




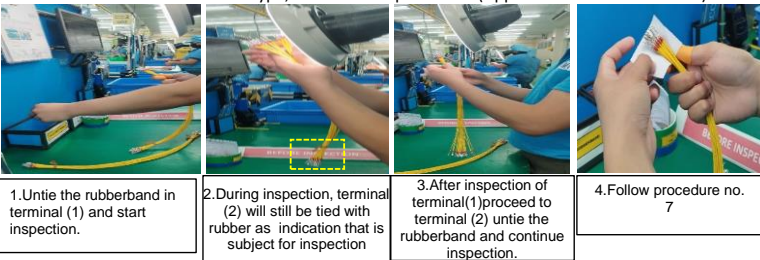




|   |  |   |  |   |        |
|---|--|---|--|---|--------|
|  |  | Process Name/ Title:<br><b>Cut and Crimp Inspection</b> |  | Document No:<br><b>WI-QAD-QAC-190</b>   |        |
|   |  | <b>WORK INSTRUCTION</b>                                 |  | Effective Date:<br><b>June 20, 2024</b> |        |
| Product Code/Name:<br><b>All Crimped Wires</b>                                  |  | Customer Code:<br><b>All Applicable</b>                 |  | Rev. No.:                               | 5      |
|   |  |   |  | Page No.:                               | 1 of 2 |

