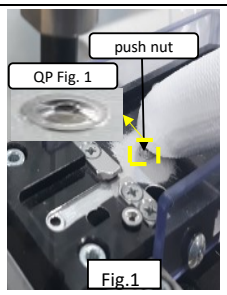
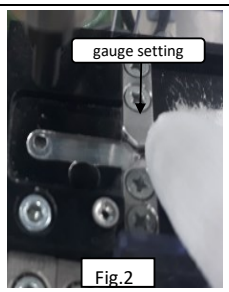
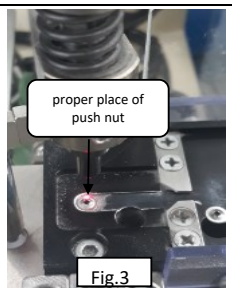
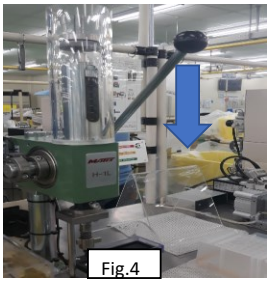
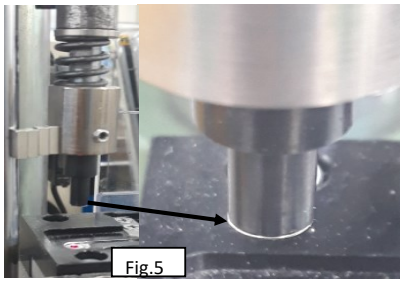
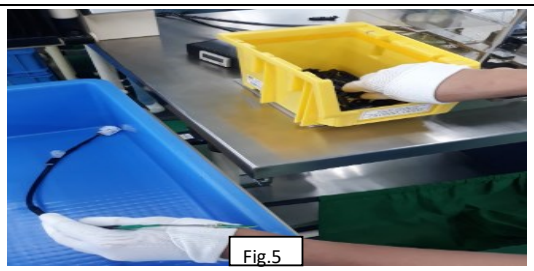
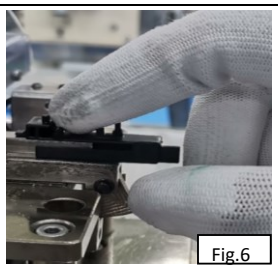
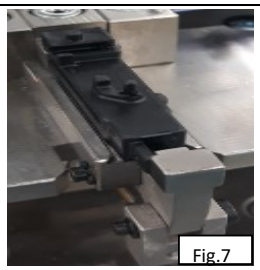
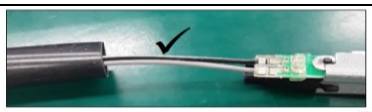
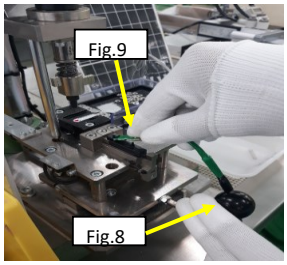
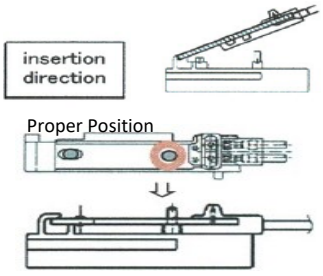
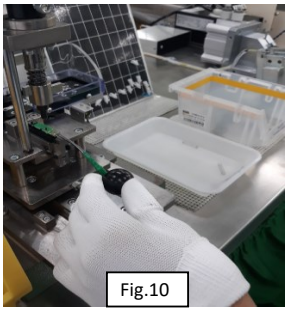
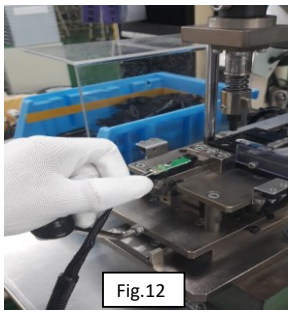
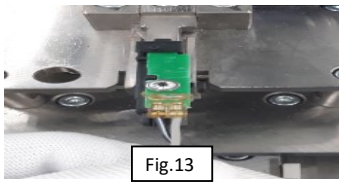
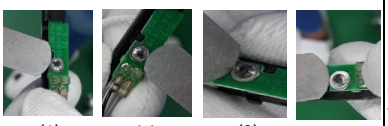
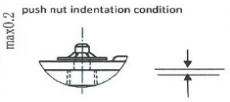
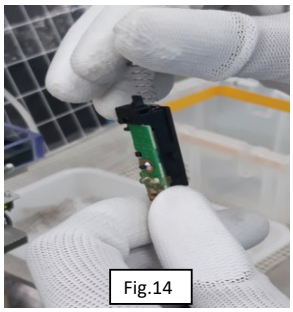
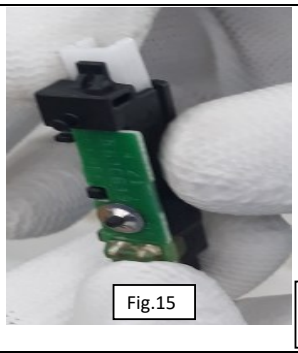
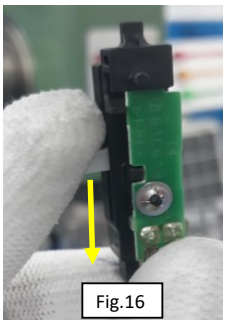
	Process Name/ Title:		Document No:	
NBC	**MR Switch Assembly**			**WI-PRO-MRS-002**
	WORK INSTRUCTION		Effective Date:	**October 11, 2022**
	Product Code/Name: **ALL**	Customer Code: **ALL**	Rev. No.: **4**	Page No.: **Page 1 of 3**

