Work Instructions

Tool No.:	R225 Non-Open Vent Rope Tether		WI62	**Page** 1 of 7
Description:	Manual Assembly With/Without Pad Printing	**Approval:**	Houa Lee/lmw 9-11-24	

Follow instructions on the Line Clearance Sheet to prepare workstation for production.

Verify all Components at the workstation match the Components listed on the Production Specification Sheet.
Verify as needed component:
– color
– graphics
– size

When using P80

Stainless Steel bins 3JFX2375 must be used whenever P80 Lubricant is needed.
The Stainless Bins are easier to clean than plastic and prevent P80 build up.

Unless specifically stated in Work Inst

Do NOT apply P80 or other lubricant to the Gaskets or Rubber Valves.
Use of lubricant may interfere with the Gasket detection equipment or cause Valve to fail.

Scrap

Immediately place nonconforming parts into the scrap bin. Report the nonconforming quantity on the tally sheet at the end of each shift. Dispose of the parts after you report the quantity.

Work Instructions

Gasket Installation

Gasket Installation

1. Place gasket into inner body.
Use hand tool provided to properly seat gasket.

With each New Container, verify that you have the correct gasket per your production sheet.

Pawl/Felt Installation During Assembly

Pawl and Felt can be assembled in either order (Felt first or Pawl first) whichever way is easiest for you.

Not all part numbers require Felt.

1. Install Pawl into Inner Body so that the legs of the Pawl engage with the teeth of the Inner Body.
2. Slide Felt over Inner Body **if required.**

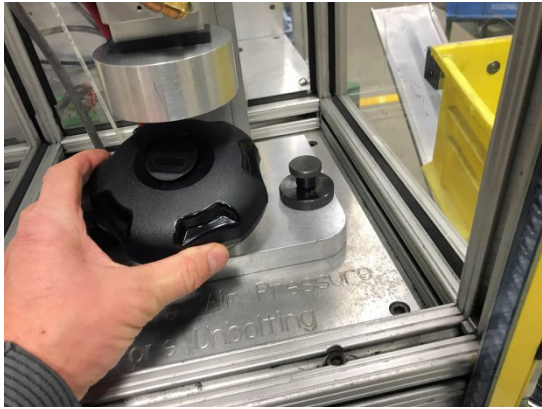3. Place Inner Body assembly onto nest of assembly machine.

4. Place Cap into top nest of assembly machine.

The assembly machine will automatically cycle when your hand is removed beyond the light curtain.
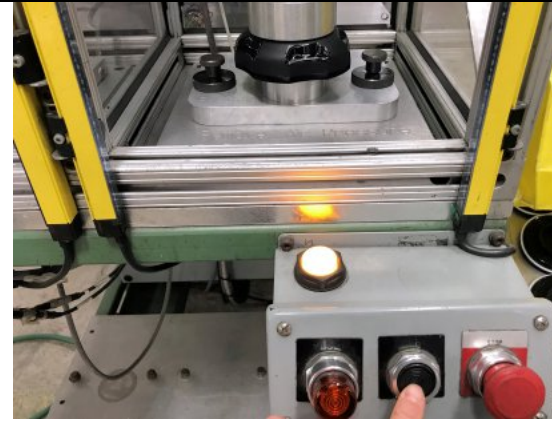
Work Instructions

ATEQ Leak Test
100%
When required. See BOE.

1. Place cap in tester.

Photo is an example.

2. Cycle tester, press start.

*Green light is a pass.

*Red light is a fail.
Red/Orange light will flash.
Press re-set button.

3. Verify Pass Test Mark.
Photo is an example.
New photo needed.

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Work Instructions

Laser Engraving

1. Load cap in laser engraver.

No orientation to Kelch logo is required.

2. Close door and cycle laser. The cycle will start when door is closed.

3. Remove assembly.

4. Verify Part Number, Date Code, and EPA Code or Customer Part Number, Etc. (if required) with print.
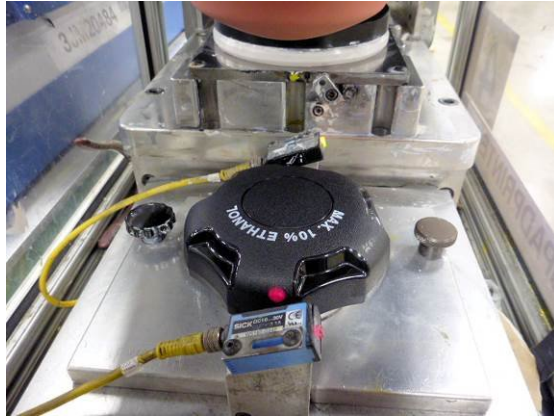
Laser engraving to be centered and legible on lug.

Must Verify with Print.

Torque Test Now
See WI 758 and chart.

5.

Work Instructions

Pad Printing During Assembly

1. Pad Print Now, when required.
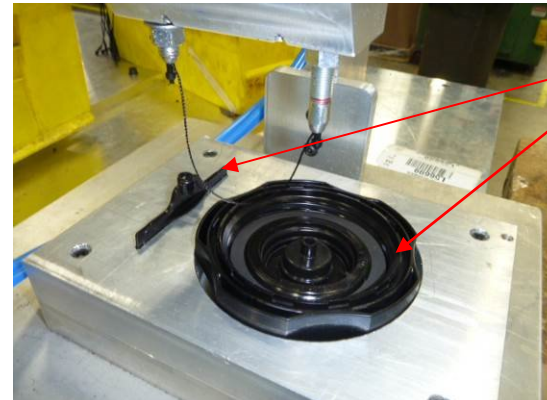   Use WI 349 and chart.

   Photo is an example.

Verify With Production Sheet If Pad Printing Is Required

Rope Tether Assembly
If Required, not all part numbers get a tether.

1. Place ends of Tether into tether machine.

2. Place **Cap** and **Anchor** into tether machine.
3. Press buttons to Cycle machine.
4. Verify correct assembly. *Tether ends need to be securely snapped into place.*

Acceptable

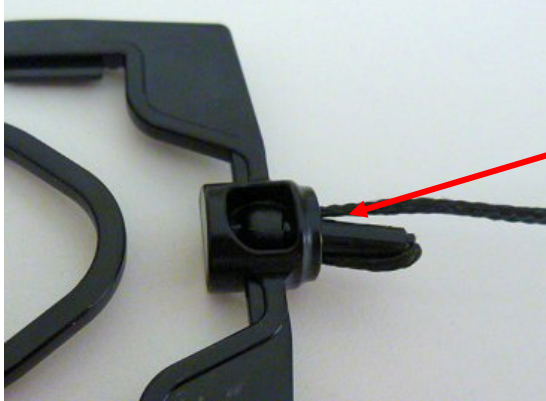The end of the ball socket is completely snapped in.

Unacceptable

The end of the ball socket is not completely snapped in.

Work Instructions

Unacceptable

The rope tether is pinned into the anchor.

Tether Pull Test Now, when you have a tether.
SEE WI 2432.

Work Instructions

PACKING without Tethers
1. Pack single layers of 9 layers per box.
2. 24 pcs per layer.
3. Place chipboard between layers.
4. Label completed carton.
5. Place completed carton on skid.
6. Place cable label on completed skid.

Verify quantities and packaging with production sheet.

Rope Tether Packaging

1. Place tether inside the cap assembly.

2. Place caps in bags or zip lock bags, when required.

Verify quantities and packaging with production sheet.

1. Neatly stack bags in carton.
2. Label carton.
3. Place completed carton on skid.
4. Place cable label on skid.

Verify quantities and packaging with production sheet.

3.