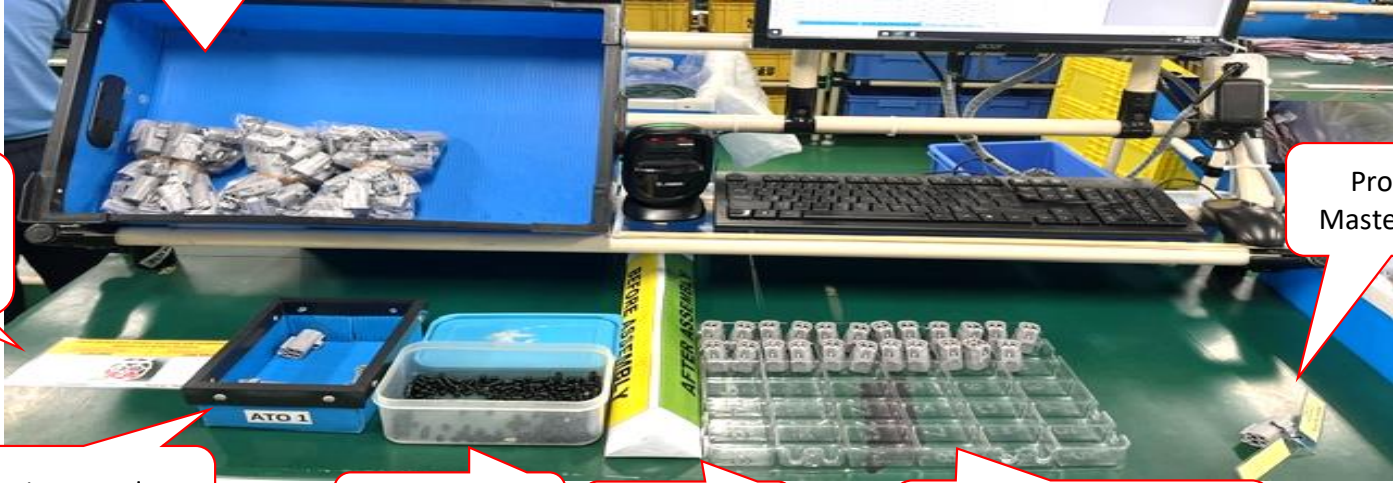
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	DUMMY SEAL INSERTION				Effective Date:	
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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
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A.Table Lay-out

1



Connectors for insertion of dummy seal

Visual Reference

Connectors on-going insertion of dummy seal

Dummy Seal




WIP Partition


Output tray (Connector with Dummy Seal)

Prototype Master Sample

1.No missing parts/tools

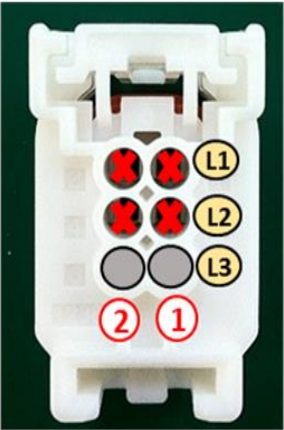
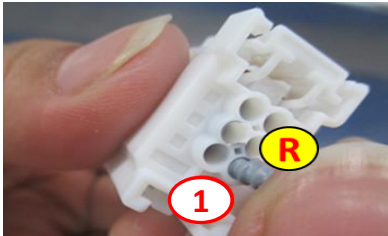
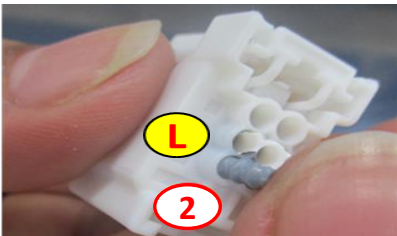


