	Process Name/ Title:		Document No:		WI-QAD-QAC-252		
	STEERING ELECTRICAL TEST				Effective Date:		
	WORK INSTRUCTION				February 14, 2025		
	Product Code/Name:		Customer Code:		Rev. No.:	3	Page No.:
STEERING		TRJ/TRMX					

No.		Work Procedure/ Illustration			Records/Remarks/ Quality Pointers		
<div><div>3</div><div>1</div></div>		<div><div><div><div><div><div></div><div>Get the box from WIP area and transfer in the electrical testing area.</div></div></div><div><div><div><div><div><div></div><div>Check if all boxes is same model</div></div></div><div><div><div><div><div></div><div></div></div></div></div></div></div><div><div><div><div><div></div><div></div></div></div></div></div><div><div><div><div><div></div><div></div></div></div></div></div></div><div><div><div><div><div></div><div></div></div></div></div></div><div><div><div><div><div></div><div></div></div></div></div></div></div><div><div><div><div><div></div><div></div></div></div></div></div><div><div><div><div><div></div><div></div></div></div></div></div></div><div><div><div><div><div></div><div></div></div></div></div></div><div><div><div><div><div></div><div></div></div></div></div></div></div><div><div><div><div><div></div><div></div></div></div></div></div><div><div><div><div><div></div><div></div></div></div></div></div></div> <div><div><div><div><div></div><div></div></div></div></div></div> <div><div><div><div><div></div><div></div></div></div></div></div> <div><div><div><div><div></div><div></div></div></div></div></div> 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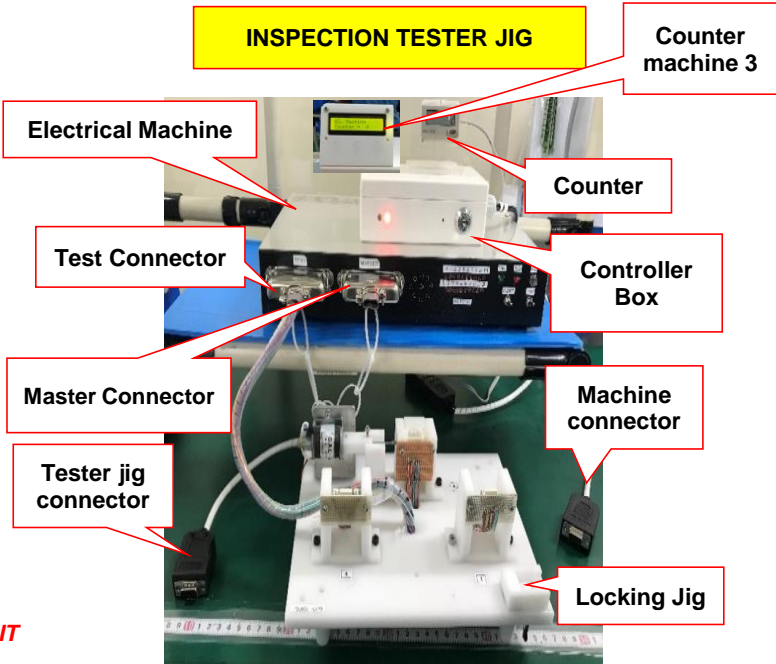
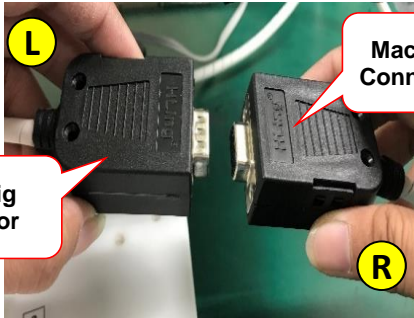
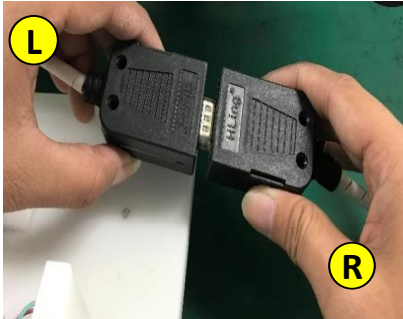
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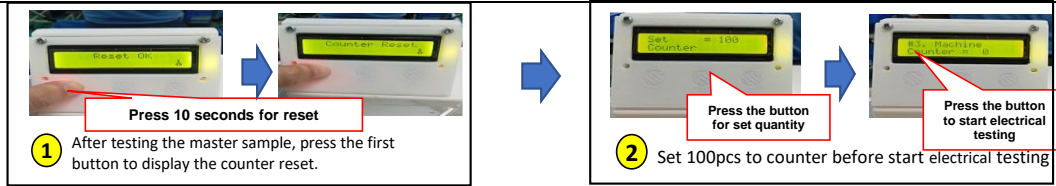
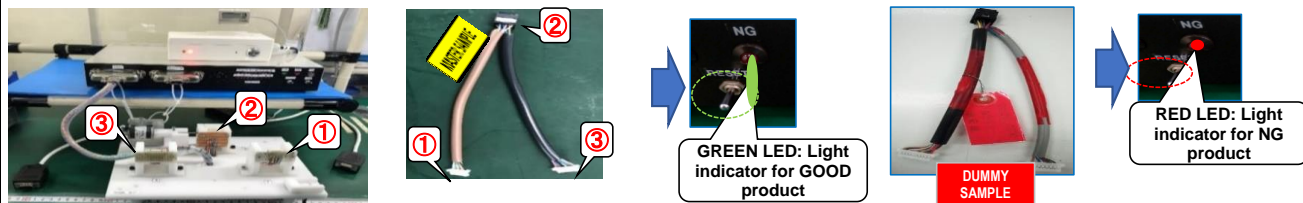

