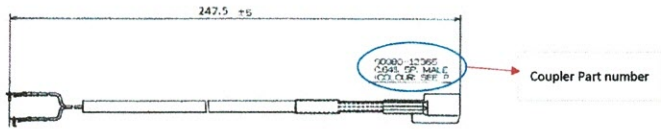
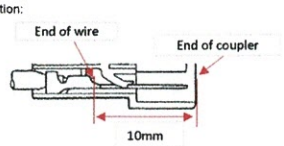
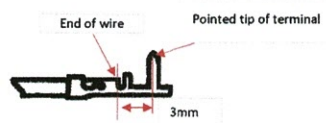
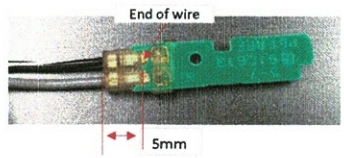
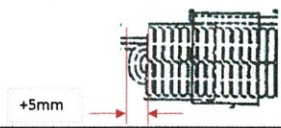
No.		Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
1	Objective	To provide instruction on creating cutting ledger as basis for cutting & crimping of wires & to identify the components of harness.	
2	Procedure	2.1 Enter the part number same with drawing in the part number column. However, when it is multiple pages, the page number must be indicated on the right corner.	If sakimelt type, 2 cutting ledger must be created; for sakimelt wires & for complete components
		2.2 In the next number column, enter the number of wires to be cut.	Note: In considering sakimelt or atomelt process, confirm to superior.
		2.3 In the document control number, enter the control number according to the corresponding control number assigned for the specified product.	Refer to Figure A for the cutting ledger format
		2.4 Input the effective date of the cutting ledger. If revision due to design change, meeting must be conducted to align with the implementation.	
		2.5 In the wire type column, write the type of the wire. If special wire types are used, specify the details of the core wire.	
		2.6 In the size column, enter the diameter of the wire.	Refer to wire type table to identify the color & diameter of wire
		2. 7 Enter the color code/assigned alphabet code of the wire color. *Refer to GL-ENG-PDE-002 Wire Color Standard Code*	
		2.8 In the cord length column, enter the dimension of the cord/wire. Ensure to input all the numerical values even if the cord dimensions are identical.	
		2.8.1 To compute for the length of wire, get the connector part number from drawing. Refer to matrix table then get the dimension from end of wire to coupler. Get the full dimension of harness then subtract the value of dimension from end of wire to coupler & dimension from end of wire to pointed tip of terminal.	
		Example: Coupler Part number: 90980-12365 Harness length: 247.5 End of wire to coupler: 10 *(based on the matrix)*	
		Illustration:	
		Wire length = (Harness length) -(End of wire to coupler) - (End of wire to pointed tip of terminal) = 247.5) -(10) - (3) = 234.5mm -> 235mm (roundup)	
		In case the drawing was in hotmelt form, 5mm was the measurement from edge to wire	
		If with loop, example Y type 5mm should be added to total wire length	

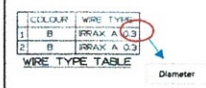












No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers

2.9 Specify the plating terminal in the plating column if there is plating with the same terminal shape.

2.10 Fill-in the terminal part number. Refer to matrix table to identify the corresponding part number of terminal.

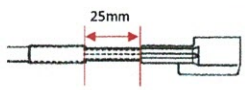
2. 11 In the Rubber Seal column, enter the part number. Refer to matrix table to identify the applicable part number of rubber seal.

2.12 In the wire peeling column, enter the peeling size specified for each terminal to be crimped. Also, all numbers must be entered even if peeling size is the same. Refer to matrix table for the Peeling measurement.

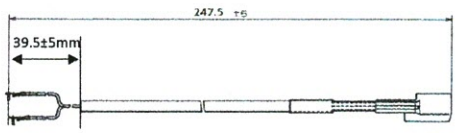
2.13 At the Component Specification column, enter the other parts specified in the drawing such as connectors/ coupler, clamp, tube & Switch assy components. Also, indicate the quantity of the specified parts, and if there are revisions, put red underline on it.

2.13.1 The dimension of vinyl tube or Corrugated tube must be identify based on drawing. To get the dimension of tubes near coupler, consider the below standard. To get the coupler dimension refer to matrix table.

Standard dimension taping from vinyl tube/Corrugated tube to Coupler



Example:



Measurement data

Total wire length:	247.5mm	
Tube to terminal tip:	39.5mm	
Tube to coupler:	25mm	
Coupler length:	34mm	*(based on the matrix)*

Tube dimension = (Total wire length) - (Tube to terminal tip) - (Tube to coupler) - (Coupler length)
= (247.5) - (39.5) - (25) - (34)
= 149mm

2.14 If necessary, specify the process clearly in figure so that the cutting / crimping work process will be easy to understand.

2.15 If it is necessary put "W check" as instruction for the crimping inspection to conduct double checking.

Figure A. Cutting Ledger format