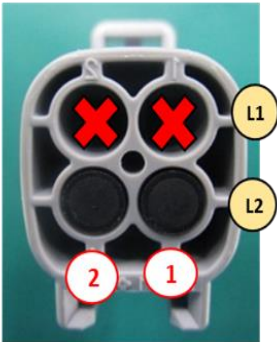


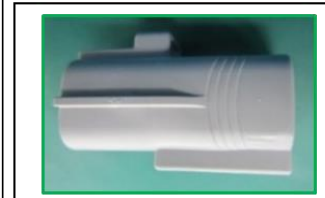
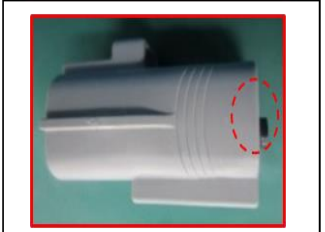
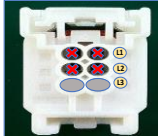
Arrange the connector,dummy seal and the needed containers into the working table.


						Prepare	Check	Approve
03/04/2025	11	Include proper method of inspection after insertion process.	C.Recto	C.Calayan	W.Carbillon			
09/25/2024	10	Add table lay-out.Additional model,7L0140.Include document control number of Daily Operation Report(F-PRO-KIT-009A)	C.Recto	C.Calayan	W.Carbillon			
02/06/2024	9	Changed Illustration(Item No.1).Change output location from output container to parts tray(countermeasure for missing dummy seal,Item no.7)	H.Almarez	A.Morcozo	W.Carbillon	C.Recto	C.Calayan	W.Carbillon
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date: June 04, 2018		

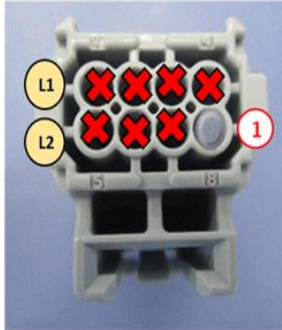
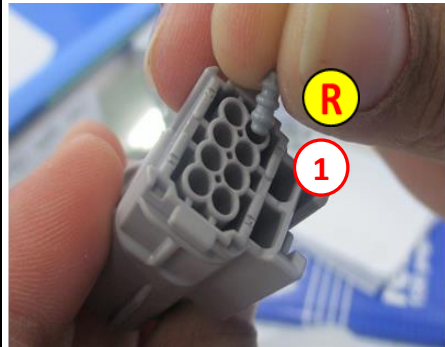



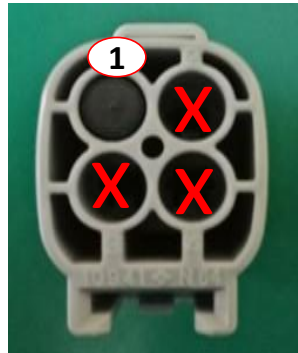


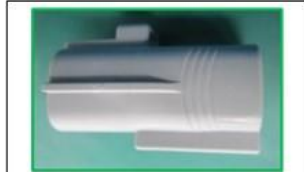

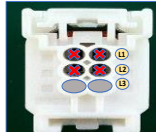
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	<h2 style="text-align: center;">DUMMY SEAL INSERTION</h2>					Effective Date:	
	<h3 style="text-align: center;">WORK INSTRUCTION</h3>					March 4, 2025	
	Product Code/Name:		Customer Code:		Rev. No.:	11	Page No.: 2 of 5
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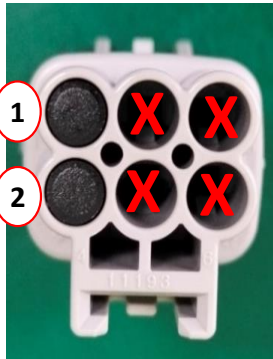




