Button on the top of the phone, Alps Microswitch on the PCB	MD (Christian Primdahl Nielsen)

New Production Technologies

Technology	Status	Owner
A new router will be used for panel separating. Jerry panel design has to be checked if one panel design for both separating technologies is feasible or if two separate panel designs are necessary.	review of A1 layout done and send to MD A1+ layout in preparation and will be checked after tapeout	Huo QiZhong (PT1 BMS)

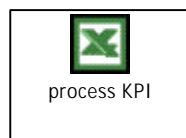
Process times / Special tooling cost / F1 hours

Attachment



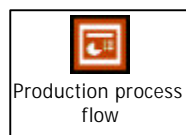
Production process quality targets

Attachment








Production process flow

Attachment



Action Items

Action / Status	Owner	Date
1) LCM responsibility will be hand over from KLf to BMS after S15	Info	
2) A1 and A1+ will take place in KLf, effective from B1 only BMS is production site	Info	
3) Production site is BMS	Info	
4) Customer test will be qualified on the manual test system from Engmatec. If required the automatic system will be qualified in BMS later, based of the utilization/capacity of the production site. This qualification need approximately 6 week. CM has to be involved in this discussion	info	
5) Production technology workshop with focus on assembly concept held - assembly concept is accepted by PT1	info	
 PTWS-Assembly		
6) Production technology workshop with focus on board-level-testing and device-level-testing held - concept is accepted by PT2	info	
 PTWS - board-level-testing RFT  PTWS - board-level-testing SAT  PTWS - device-level-testing  Testcases CT		
7) Prototype quantities have to be provided by TPM	Bonde	DONE
8) Display rotation by 180 degree: tape on earpiece needed; in-house assembly because earpiece is also used in other projects F1 hours updated accordingly		
Tolerance calculation initiated: If possible avoid tape to save money	Christian P.Nielsen	S15
9) Round VF label has to be glued on battery cover -> Make-Or-Buy-Decision open TPMs have to check how many different variants are possible number of expected variants still open, final decision until S15 needed	Bonde/Broeze/Song (TPMs)	S15
Make-Or-Buy decision has to be done afterwards considering costs and variance of BC	PT1/TPM	S15
Evaluate concept for production avoiding misalignemt	PT1	S15

Action Items

Action / Status	Owner	Date
10) RF shielding (same as in Aries) has an interior angle greater than 180 degree; find out about failure rate in Aries and evaluate production risks Check if prem can variant is available No prem can variant is available; because of the lifecycle volume of 450k we may accept fish can solution	Hilker / PT1	DONE
11) Evaluate feasibility in Jerry to use a standard SW for production	YongQiang Yang (SW), JingWen Gong (LCM3), Arjen Broeze, Sara Song (TPM)	S3 (17.08.06)
12) Alps Microswitch for On/Off key: SIPLACE accuracy is not suitable to use the component with taps -> has to be considered for the component selection ALPS SKRE without taps will be used and is being created in SAP right now	Christian P. Nielsen	DONE
13) Primavera planning: not all resources in BMS are available in Primavera; BMS has to finish planning until S15	JingWen Gong (LCM3) and PT	S15
14) Packaging concept still under discussion with VF, but filling concept according to production line concept (hint is placed in the M1 document)	TPM	S15