Process Name/ Title:		Document No:		WI-QAD-QAC-252	
STEERING ELECTRICAL TEST		Effective Date:		February 14, 2025	
WORK INSTRUCTION		Rev. No.:		3	Page No.: 2 of 7
Product Code/Name:		Customer Code:			
STEERING		TRJ/TRMX			

No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
3	Check the machine parts/ condition	<div><div>ELECTRICAL TEST MACHINE</div><div>BACK</div><div>FRONT</div><div><i>If found any abnormality, inform to Sub-Leader/Leader and follow STOP-CALL-WAIT procedure</i></div></div> <div><div>INSPECTION TESTER JIG</div><div>Counter machine 3</div><div>Counter</div><div>Controller Box</div><div>Machine connector</div><div>Locking Jig</div><div>Electrical Machine</div><div>Test Connector</div><div>Master Connector</div><div>Tester jig connector</div></div>	Must have no worn-out or damaged parts.
4	Plug-in the tester jig connector to machine connector.	<div><div>Machine Connector</div><div>Tester Jig Connector</div><div>L</div><div>R</div></div> <div><div>L</div><div>R</div></div>	There should be no loose connection and/or attachment of plug.

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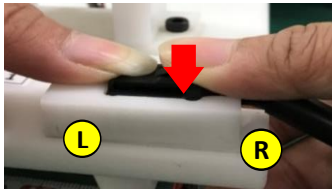