| No.             | Work Procedure/ Illustration                                    |  |                     | Records/Remarks/<br>Quality Pointers |   |                |                        |                     |                 |                 |          |                      |             |                |                     |                |             |                      |             |                |                     |                |             |        |       |     |   |     |    |                 |  |  |   |
|-----------------|---|--|---------------------|--------------------------------------|---|----------------|------------------------|---------------------|-----------------|-----------------|----------|----------------------|-------------|----------------|---------------------|----------------|-------------|----------------------|-------------|----------------|---------------------|----------------|-------------|--------|-------|-----|---|-----|----|-----------------|--|--|---|
| 1               | Place the wires in " Before Inspection" Area                    |    |                     |                                      | <ul style="list-style-type: none"><li>▶ Every start of the shift review the work Instructions and inspection standard.</li><li>▶ Remove unnecessary materials on top of inspection table</li></ul>  |                |                        |                     |                 |                 |          |                      |             |                |                     |                |             |                      |             |                |                     |                |             |        |       |     |   |     |    |                 |  |  |   |
| 5 2             | Fill in the Magnifying Lamp Checksheet the result of inspection |    |                     |                                      | <ul style="list-style-type: none"><li>▶ Conduct instrument checking every first day of the week</li><li>▶ Write legibly and correctly.</li><li>▶ <b>Leader</b> should check the instrument checksheet after checking of Inspector for verification.</li></ul>   |                |                        |                     |                 |                 |          |                      |             |                |                     |                |             |                      |             |                |                     |                |             |        |       |     |   |     |    |                 |  |  |   |
| 3               | Check the ID tag details versus the actual                      |   |                     |                                      | <ul style="list-style-type: none"><li>▶ Ensure that the details in production ID Tag versus actual parts has no discrepancy(eg. Quantity, revision level, part no., etc.)</li><li><b>** If there's any conflict in the identification tag and the actual parts report immediately to Leader or Sub-Leader Always follow STOP-CALL-WAIT procedure.</b></li></ul>   |                |                        |                     |                 |                 |          |                      |             |                |                     |                |             |                      |             |                |                     |                |             |        |       |     |   |     |    |                 |  |  |   |
| 4               | Fill in Daily Report  | <table><thead><tr><th colspan="2">INSPECTION TIME</th><th rowspan="2">Color of wire (Actual)</th><th rowspan="2">PRODUCT NAME/ MODEL</th><th rowspan="2">LOT NO./BOX NO.</th><th rowspan="2">WIRE TYPE</th><th rowspan="2">DIAMETER</th><th rowspan="2">Color of wire(D tag)</th><th rowspan="2">WIRE LENGTH</th><th rowspan="2">Qty per Bundle</th><th rowspan="2">7D0349-0060 Lot No.</th><th rowspan="2">INSPECTED QTY.</th><th rowspan="2">DEFECT QTY.</th></tr><tr><th>Start</th><th>End</th></tr></thead><tbody><tr><td>7:00</td><td></td><td>G</td><td>7L0053-7025</td><td>0224-1</td><td>TVSSF</td><td>0.3</td><td>G</td><td>806</td><td>20</td><td>2023-2-23(2-19)</td><td></td><td></td></tr></tbody></table>  |                     |                                      | INSPECTION TIME   |                | Color of wire (Actual) | PRODUCT NAME/ MODEL | LOT NO./BOX NO. | WIRE TYPE       | DIAMETER | Color of wire(D tag) | WIRE LENGTH | Qty per Bundle | 7D0349-0060 Lot No. | INSPECTED QTY. | DEFECT QTY. | Start                | End         | 7:00           |                     | G              | 7L0053-7025 | 0224-1 | TVSSF | 0.3 | G | 806 | 20 | 2023-2-23(2-19) |  |  | <ul style="list-style-type: none"><li>▶ Write start time and the details on the daily report.(F-QAC-532)</li><li>▶ Inspected quantity should be fill up after inspection of 1box.</li></ul> |
| INSPECTION TIME |   | Color of wire (Actual)   | PRODUCT NAME/ MODEL | LOT NO./BOX NO.                      | WIRE TYPE   | DIAMETER       |                        |                     |                 |                 |          |                      |             |                |                     |                |             | Color of wire(D tag) | WIRE LENGTH | Qty per Bundle | 7D0349-0060 Lot No. | INSPECTED QTY. | DEFECT QTY. |        |       |     |   |     |    |                 |  |  |   |
| Start           | End   |  |                     |                                      |   |                |                        |                     |                 |                 |          |                      |             |                |                     |                |             |                      |             |                |                     |                |             |        |       |     |   |     |    |                 |  |  |   |
| 7:00            |   | G  | 7L0053-7025         | 0224-1                               | TVSSF   | 0.3            | G                      | 806                 | 20              | 2023-2-23(2-19) |          |                      |             |                |                     |                |             |                      |             |                |                     |                |             |        |       |     |   |     |    |                 |  |  |   |