No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
1	Right Hand: Place the index finger (Fig. 1) to the push nut, move pass thru gauge setting (Fig. 2) and place to proper setting (Fig. 3).	  	Ensure to wear gloves Always conduct hatsumono and owarimono every change model Refer to QP Fig 1 for the proper position of push nut. Only one push nut should be fitted to the gauge setting Ensure to place the push nut in the red marking.
2	Right Hand: Pull the lever down (Fig. 4) until the push nut attached on the push nut probe pin (Fig. 5).	 	Ensure that the push nut attached to the push nut probe pin.
3	Simultaneously, Right hand: Get the housing Left hand: Get the harness (Fig. 5)		
4	Right Hand Insert the housing in the jig (Fig 6) ,wait until it locks (Fig.7).	 	Ensure that the housing was locked before inserting the homelted PCB Refer to the below picture for the proper position of housing.
5	Inspect Twisted wire Refer to: IS-PRO-MRS-002	 	
6	Left hand: Hold the machine handle (Fig.8) Right hand: Insert the hotmelted PCB (Fig.9)	 	Ensure to follow the proper insertion of the hotmelted PCB  Refer to the below picture for the proper position 

Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Prepare	Check	Approve
10/11/2022	4	Changed picture of light indicator and include set -up for PCB indication	G. Saloza	C.Lalican	O. Merin			
02/17/2021	3	Add twisted wire Inspection and changed hand position (No. 12)	L. Famodulan	D. Cornero	O. Merin			
03/17/2020	2	General revision base on actual procedure	C . Luna	D. Cornero	O. Merin			
06/01/2017	0	Establish ISO format	M. Rodriguez	O. Merin	Sugiyama	G. Saloza	C.Lalican	O. Merin
						Est. date:	06/01/2017	

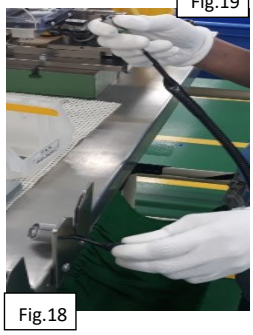
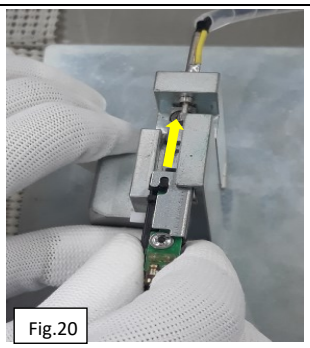
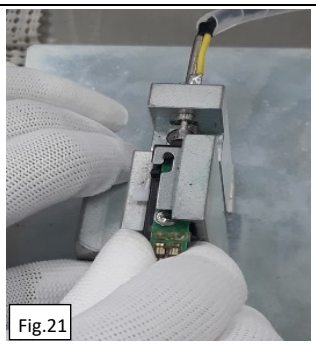
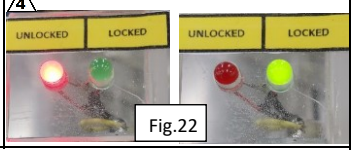
NBC (Philippines)
MASTER COPY