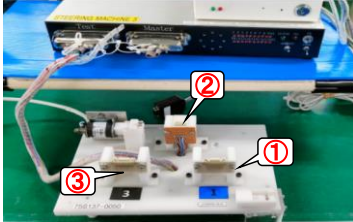
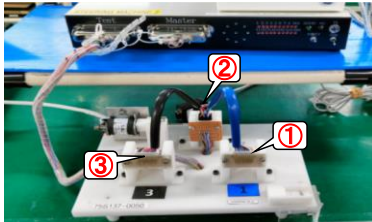
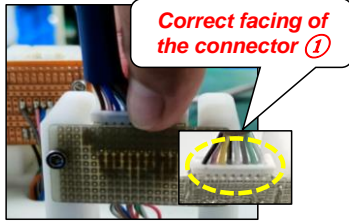
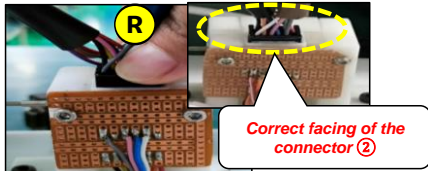
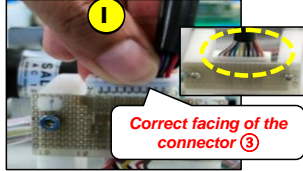
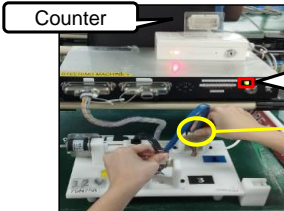
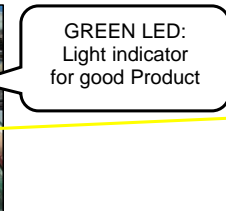


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No.	Work Procedure/ Illustration			Records/Remarks/ Quality Pointers	
5	Plug-in the Test Connector then lock both sides using both hands.				> There should be no loose attachment.
6	Plug-in the Master Connector then lock both sides using both hands.				
7	Switch on the PSW, Push upward to Turn-ON the Machine.				> Use Inspection tester jig allocated per model.
8	Set the quantity in counter				> Must be conducted every start-up or change model. For machine 3 available.
9	Verification of GOOD and NG SAMPLE				> Must be conducted every start-up or change model. > Tube color depends per corresponding part number
10	Record the details in the electrical Test Monitoring & Daily Equipment (Steering electrical jig/Machine				> Fill in the other necessary details after finish of each box in the electrical test checksheet - F-QAC-877 & Daily Equipment (Steering electrical jig/Machine) F-QAC-876.

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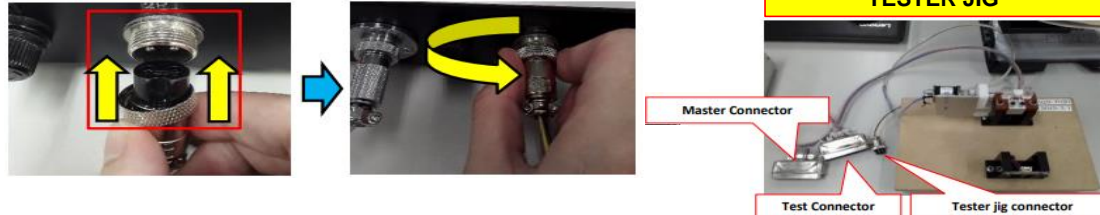

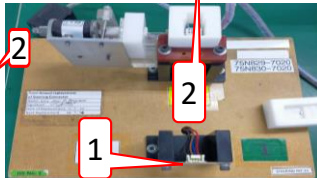


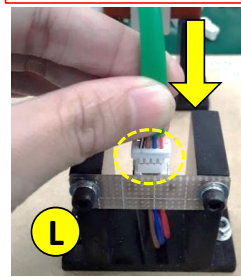
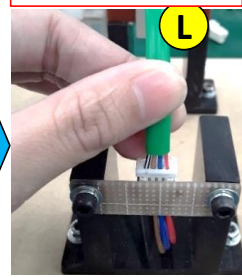
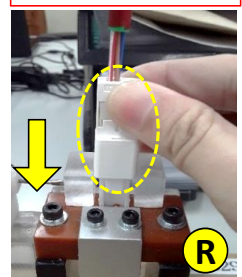