| 5               | Conduct Visual Inspection                                       | <p>a.) Get 1 bundle from the before inspection box.<br/>b.) Untie the rubber band and unwrap it.<br/>c.) Place the rubber band on the designated boxes.</p>  <p>A. Check the smaller terminal first.<br/>B. It should be started in front part of the terminal.<br/>C. Hold the wire about 2-3 cm below the terminal being inspected.<br/>D. Check it one-by-one.<br/>E. Turn the wire counterclockwise.</p> <p>Step by step checking of All portion of Crimp wire. (IS-QAD-QAC-015)</p> <ul style="list-style-type: none"><li>&gt; Head of terminal</li><li>&gt; Stabilizer</li><li>&gt; Protruded wire</li><li>&gt; Appearance of wire crimped portion.</li><li>&gt; Bellmouth</li><li>&gt; Corewire Between bellmouth and insulation.</li><li>&gt; Insulation Crimped Barrel</li><li>&gt; Lance</li><li>&gt; Cut off Tab</li><li>&gt; Waterproof seal</li></ul> <p>If the terminal has the same type, follow below procedure.(Applicable in seatbelt model.)</p>  <p>1.Untie the rubberband in terminal (1) and start inspection.<br/>2.During inspection, terminal (2) will still be tied with rubber as indication that is subject for inspection<br/>3.After inspection of terminal(1)proceed to terminal (2) untie the rubberband and continue inspection.<br/>4.Follow procedure no. 7</p>  |                     |                                      | <ul style="list-style-type: none"><li>▶ Put finger cots prior inspection for the thumb and point fingers. Finger cot for index finger is optional.</li><li>▶ Place the crimped wires in the " BEFORE " inspection area.</li><li>▶ <b>Maximum Allow able no. of bundles is 6 bundle</b></li><li>▶ Make sure that there is partition for parts Before and After Inspection.</li><li>▶ When encountered non-conformity, follow 5.1.2 of Control of Non-conformity and Corrective Action Procedure (NBP-OP-003)</li><li><b>** During inspection if encountered defect or abnormality call the attention of Leader or Sub-Leader. Follow STOP-CALL-WAIT.</b></li><li>▶ <b>** Terminal part number of 7116-4025 and 7114-4025 is applicable to inspect in naked eye if needed or no available magnifying lamp. Finger cots for this type of terminal is optional because of excess oil in waterproof seal cannot rotate the wire properly.</b></li><li>▶ If cannot handle the crimp wire transfer to the middle finger.</li><li>▶ After inspection of terminal 1 (smaller terminal), proceed to inspection of terminal 2. Follow step 8, A to F.</li><li>▶ Align the terminal tips softly to avoid cohering of terminal part.</li></ul> |                |                        |                     |                 |                 |          |                      |             |                |                     |                |             |                      |             |                |                     |                |             |        |       |     |   |     |    |                 |  |  |   |
| 06/20/24        | 5   | Major Revision   | S.Apil              | M.Garcia                             | R.Pascua  | <b>Prepare</b> | <b>Check</b>           | <b>Approve</b>      |                 |                 |          |                      |             |                |                     |                |             |                      |             |                |                     |                |             |        |       |     |   |     |    |                 |  |  |   |
| 08/02/23        | 4   | Major Revision   | S.Apil              | D. Dadulla                           | R.Pascua  |                |                        |                     |                 |                 |          |                      |             |                |                     |                |             |                      |             |                |                     |                |             |        |       |     |   |     |    |                 |  |  |   |
| 09/21/22        | 3   | Include reviewing of work instruction and inspection Guide   | R. Clemenso         | D. Dadulla                           | R. Alcantara  |                |                        |                     |                 |                 |          |                      |             |                |                     |                |             |                      |             |                |                     |                |             |        |       |     |   |     |    |                 |  |  |   |
| 05/14/22        | 2   | Major Revision   | S.Apil              | D. Dadulla                           | R. Alcantara  |                |                        |                     |                 |                 |          |                      |             |                |                     |                |             |                      |             |                |                     |                |             |        |       |     |   |     |    |                 |  |  |   |
| 01/07/22        | 0   | Initial Issue  | D. Dadulla          | R. Alcantara                         | A. Arañes   |                |                        |                     |                 |                 |          |                      |             |                |                     |                |             |                      |             |                |                     |                |             |        |       |     |   |     |    |                 |  |  |   |
| Eff./Rev. Date  | Rev. No.  | Details of change  | Revise              | Check                                | Approve   | Est. date:     | January 7, 2022        |                     |                 |                 |          |                      |             |                |                     |                |             |                      |             |                |                     |                |             |        |       |     |   |     |    |                 |  |  |   |

