



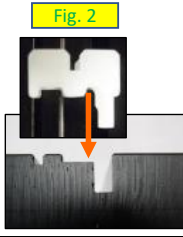


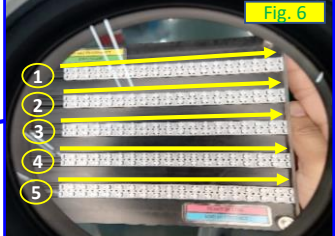
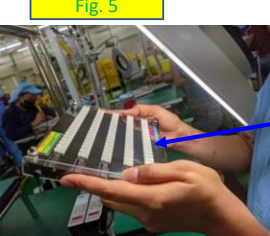
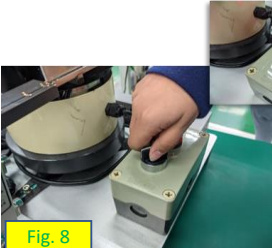
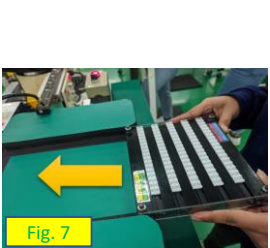





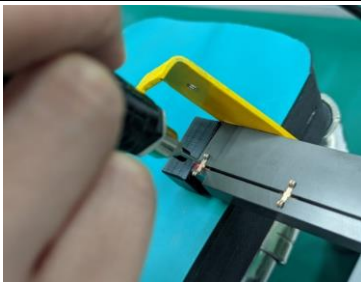
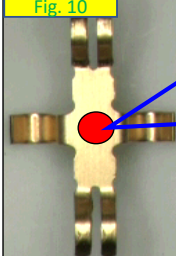








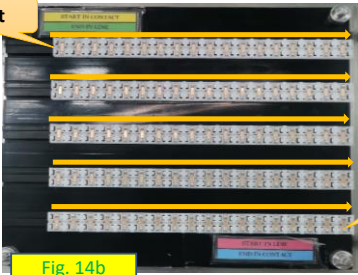

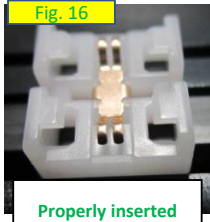
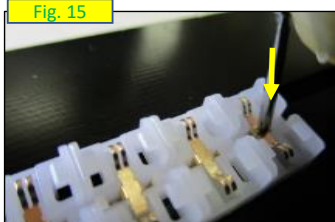
	Process Name/ Title:		Document No:		WI-PRO-COS-070	
	CONTACT SWITCH ASSEMBLY / B15C Contact Assembly (using Feeder Machine)					
	WORK INSTRUCTION		Effective Date:		November 21, 2024	
	Product Code/Name:	Customer Code:	Rev. No.:	0	Page No.:	1 of 4
	ALL	ALL				

No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
1	Get a plastic of contact from the container (tupperware). (refer to fig. 1)		Observe proper handling: Never transfer or pick up contact using bare hands to avoid contamination, discoloration and deformation.
2	Carefully pour the contact inside the contact feeder machine. (max. qty. should be 2.5k below)		
3	Set the slider(7K 0575-0010) on the plate assembling table (refer to fig. 2-4)	<div></div> <p>Make sure slider leg is properly inserted</p>	Clean the Plate assembling table using brush and wipes before placing the slider.  INCOMPLETE NAILS  DAMAGED/BROKEN NAILS
4	Inspect condition of slider through magnifying lamp. Checking of slider condition must be in sequence from top to bottom then from left to right. (refer to fig.5-6)	<div></div>	
5	After inspection, insert the plate with slider in the platform. (Fig. 7) Switch on the feeder machine. (Fig. 8)	<div></div>	
6	Get the vacuum pen then switch on the air pressure.		

						Prepare	Check	Approve
								
Nov. 21, 2024	0	Newly establish Work Instruction for contact assembly using feeder machine	E.Obniala	A.Ayop	W.Carbillon	Est. date:	November 20, 2024	
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve			

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	WORK INSTRUCTION		Rev. No.:		0	Page No.:
	Product Code/Name: ALL		Customer Code: ALL			2 of 4