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No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
11	Write the ID tag number on the hourly every start of the box		<p>> For first box, first piece conduct by two's inspection by leaders / sub-leaders.</p> <p>> The rest will be conduct by the inspector every start of the next box.</p>
12	Conduct locking of connector	 <p>Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to check if properly locked.</p> <div>   </div> <p>BEFORE PRESSING (UNLOCK CONNECTOR) AFTER PRESSING (LOCKED CONNECTOR)</p>	<p>> Ensure that the connector is fully locked. Must have no unlock/half-lock condition.</p> <p>> Avoid manual locking which may cause damaged connector lock.</p>
13	Hold the assy part, insert the white connector with VM tube (Sunprene) to location 1.	<p>Electrical Testing (for models AVSS wires with/out SPS-21T-205 and 115603-2 terminal)</p> <div>    </div> <p>Correct facing of the connector ①</p>	<p>> Tube Color will depend on the model.</p> <p>> Refer to illustration for the locations of connector 1, 2 and 3.</p>
14	Insert the black connector to location 2 and white connector on location 3.	<div>   </div> <p>Correct facing of the connector ② Correct facing of the connector ③</p>	<p>> Facing and insertion of connector must be correct.</p>
15	Off your fingers from the assy part during testing.	<div>     </div> <p>Counter GREEN LED: Light indicator for good Product GOOD NO GOOD No Gap With Gap</p>	<p>1. Conduct STOP, CALL, WAIT if encounter abnormality on electrical tester jig. In case of electrical test NG alarm, leader should check affected unit by visual inspection prior retest.</p> <p>2. Check proper insertion of connector to location 1,2,3. Should have no gap.</p>

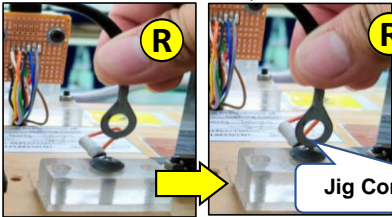
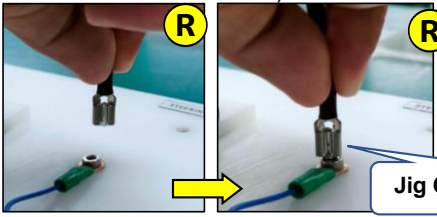
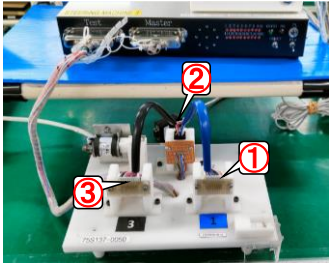
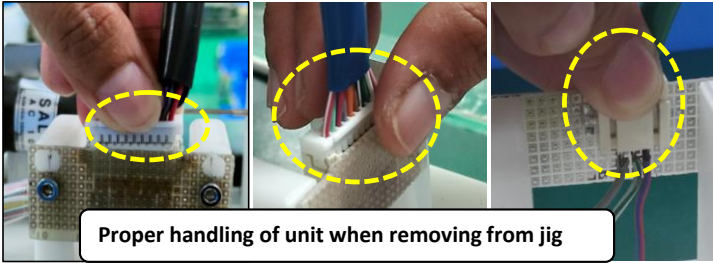
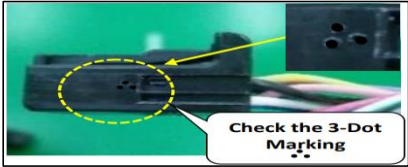



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	STEERING ELECTRICAL TEST			Effective Date:	February 14, 2025
	WORK INSTRUCTION			Rev. No.:	3
	Product Code/Name:	Customer Code:	Page No.:	5 of 7	
	STEERING		TRJ/TRMX		


No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
REFERENCE FOR 75N829/75N830 PARTS		
	<div>Plug-in the tester jig connector to machine connector.</div> <div></div>	<div>> There should be no loose attachment of plug.</div> <div>> All wiring must be in good condition and no damage on insulation.</div>
	<div>Verification of GOOD and NG SAMPLE</div> <div><div><div>INSERTION SEQUENCE GUIDE</div><div><div>Parts sequence to be inserted</div></div><div><div>Tester jig insertion slot</div></div></div><div><div><div>DUMMY SAMPLE</div></div><div><div>MASTER SAMPLE</div></div></div></div>	<div>> Follow the insertion slot as shown</div>
	<div><div><div>BEFORE INSERTION</div><div><div>L</div></div><div>AFTER INSERTION</div><div><div>L</div></div></div><div>INSERTION OF SMALL CONNECTOR</div><div><div><div>BEFORE INSERTION</div><div><div>R</div></div><div>AFTER INSERTION</div><div><div>R</div></div></div><div>INSERTION OF BIGGER WHITE CONNECTOR</div></div></div>	<div>> Make sure that the connectors are fully inserted.</div>