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DCC Stamp



Process Name/ Title:

Cut and Crimp Inspection

Document No:

WI-QAD-QAC-190

WORK INSTRUCTION

Effective Date:

June 20, 2024

Product Code/Name:

All Crimped Wires

Customer Code:


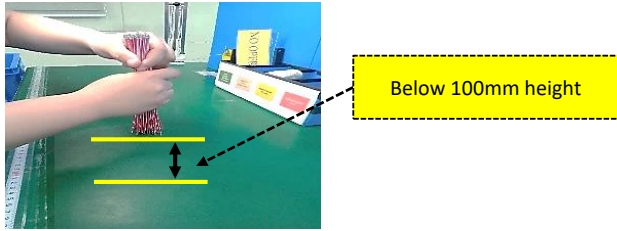



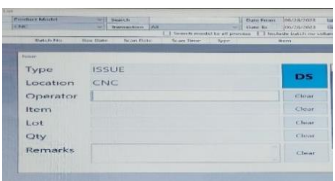
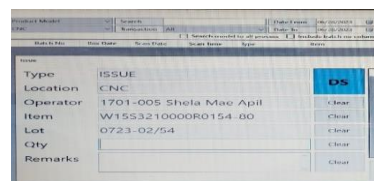
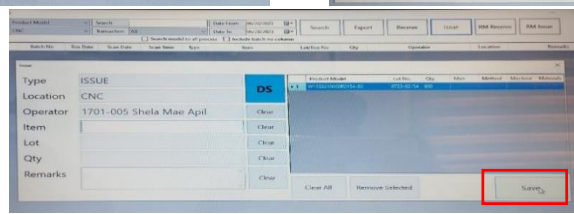
All Applicable

Rev. No.:

5

Page No.:

