

Sequence of Events (SOE)

Process Name: ModelTruck Assembly

Revision: 3

	Setup	Work	Move	
V	Machine	Labor	Machine	Labor
A	Machine	Labor	Machine	Labor

Cycle Time Picture Task Description

This document is nothing more than a Microsoft Word™ table with both a header and footer. VMS Factory® allows free-form text entry and doesn't limit what you can type in for text, nor how many process steps or pictures you can have in any one process or Visual Method Sheet. Actually, you can use any word processor or text editing software sufficiently powerful enough to create a text only file. VMS Factory® can also accept input created by your MRP or ERP system!

This is the SOE document used to actually build the 9-page VMS you find on our website. The text in boxes and markups (ovals and arrows) are not normally found in an SOE.

- MODEL TRUCK (Ex 3)**
- :REV EX 3
 - :EFFDATE 1 Jan 02
 - :Dialog OFF
 - :VMS# 1001
 - :CellsPerPage 2,3
 - :TextSize 7.5
 - :ICONS ON
 - :UFT ECO #:
 - :UFV 04-09-55
 - :PictPathNames OFF
 - :PictPreFix P0000
 - :PictDigitCount 3
 - :PictPostFix JPG
 - :LogoOffsetMode ABS
 - :LOGO "LPI Logo.jpg" 1.159, 0.267, ToFront
 - :LOGO "Header.cpt" 5.498, 8.147, ToFront
 - :LOGO "Message.cpt" 5.962, 0.284, ToBack

Highlights in BLUE are called VMS Directives and set certain options within the software to make running the software easier.

Highlights in YELLOW and items in this area are for Process Analysis Only - NOT REQUIRED for proper functioning of VMS Factory®.

Cab Assembly

082	1. Check PARTS against BOM	x			x			
083	2. Position the CAB BOX upside down with 4 HOLES facing up and position the FLAT SURFACE of the U-BRACE flush with the BOTTOM SURFACE of the CAB BOX aligning the HOLES as shown	x			x			x
084	3. Insert SCREW through the LEFT HOLE and secure with NUT on the INSIDE of the CAB BOX							
085	4. Tighten SCREW using TORQUE SCREWDRIVER - CAUTION: Do NOT over-tighten!	x			x			
086 1.1	5. Verify NUT is seated correctly	x			x			
	6. Verify SCREW is tight	x			x			x

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Cycle Time	Picture	Task Description	Machine	Labor	Machine	Labor	Machine	Labor			
	087	7. Insert SCREW through the RIGHT HOLE and secure with NUT on the INSIDE of the CAB BOX									
	088	8. Tighten SCREW using TORQUE SCREWDRIVER - CAUTION: Do NOT over-tighten!									
	089	9. Verify NUT is seated correctly	X			X					X
		10. Verify SCREW is tight		X		X					
		Wheel Assembly		X		X					
	090 1.2	1. Check PARTS against BOM		X		X					
	091 1.2	2. Hold the RIM with SPOKES facing the ASSEMBLER	X			X					X
	092 2.1	3. Slip the TIRE over the RIM with LIP of TIRE flush with SPOKE SIDE of RIM									
	093 2.1	4. Repeat the PREVIOUS 2 STEPS 3X (Creating 4 WHEEL ASSEMBLIES)	X			X					X
	094 1.1	5. Verify each TIRE (4X) is flush with its RIM	X			X					
		Truck Body Assembly	X			X					
	095 1.1	6. Check PARTS against BOM	X			X					
	331	7. Position the LEFT SIDE of the FRAME toward the ASSEMBLER placing the CAB between the TWO FORWARD HORIZONTAL RAILS as shown	X			X					
	132	8. Align the FORWARD HOLE of the LEFT SIDE of the CAB with the FORWARD HOLE of the LEFT HORIZONTAL RAIL	X			X					
	133	9. Align a WASHER between the FORWARD CAB and RAIL HOLES as shown (using the WASHER as a SPACER)	X			X					
	134	10. Insert SCREW through the FORWARD HOLE in the RAIL, through the WASHER and through the FORWARD HOLE of the CAB	X			X					X
	135	11. Place NUT on SCREW on the INSIDE of the CAB BOX	X			X					X
	099	12. Tighten SCREW using TORQUE SCREWDRIVER - CAUTION: Do NOT over-tighten!	X			X					
	100	13. Verify NUT is seated correctly	X			X					X
		14. Verify SCREW is tight	X			X					X