DCC Stamp

No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
7	Left Hand: Push the machine handle (Fig. 10) Right hand: Pull the lever down until the push nut attached to the hotmelted PCB (Fig.11)	 Fig.10  Fig.11	Ensure that the push nut was attached to hotmelted PCB.
8	Left Hand: Pull the machine handle (Fig. 12) and remove the hotmelted PCB w/ attached push nut (Fig. 13). Check pushnut condition Refer to IS-PRO-MRS-002	 Fig.12  Fig.13  (1) (2) (3) (4)	Every start up check the gap of the push nut to hotmelted PCB Conduct four sides checking of the push nut, use clearance gauge (max 0.2mm) every change model  Check housing pin if there is no fracture
9	Left Hand: Hold the assembled PCB Right Hand: Insert the spring compression(7K0580-0040) (Fig.14) into the housing (7K0580-0020)	 Fig.14  Proper Facing	Ensure to check the spring before insertion it should be free from deformation or excess (IS-QAD-QAC-004) Ensure that the PCB is facing to the left side position
10	Left Hand: Hold the assemble PCB Right Hand: Insert the slider magnet to the housing (Fig. 15) and check the smoothness slider magnet by pulling down (Fig. 16)	 Fig.15  Proper positioning while inserting the slider magnet  Fig.16	Ensure that slider magnet is free from foreign material, deformation, crack etc. Ensure that spring compression has no gap. Ensure that the PCB is facing to the left side Ensure to check the smoothness of the slider magnet
11	Left Hand: Hold the assemble PCB (Fig. 17) Right Hand: Insert plate Checked Plate and Hotmelt Condition Refer to IS-PRO-MRS-002	 Fig.17  Proper Facing	Ensure that the PCB is front position Ensure to follow the Work instruction If encounter NG: STOP-CALL-WAIT If encountered NG always ask for Line Leader disposition

NBC (Philippines)
MASTER COPY

DCC Stamp

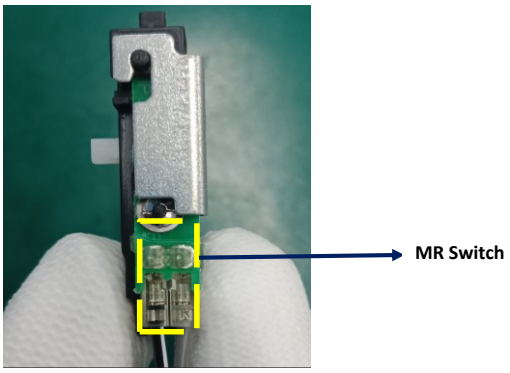
No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
12	Left Hand: Put the connector in the holder (Fig. 18) Right Hand: Hold the assemble PCB (Fig.19)	Fig.19  Fig.18	 Place only at plate insertion jig. (A7040E model < 216 mm)  Connector on long harness hang on the holder
13	Left hand: Hold the plate insertion jig Right hand: Insert the assemble PCB to the plate insertion jig to lock the plate (Fig. 20) Note: Lock indicator will light if already lock (Fig. 22) Repeat process 1- 13	 Fig.20  Fig.21	Ensure to lock the plate Ensure that the light indicator is on RED light means unlocked plate, GREEN light means locked plate Refer to the below picture of light indicator. 4  Fig.22

Quality Pointers:

1. Check if there is no spring compression deformation (before assembling)
2. Check if there is no spring compression redundant or excess (touch)
3. Check the spring compression and slider magnet if there is no gap opening
4. Check the attachment of plate (fixation of plate)
5. Check the housing assembled part if there is no claw, broken, fracture and any missing parts
   Refer to IS-QAD-QAC-004
6. Check the set -up for PCB indication (Refer to **F-PRO-MRS-O10**)

Operation Pointers:

Hold the side of the tool (housing) and check the insertion of the housing. Do not touch the MR switch.



NBC (Philippines)
MASTER COPY

DCC Stamp