

# M1: SCM TLM LCM 3 Milestone

**Product:** Onyx

**LCM 3    Production Technology  
          Management**

Mr. Schulte

Date: 24.02.2006  
Sign: \_\_\_\_\_

**LCM 3    Production Technology  
          Management  
          Project Manager**

Mr. Waschowski

Date: 24.02.2006  
Sign: \_\_\_\_\_

## Herewith the M1 LCM3-Milestone is

declared ☐

declared with restrictions ☐

is not declared ☐

**LCM        Lifecycle Management**

Mr. Dörne  
(or substitute)

Date 24.02.2006  
Sign \_\_\_\_\_

### Short summary / comments / restrictions:

- Test-/Cycle times and output of volumes based on a stable mobile software; if the software shows unexpected side-effects the output and cycletimes can decrease up in major dimensions.
- The quality of mobile software will have a major impact of the deliveries of the prototype shop, as well the SCM milestones S25 & S3
- If all NB-Components will used, the cycle time of SMT-line has to be recalculated and will reduce the lineoutput.
- The force which is needed for testing the keys on slider part is limited with the standard pressures of the factory (20Newton).
- The focus cameratest is not part the cycletime calculations, if this test is needed recalculations has to be started.
- The toleranz analyses between 3,2MPix Camera to PCB and housing is missing from MD; See attached mail; mounting of housing can cause camera defects.

### Distribution List:

PL	Project Manager	Mr. Feldhoff	
CCQ	Product Quality	Mr. Krepke	
BA C		Mr. Wilson	(w/o attachments)
LCM1		Mr. Gillitzer	

### Attachment:



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**SCM TLM LCM**

<b>General Information</b>
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**Milestones**

	Target	Reached
<b>M0</b>	23.12.2005	09.01.2006
<b>S0</b>	19.01.2006	20.01.2006
<b>M1</b>	24.02.2006	
<b>S15</b>	31.03.2006	
<b>S2</b>	15.05.2006	
<b>S25</b>	04.07.2006	
<b>SCM-S3</b>	25.08.2006	
<b>S3</b>	25.08.2006	
<b>PS</b>	19.09.2006	
<b>DS</b>	20.10.2006	
<b>SCM-S4</b>		
<b>S4</b>	10.11.2006	
<b>SCM-M3</b>	tbd	
<b>M3</b>	tbd	

**Planned prototype runs**

Tape out	Main	MMI	FPC
A1	13.02.2006		
B1	03.04.2006		
B1+	23.05.2006		
B2(B1++)	05.07.2006		
Pilot	11.08.2006		
<b>Prototype run</b>			
A1	27.02.2006		
B1	18.04.2006		
B1+	07.06.2006		
B2(B1++)	14.07.2006		

**Volumes / Sites**

Site	Peak Vol.	RU Date	Transfer Date
Klf	90K	19.09.2005	
SSMC			
Man			
Zal			

**Checklist acc. to MEP**

Yes No

Project plan in Primavera on work-package level until M3 showing dedicated resources by name

☒ ☐

Milestone planning is in accordance with prototype runs, PTR, FRT, ramp up plan and ramp up volume

☒ ☐

Committed realization plan for new product technologies is available

☒ ☐

Committed realization plan for new production technologies is available

☒ ☐

Committed calculation for process times, special tooling cost and F1 hours are available

☒ ☐

Committed production process flow layout is available

☒ ☐

Committed production process quality targets are available

☒ ☐

Committed result out of production and test workshop is available

☒ ☐

Part declaration PT is available

☒ ☐

**Checklist internal**

Yes No

Availability of resources LCM3 are secured until SCM-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	date
SMT	UMTS	S25
SMT2	UMTS	S25
Assembly	High/Flex/5Tower solution	S25
A2T	High / Flex	S25
Config	UMTS	S25

## Info / Attachments

### New Product Technologies

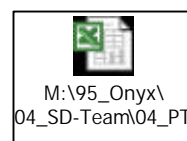
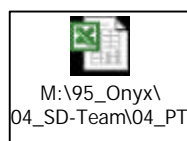
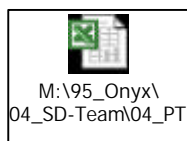
Technology	Status	Owner
Gluing of one Label over two shieldings	started	Hessel
Use of new 3 Mpix AF camera and influence on assembly	Will qualified during prototype runs	Hessel
New 5x5 mm VT camera	Will qualified during prototype runs	Hessel
Through board camera socket	Will qualified during prototype runs	Hessel
Swivel and gluing of hardcap keypad in slider	Will qualified during prototype runs	Hessel

### New Production Technologies

Technology	Status	Owner
FSR Foil Autofocus Camera Double Action Key	Will qualified during prototype runs	Möllenbeck
Use of new routing technology for panel separation	Will qualified during prototype runs	Hessel

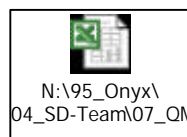
### Process times / Special tooling cost / F1 hours

Attachment



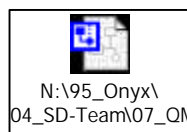
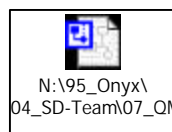
### Production process quality targets

Attachment



### Production process flow

Attachment



## Action Items

Action / Status	Owner	Date
In project swift the transflash reader won't be tested, the same problems / effects were shown in Swift. Actual status: reader will not tested electrical	Waschkowski	Info !
Gluing Label on Shielding (A²T Line or MDF-placer)	Hessel	S2
no ID concept: battery cover, keypad (keypad glueing tolerances has to be adapted like swift)	Hessel	S2
Test Transflash Reader Fall Back Solution (Test in CT ) is not possible Modification of Transflash Reader - Plastic Part with drill hole to center the testadapter requires commitment of supplier	Gräbsch	S2
no additonal manually assembly	Hessel	info
Prototype shop test of autofocuscamera with two steps	Möllenbeck	S2
Tolerance analysis of 3 Mpix AF camera to housing	Hessel	S15

**BENQ mobile****Communications  
Supply Chain Management Devices****M1: SCM TLM LCM 3 Milestone****Product:** Onyx**LCM 3    Production Technology  
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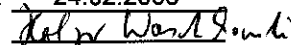
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**Attachment:****SCM TLM LCM****M1  
LCM3-Milestone Declaration****24.02.2006****Page 1**