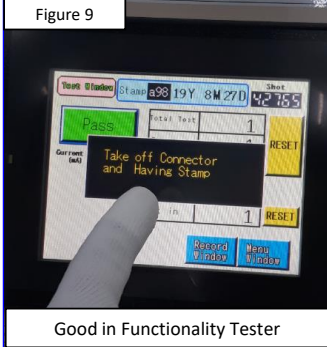

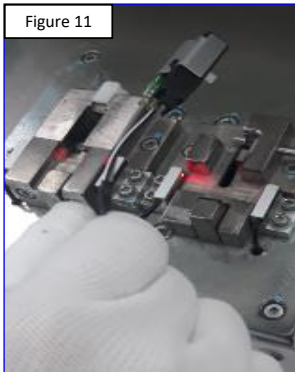
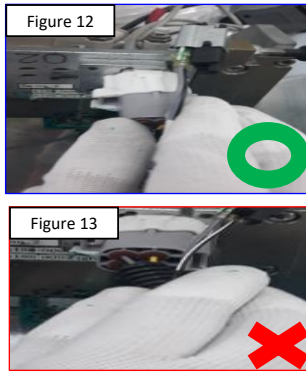
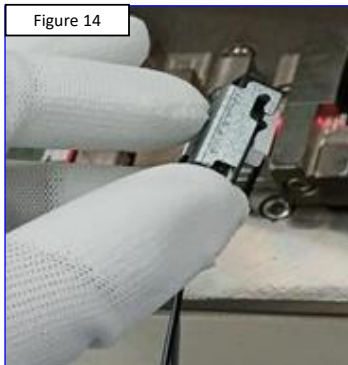
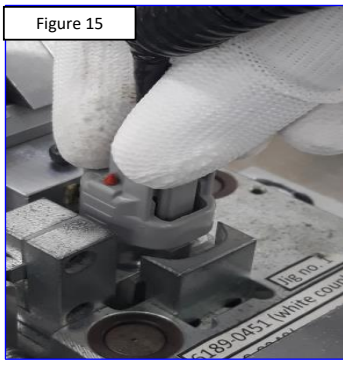
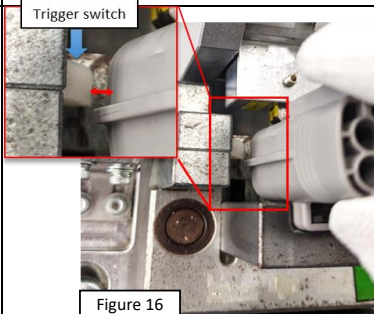
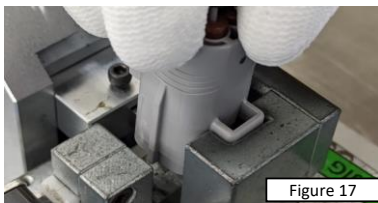
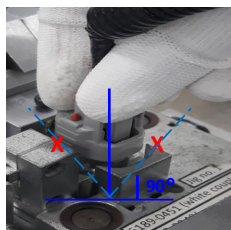