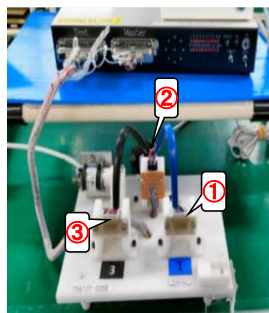



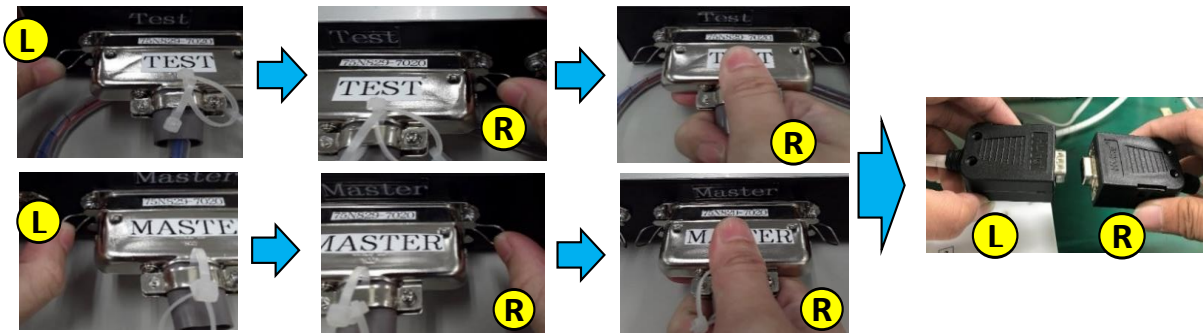

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No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
16	Hold the tube (with AVSS wire) near terminal and place the tip of terminal on the top of the jig contact point.	<div> <div>(TERMINAL PART NUMBER 115603-2)</div>  <div>Jig Contact Point</div> </div> <div> <div>(TERMINAL PART NUMBER: SPS-21T-205)</div>  <div>Jig Contact Point</div> </div>	
17	Remove the assy parts from the jig.	 <div>Removal of product should follow the sequence 3-2-1.</div>  <div>Proper handling of unit when removing from jig</div>	> Hold the parts properly. > Hold in the connector while removing the product.
18	Check the presence of punchmark and counter	 <div>Check the 3-Dot Marking</div>  <div>Appearance of punchmark for 75N829/75N830</div>	> There should be 3 punchmark present on the connector after test as identification of GOOD product
<div>3</div> <div>19</div>	Conduct 1 pc. visual checking on connector (first piece) using loupe	  <div>Good Condition of Connector</div>	Every first piece item of the box we need to check the black connector condition using loupe to see if no damaged, broken connector, or scratch.

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No.	Work Procedure/ Illustration				Records/Remarks/ Quality Pointers
<div><div>3</div><div>20</div></div>	Conduct the electrical test to all parts		 <p>Triangle partition (before and after)</p>	 <div>Maximum of 25 pieces can be buffered or placed on the table after inspection and before being placed in the box.</div> 	<ul style="list-style-type: none">> Follow the proper holding of the products during insertion and dis-assembly from the jig.> Use partition for parts before and after test.
21	Do not forget to turn-off the power of the machine before disassemble of ports		 <p>Switch off the PSW, Push downward to Turn-off the Machine.</p>	<ul style="list-style-type: none">> Shall be done every change over , long breaks and every end of shift.	
22	Dis-assemble/release the tester and master connector			<ul style="list-style-type: none">> Use left and right thumb and pull to unplug the connectors from the machine.	
23	Place the tester jigs to their corresponding jig rack allocation		<p>Tester Jig per part number has corresponding location with labels.</p>	<ul style="list-style-type: none">> 5'S must be properly followed and conducted in the working area.	

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