No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
7	Get a contact from contact feeder railing using vacuum pen.		Note: If encountered dropped contact, it should be treated as NG.
8	Vacuum tip should be in exactly vertical position on the flat center part. (refer to fig 9 ~ 10).	<div><div>Vacuum the center flat part of the contact</div></div>	
9	Observe proper position of vacuum tip in getting the contact (refer to fig. 11 ~ 12)	<div><div>Proper Position of Contact in Vacuum tip</div><div>Improper Position of Contact in Vacuum tip</div></div>	If encountered DEFORM contact Refer to Page 3 for the NO GOOD TREATMENT If encountered wrong position of contact, switch off the vacuum to remove contact from the tip. 
10	Fixed the Slider using left Index Finger with support of middle finger (refer to fig. 13) AVOID TOUCHING OF CONTACT.	<div><div>GOOD</div><div>NO GOOD</div></div>	
11	Proper direction of contact assembly should start on the upper left side of the first row going to the right . Proceed to the second row and so on until all slider have contact in it. (refer to fig. 14a ~ 14b)	<div><div>Start</div><div>End</div></div>	
12	Vacuum tip should be vertical to the slider during contact assembly. Check the contact sound and insertion to indicate that contact is properly inserted in the slider. (refer to fig. 15 ~ 16)	<div><div>Properly inserted</div></div> <div>> If encountered Deform or Mis Align Contact : DISPOSE REWORK/REPAIR IS STRICTLY PROHIBITED Refer to Page 3 for the NO GOOD TREATMENT</div>	<ul style="list-style-type: none">• Contact must be fully inserted to slider .• Gap and unbalanced insertion is not allowed.• Do not forced the deformed contact to insert inside the slider.

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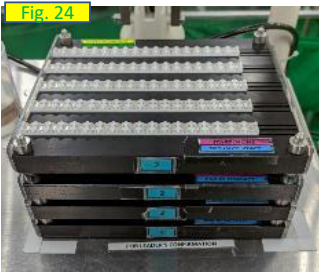
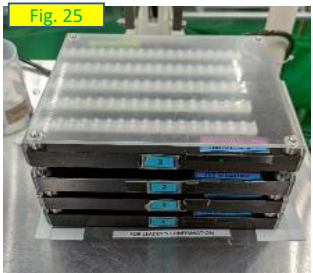
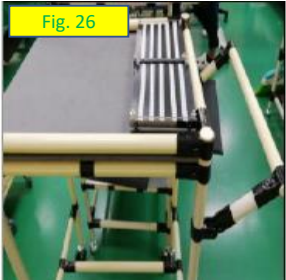
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	Product Code/Name:	Customer Code:	Page No.:		3 of 4	
	ALL	ALL				

No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
	Conduct inspection under Magnifier after assembling contact (7D0349-0040) refer to IS-PRO-COS-004. Check the whole plate if have missing contact assembly.		Always conduct one plate checking to secure that all plate are well inspected.
	Slant the tray and check the contact Assembly in VIEW A position. (refer to fig. 17 ~ 18)	 	
	Rotate the tray in 180° and check the contact in VIEW B position . (refer to fig. 19 ~ 21)	  	
	<div>Quality Point</div> <div>  <p>○ GOOD</p> </div> <div> <p>× Inclination</p>  </div> <div> <p>× Deformed</p>  </div> <div> <p>× Deformed</p>  </div> <div> <p>× Missing Parts</p>  </div> <div> <p>× Floating</p>  </div> <div> <p>× Missing nail</p>  <p>missing</p> </div> <div> <p>× Foreign Materials</p>  </div> <div> <p>× Wrong Assembly</p>  </div> <div> <p>× Damaged nail</p>  </div> <div> <p>There should be NO:</p> <p>If encountered above NG dispose immediately: REWORK/REPAIR IS STRICTLY PROHIBITED</p> </div> <div> <p>Based on the instruction below: Tokai Rika Toyota Quality Control div. Quality News No. QN-2208001 issued : 2022/8/4</p> </div>		
	After inspection,put the plate of assembled slider contact on the designated area. (refer to fig . 22 ~ 23)	 	Make sure to put cover on the top of the finished plate to avoid dirt and dust. Maximum Plate layer: 8pcs


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Product Code/Name:		Customer Code:			4 of 4
ALL		ALL			

No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
13	After the plate has been inspected by the assist operators, assigned final verifactor will conduct again another inspection same with the assembling process inspection sequence. (refer to fig . 24 ~ 25)	 	
14	The assigned final verifactor will then put the inspected assembled slider contact in the push cart used in parts delivery which is the location for "after final verification". (refer to fig . 26)		

NO GOOD TREATMENT

	<p>If encountered NO GOOD CONTACT or ASSEMBLED PARTS directly put it on the NG container.</p> <p>Note : For Drop Contact put it also in the NG Container</p> 	<p>Make sure to put all No good contact in the container and do not mix it to Good Contact.</p>
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