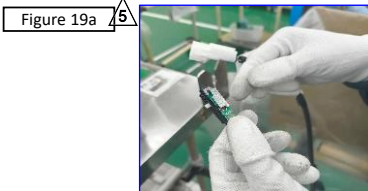


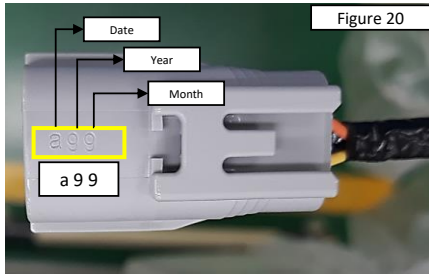
	Process Name/ Title:		Document No:		WI-PRO-MRS-018		
	Functionality Test and Engraving Process				Effective Date:		
	WORK INSTRUCTION				March 14, 2025		
	Product Code/Name:		Customer Code:		Rev. No.:	5	Page No.:
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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
1	<p>Simultaneously, Left Hand: Reconfirm then get the assembled PCB in plate insertion jig .Refer to Figure 1</p> <p>Check proper Light indicator ensure RED light means Unlocked plate and GREEN light means Locked plate.</p> <p>Right Hand: Get the coupler from the left buffer holder Refer to Figure 2</p>	  <p>Reconfirm : push the assembled pcb to the plate insertion jig to move the indicator Light to the next process.</p> 
2	<p>Right Hand: Insert the coupler in the functionality tester machine Refer to Figure 3</p> <p>From Left Hand : Transfer the harness to Right Hand Refer to Figure 4</p>	 
3	<p>Right Hand : Insert the assembled PCB to functionality tester machine Refer to Figure 5-6</p>	  <p>Ensure to insert the assembled PCB properly.</p> <p>Indicator Light should be on "Function Test "</p> 
4	<p>Left Hand: Push the start switch Refer to Figure 7-8</p>	 
5	<p>Rigth Hand: Machine confirmation"finger pointing YOSH" Refer to Figure 9</p>	  <p>Ensure to do the finger pointing Yosh.</p> <p>> If the Function test is NG the Indicator Light will be not moved to the next process.</p> <p>If encountered NG: STOP- CALL- WAIT GL-PRO-COM-033</p>

03/14/25	5	Hold product using both hands prior inspection.	E.Obniala	A.Ayop	W.Carbillon	<table border="1"> <tr> <td>Prepare</td> <td>Check</td> <td>Approve</td> </tr> <tr> <td></td> <td></td> <td></td> </tr> <tr> <td>E.Obniala</td> <td>A.Ayop</td> <td>W.Carbillon</td> </tr> <tr> <td>Est. date:</td> <td colspan="2">June 30, 2021</td> </tr> </table>	Prepare	Check	Approve				E.Obniala	A.Ayop	W.Carbillon	Est. date:	June 30, 2021	
Prepare	Check	Approve																
																		
E.Obniala	A.Ayop	W.Carbillon																
Est. date:	June 30, 2021																	
11/03/23	4	Conduct counting of engraving marks when encountered abnormality.	L.Famodulan	A.Ayop	W.Carbillon													
06/30/22	3	Indicate check proper light indicator and chage picture.(figure 1).Include set of PCB	G.Saloza	C.Lalican	O.Merin													
09/21/21	2	Additional Q Point attach clip tag "For Double Check"	C. Lalican	W. Carbillon	O.Merin													
06/30/21	1	Include used of Light Indicator	L. Famodulan	C. Luna	O.Merin													
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve													

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No.	Work Procedure/ Illustration							Records/Remarks/ Quality Pointers	
6	Simultaneously, Left Hand : Remove the harness (Refer to Figure 11) Right Hand : Remove the coupler from functionality test machine (Refer to Figure 12)		 				Do not remove the coupler by holding the wire refer to the Figure 13 If encountered NG: STOP- CALL-WAIT Refer to WI-PRO-MRS-016		
7	Left Hand: Hold the assembled PCB Refer to Figure 14 Righth Hand: Insert the coupler in the engraving jig Refer to Figure 15		 				Re-insertion of the coupler is prohibited. Re-test is strictly prohibited, Call the attention of LEADER for Re-test . Indicator Light should be on "Engraving"		
	Coupler should not touch the trigger switch when setting the coupler prior engraving. Should have at least small clearance between coupler and trigger switch. Refer to figure 22-23 After setting the coupler, slowly push down the coupler for engraving. Refer to Figure 17		 				Do not position the coupler in less or greater than 90 degrees. 		
8	Transfer to Buffer Holder the Good Harness Refer to Figure 18. Repeat Process 1-6 While waiting to finish in Function test get the product from right buffer holder and Inspect the Product. 5*Product must be held by both hands; left - switch right - connector. Refer to Figure 19a and 19b.		  				Ensure to follow the inspection point IS-PRO-MRS-002 (MR Switch Assembly Inspection Point) Note: ► Attached clip (FOR DOUBLE CHECK) to the last product produce when leaving the area. 		
9	Inspect the engraved coupler (Refer to WI-PRO-COM- 001) Refer to Figure 20		 <div>Example: a 9 9 a = 27 (Day) 9 = 2019 (Year) 9 = September (Month)</div>				Ensure that the engraved date is align in (WI-PRO-COM-001) Ensure that the engraved date is readable. Normal Judgment: Without broken coupler, dent and scratch		
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No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
10	Put the good harness inside the box and insert the assembled PCB in the plastic Refer to Figure 21 Repeat process no. 7-14	<div>Figure 21</div> 	If encountered NG: STOP- CALL- WAIT WI-PRO-MRS-016