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| No.             | Work Procedure/ Illustration   | Records/Remarks/<br>Quality Pointers  |                     |                        |                     |                 |                 |                |                       |                 |                |                     |                |             |                 |           |          |                       |             |                |                     |                |             |   |     |    |                 |      |  |  |
|-----------------|--|---|---------------------|------------------------|---------------------|-----------------|-----------------|----------------|-----------------------|-----------------|----------------|---------------------|----------------|-------------|-----------------|-----------|----------|-----------------------|-------------|----------------|---------------------|----------------|-------------|---|-----|----|-----------------|------|--|--|
|                 | <p>In High speed machine there are two allocated inspectors for terminal 1 and terminal 2 (Small and Big terminal)</p> <div> <div>A. Inspector 1 should inspect the small terminal</div>  <div>A. Inspector 2 should inspect the Big terminal</div> </div>   | <p>► Count the quantity of per bundle while inspection of per piece.(Applicable only in High Speed Machine).</p> <p>► After inspection of small terminal put in the crimped wire holder in the middle of table then inspector 2 will get and inspect the big terminal.</p>  |                     |                        |                     |                 |                 |                |                       |                 |                |                     |                |             |                 |           |          |                       |             |                |                     |                |             |   |     |    |                 |      |  |  |
| 6               | <p>Distance of wire bundling</p>   | <p>► It must be below 100mm on the table.</p> <p><b>** Terminal tip distance from the table during alignment must be followed to prevent terminal deformation.</b></p>  |                     |                        |                     |                 |                 |                |                       |                 |                |                     |                |             |                 |           |          |                       |             |                |                     |                |             |   |     |    |                 |      |  |  |
| 7               | <p>Wrap and tie the terminal</p> <div> <div>A</div>  <div>B</div>  </div>   | <p>► Below list are the terminals need to wrap with clean paper to avoid any deformation.</p> <table> <tr> <td>*8100-3617</td> <td>*7D0349-0060</td> </tr> <tr> <td>*8100-3623</td> <td>*505572-1000</td> </tr> <tr> <td>*SPHD-001T-P0.5</td> <td>*SXA-001T-P0.6</td> </tr> </table> <p>► Get another bundle from the for inspection table or box. Repeat procedure 5 ~ 7.</p> <p>► Repeat the procedure to the remaining bundles subject for inspection</p> <p>► Use yellow rubber band with hook.</p>   | *8100-3617          | *7D0349-0060           | *8100-3623          | *505572-1000    | *SPHD-001T-P0.5 | *SXA-001T-P0.6 |                       |                 |                |                     |                |             |                 |           |          |                       |             |                |                     |                |             |   |     |    |                 |      |  |  |
| *8100-3617      | *7D0349-0060   |   |                     |                        |                     |                 |                 |                |                       |                 |                |                     |                |             |                 |           |          |                       |             |                |                     |                |             |   |     |    |                 |      |  |  |
| *8100-3623      | *505572-1000   |   |                     |                        |                     |                 |                 |                |                       |                 |                |                     |                |             |                 |           |          |                       |             |                |                     |                |             |   |     |    |                 |      |  |  |
| *SPHD-001T-P0.5 | *SXA-001T-P0.6   |   |                     |                        |                     |                 |                 |                |                       |                 |                |                     |                |             |                 |           |          |                       |             |                |                     |                |             |   |     |    |                 |      |  |  |
| 8               | <p>Accomplish Daily Report and ID Tag</p> <table border="1"> <thead> <tr> <th colspan="2">INSPECTION TIME</th> <th rowspan="2">Color of wire (Actual)</th> <th rowspan="2">PRODUCT NAME/ MODEL</th> <th rowspan="2">LOT NO./BOX NO.</th> <th rowspan="2">WIRE TYPE</th> <th rowspan="2">DIAMETER</th> <th rowspan="2">Color of wire(ID tag)</th> <th rowspan="2">WIRE LENGTH</th> <th rowspan="2">Qty per Bundle</th> <th rowspan="2">7D0349-0060 Lot No.</th> <th rowspan="2">INSPECTED QTY.</th> <th rowspan="2">DEFECT QTY.</th> </tr> <tr> <th>Start</th> <th>End</th> </tr> </thead> <tbody> <tr> <td>7:00</td> <td></td> <td>G</td> <td>7L0053-7025</td> <td>0224-1</td> <td>TVSSF</td> <td>0.3</td> <td>G</td> <td>806</td> <td>20</td> <td>2023-2-23(2-19)</td> <td>1500</td> <td></td> </tr> </tbody> </table> <div> <div>Identification Tag</div>  <div>Write inspector's code and inspection date</div> </div> | INSPECTION TIME   |                     | Color of wire (Actual) | PRODUCT NAME/ MODEL | LOT NO./BOX NO. | WIRE TYPE       | DIAMETER       | Color of wire(ID tag) | WIRE LENGTH     | Qty per Bundle | 7D0349-0060 Lot No. | INSPECTED QTY. | DEFECT QTY. | Start           | End       | 7:00     |                       | G           | 7L0053-7025    | 0224-1              | TVSSF          | 0.3         | G | 806 | 20 | 2023-2-23(2-19) | 1500 |  | <p>► End time should accomplish every end of the shift.</p> <p>► Count the no.of bundles after inspection of 1 box compare the actual count vs. ID tag.It should be no discrepancy.</p> <p>► Write the inspected quantity on daily report and write inspector details on ID Tag.</p> |
| INSPECTION TIME |  | Color of wire (Actual)  | PRODUCT NAME/ MODEL |                        |                     |                 |                 |                |                       |                 |                |                     |                |             | LOT NO./BOX NO. | WIRE TYPE | DIAMETER | Color of wire(ID tag) | WIRE LENGTH | Qty per Bundle | 7D0349-0060 Lot No. | INSPECTED QTY. | DEFECT QTY. |   |     |    |                 |      |  |  |
| Start           | End  |   |                     |                        |                     |                 |                 |                |                       |                 |                |                     |                |             |                 |           |          |                       |             |                |                     |                |             |   |     |    |                 |      |  |  |
| 7:00            |  | G   | 7L0053-7025         | 0224-1                 | TVSSF               | 0.3             | G               | 806            | 20                    | 2023-2-23(2-19) | 1500           |                     |                |             |                 |           |          |                       |             |                |                     |                |             |   |     |    |                 |      |  |  |
| 9               | <p>Scanning of Identification Tag</p> <div>    </div>   | <p>► Type of transaction is Issue</p> <p>► Double check the scanning details before clicking the save button.</p> <p>► If accidentally input or scanned wrong data click the clear or call the attention of Leader.</p> <p>► Place the Identification tag on the after inspection box.</p> <p>► After completing inspection of one (1) lot, move it to the" after inspection " area.</p> <p>► Make sure that the location is free from the falling objects/water to avoid foreign material, product corrosion or any abnormalities.</p> <p>► Use skateboard for moving parts in the finish goods.</p> |                     |                        |                     |                 |                 |                |                       |                 |                |                     |                |             |                 |           |          |                       |             |                |                     |                |             |   |     |    |                 |      |  |  |

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