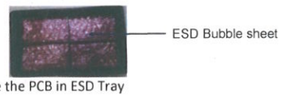
Standard Operating Sheet						Operation:- Automatic Function testing @ 13.5V			
Department	Interface Process Engg.	Signature				Revision History : Rev.01 - Document initially Review and found no any chage in ws - 16.04.2018 Rev 02 - Add new parts 5438 1621 2007 (TSC 04) & 5446 1623 1201 (TSC 05) - 24.01.2020	Document No.	97-19-DN1-1-260	Process Flow
Part Name	TPMS CONTROLLER	Name	Rohit Diwaker	Bharat	Rahul Yadav		Reference	NA	Testing-Voltage/Current Check & Microcontroller Programming @ 12V → Automatic Function testing @ 13.5V → Silicon adhesive application around MOV ,Capacitor & Antenna Fixing Point
		Authority	Prepared By	Review By	Approved By		Issue date	24.01.2020	
Part No.	5502 5480 0102 **(TSC 02)**, 5438 1621 2007 **(TSC 04)**, 5446 1623 1201 **(TSC 05)**						Rev No.	02	
Customer	TML	Date	10.08.2016				Rev. Date	24.01.2020	

Start Up Instruction

1. Working Table को साफ़ करें |
2. Power connection & Earthing को Check करें |
3. Check करें कि Testing jig & supply Properly connected हों |
4. Check करें कि instruments की Caliberation date expire ना हों |

Handling System:- ESD Tray with ESD Bubble sheet & Seperator use करें |



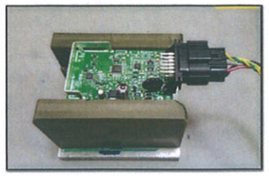
Place the PCB in ESD Tray

Before (Incoming Unit)

DOt mark of previous testing

During Process

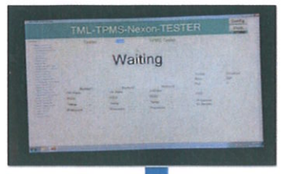
Work Flow Sequence



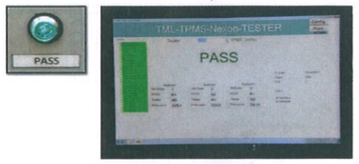
यूनिट को Fixture में Fix करें और Mating coupler के साथ connect करें |

Press START S/w

Start Testing Process



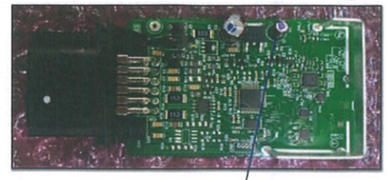
If PASS / If FAIL



If Part is **OK, Green** light will glow on Testing jig & **PASS** indication on monitor and Put DOT Mark on Part and Part put in ESD Tray.

If Part is **FAIL, RED** light will glow on Testing jig & Show **FAIL** indication on Monitor , After that part put in Red Tray with Reject Tag..

After Process



Dot mark after testing

NG Pictures For Reference (If any)

Environmental & Safety Instructions:-

(A)Product safety
1. ESD दस्ताने / Finger coats पहनें |
2. ESD Wrist band पहनें |
3. ESD jacket पहनें |

(B)Operater safety
1.कार्य करते समय सावधानी रखें |

Document Required:-

1. Daily/Monthly Rejection Sheet
2. Set up & FPA Sheet.
3. Startup check sheet.
4. Rework Part verification sheet

Tools required	Equipment Required
NA	Automatic Test Setup, Power supply

Significant Characteristics:-

1. Product:-
2. Process:-

Set-up Instruction:-
1. Power Supply को Test setup के साथ कनेक्ट करें |
2. Positive Supply wire को Test Jig के Red Socket के साथ और Neutral supply wire को Black socket के साथ Testing Jig पर Connect करें |
3. Power supply में Power switch को ON करें |
4. Select 13.5V on power supply voltage.
5. Monitor को ON करें और TPMS Softwere को Open करें।
6. +B S/w को ON करें |
7. COM और Running part के अनुसार Program select करें |
8. OK तथा NG Master sample के साथ Set-up Verification करें ,और उसका Data Setup & FPA Sheet में भरें |

Abnormal Conditions:-
Shop floor पर कार्य करते समय निम्नलिखित abnormal situations आ सकती हैं |
1. Fallen part on shop floor
2. Part related problem continues rejection more than or equal to 3 Nos.
3. Test setup Breakdown
Reaction Plan:- उपरोक्त abnormal situations आने पर operator तुरंत अपने लाइन इंचार्ज को सूचित करें |
Other abnormal situations:- अन्य abnormal situations के लिए **MANAGEMENT OF ABNORMAL SITUATION (Doc.No.-WI-12-01)** में दिए गए निर्देशों का पालन करें |

Checkpoints :-
1. Check all parameter as per PCS.

Reaction Plan
प्रोडक्ट की Quality में कमी आने पर उस Unit को रिजेक्ट कर Red Drawer में रखें और Reject Tag लगाकर Line In charge को Inform करें |

Our Aim:-

0' Defect to Next Operation

PROCESS CONTROL STANDARD (PCS)

Class	Process/Product Characterstics	Specification	Inspection method	Frequency	Recording	Control I/C	Remarks
	Setup verification	Setup verification done by OK/NG Master sample	Visual on Test setup	100%	Yes (Per 4 Hour)	Operator	Use setup & FPA Sheet
	Auto Function Testing	Pass (Green) / FAIL (Red) indication display by automatic Test Setup	Visual	100%	Yes (Per 4 Hour)	Operator	Use setup & FPA Sheet

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TO Prodn COPY NO.: 01
DATE OF ISSUE : 24.01.2020
Interface MR