Note:
 Ensure to **remove/flash out all the product** in the line before starting new model to avoid mixing. GL-PRO-COM-014




Light Indicator
 Indicates the sequence process . It will automatically move once the process is done



Treatment Method Engraving:

1. If power fluctuates during the process, check the engraving condition of the product
2. If engrave is not good visually, dispose the affected product
3. If no-engrave, re-engrave then check the visual condition


Function Machine Tester:

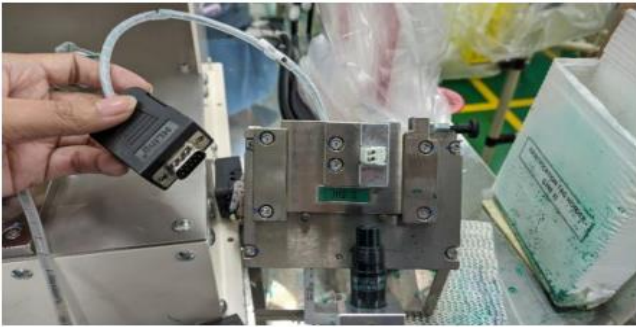

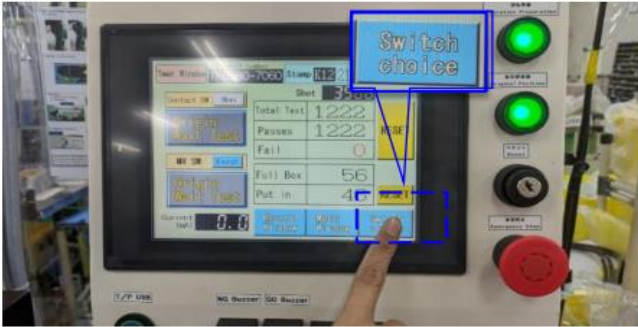
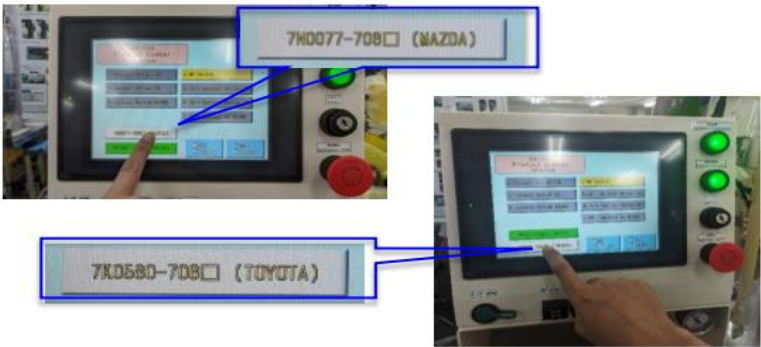

1. If power fluctuation encountered during the process, re-test the affected product.
2. If the affected product failed on the tester, dispose the product
3. Check the set of PCB refer **F-PRO-MRS-010**.For convert a setting of machine by maintenance.
4. If encountered abnormality, Leader will conduct counting of engraving marks to ensure that all product undergone engraving process and function test.

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No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
Machine Set up for 7N0077 and 7K0580 product			
1	Install the coupler jig to be used		NOTE : Machine set up must be conducted by incharge Leader .
2	Connect the connector of machine and coupler jig.		Ensure to check the label connector prior insertion based on the model to be produced
3	Press the "Switch choice" on the function test machine screen .		
4	Click the desire function to be used based on the model for production		
5	Click "Test Window" for Final set up of product After machine set-up and HATSUMUNO ,proceed with mass production .		

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