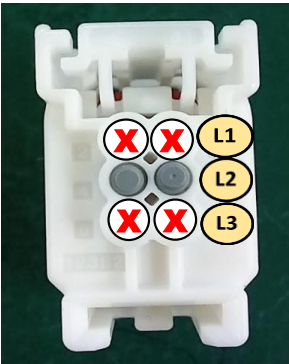
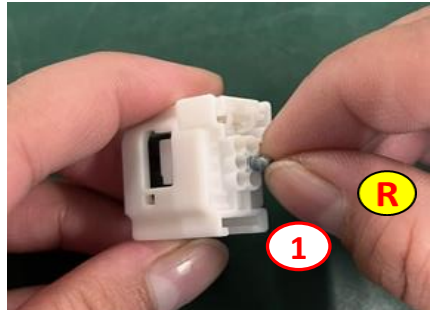
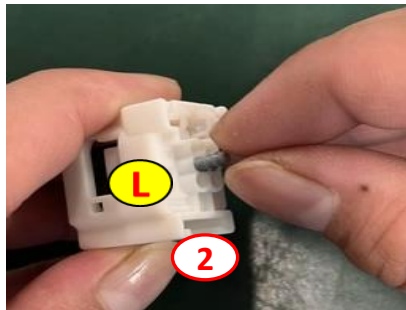



B.Dummy Insertion

1	<p>7R0102 7R0103 7R0117 7R0118</p> 	 <p>1. Get the coupler (6189-1142) using left hand and get one dummy seal (7165-0797) using right hand then insert in line 3 from right to left. Press the dummy seal using right thumb finger after every insertion.</p>	 <p>2. Get the second dummy seal (7165-0797) using right hand then insert in line 3 on left side. Press the dummy seal using right thumb finger after every insertion.</p>	 <p>GOOD</p>  <p>NG</p>	<ol style="list-style-type: none"> 1. No wrong insertion 2. One by one insertion 3. Make sure it was properly inserted 4. No incomplete dummy seal 5. Check for the completeness of inserted dummy seal 6. No mixing of with dummy seal and without dummy seal
2	<p>7L0139 7L0141</p> 	 <p>1. Get the coupler (6188-0066) using left hand and get one dummy seal (7160-9465) using right hand then insert in line 2 from right to left. Press the dummy seal using right thumb finger after every insertion.</p>	 <p>2. Get the second dummy seal (7160-9465) using right hand then insert in line 2 on left side. Press the dummy seal using right thumb finger after every insertion.</p>	 <p>GOOD</p>  <p>NG</p>	<p>NOTE: Always use visual reference based on running model.</p> <p>Check correct part, proper insertion and completeness of dummy seal before issuance</p> <p>Coupler Part No. : 6189-1142 Dummy Seal Part No.: 7165-0797</p>  <p>SAMPLE VISUAL REFERENCE</p>

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	ALL APPLICABLE		ALL APPLICABLE				


No.	Work Procedure/ Illustration					Records/Remarks/ Quality Pointers
3	7M0516		 <p>1. Get the coupler (6188-0799) using left hand and get one dummy seal (7165-0797) using right hand then insert in line 2.</p>	 <p>2. Press the dummy seal using right thumb finger after every insertion.</p>	<div><p>GOOD</p></div> <div><p>NG</p></div>	<ol style="list-style-type: none">1. No wrong insertion2. One by one insertion3. Make sure it was properly inserted4. No incomplete dummy seal5. Check for the completeness of inserted dummy seal6. No mixing of with dummy seal and without dummy seal
4	7N0114 7L0126		 <p>1. Get the coupler (6188-0066) using left hand and get one dummy seal (7160-9465) using right hand then insert in slot number 1. Press the dummy seal using right thumb finger after every insertion.</p>	 <p>2. Press the dummy seal using right thumb finger after every insertion.</p>	<div><p>GOOD</p></div> <div><p>NG</p></div>	<div><p>NOTE: Always use visual reference based on running model.</p><p>Check <u>correct part, proper insertion and completeness</u> of dummy seal before issuance Coupler Part No. : 6189-1142 Dummy Seal Part No.: 7165-0797</p><p>SAMPLE VISUAL REFERENCE</p></div>



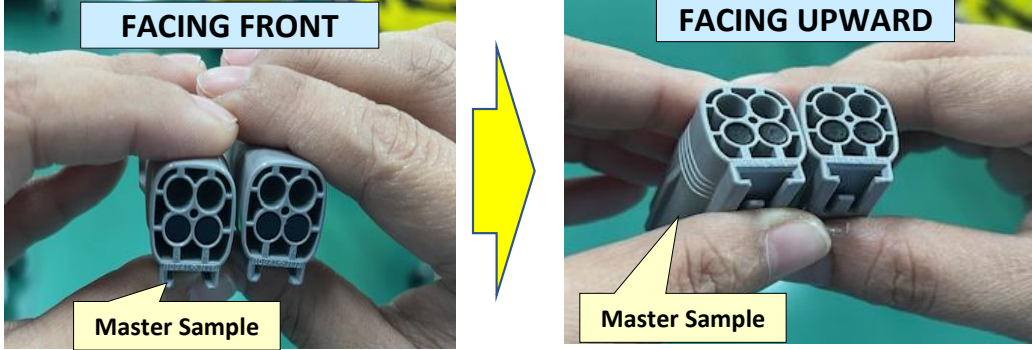



	Process Name/ Title:		Document No:		WI-PRO-KIT-007	
	DUMMY SEAL INSERTION		Effective Date:		March 4, 2025	
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No.	Work Procedure/ Illustration				Records/Remarks/ Quality Pointers	
5	7N0101		 <p>1. Get the coupler (6188-0175) using left hand and get one dummy seal (7160-9465) using right hand then insert in line 1 on the left side. Press the dummy seal using right thumb finger after every insertion.</p>	 <p>2. Get another one dummy seal (7160-9465) using right hand then insert in line 2 on the left side. Press the dummy seal using right thumb finger after every insertion.</p>	<div><p>GOOD</p></div> <div><p>NG</p></div>	<div>1. No wrong insertion</div> <div>2. One by one insertion</div> <div>3. Make sure it was properly inserted</div> <div>4. No incomplete dummy seal</div> <div>5. Check for the completeness of inserted dummy seal</div> <div>6. No mixing of with dummy seal and without dummy seal</div>
6	7L0140		 <p>1. Get the coupler (6189-1142) using left hand and get one dummy seal (7165-0797) using right hand then insert in line 2 from right to left. Press the dummy seal using right thumb finger after every insertion.</p>	 <p>2. Get the second dummy seal (7165-0797) using right hand then insert in line 2 on left side. Press the dummy seal using right thumb finger after every insertion.</p>	<div><p>GOOD</p></div> <div><p>NG</p></div>	<div>NOTE: Always use visual reference based on running model.</div> <div>Check <u>correct part, proper insertion and completeness</u> of dummy seal before issuance Coupler Part No. : 6189-1142 Dummy Seal Part No.: 7165-0797</div> <div><p>SAMPLE VISUAL REFERENCE</p></div>

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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
C.After dummy seal insertion 11	<div>   </div> <div> <p>1. Put the connector on tray with the dummy seal parts facing up then call the attention of Leader for Hatsumuno confirmation.Record the details on Daily Operation Report(F-PRO-KIT-009A).</p> </div> <div>  <p>2. After producing all required qty, verify dummy seal completeness and insertion condition by facing the connector in front then tilt going upward for proper visualization.</p> </div> <div>  <p>3. Put the compared output on plastic then continue inspection.</p> </div> <div>  <p>4. After finished inspecting all the dummy sealed coupler, fill out the information needed in Label for Dummy Seal.</p> </div> <div>  <p>5. Put the Label for Dummy Seal inside the plastic of connector and put on the proper location under the working table.Record other needed details in Daily Operation Report(F-PRO-KIT-009A).</p> </div>	<div> <p>1. No wrong insertion</p> <p>2. One by one insertion</p> <p>3. Make sure it was properly inserted</p> <p>4. No incomplete dummy seal</p> <p>5. Check for the completeness of inserted dummy seal</p> <p>6. No mixing of with dummy seal and without dummy seal</p> </div> <div> <p>1.No missing details</p> <p>2.No wrong details</p> </div>