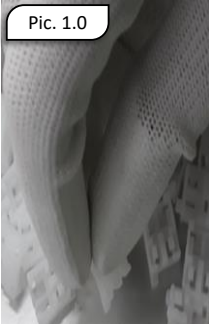


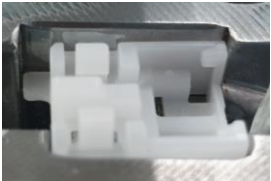

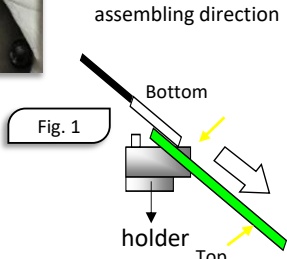
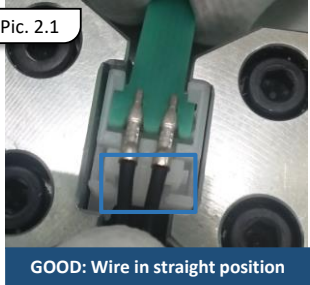

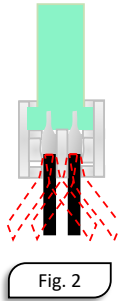
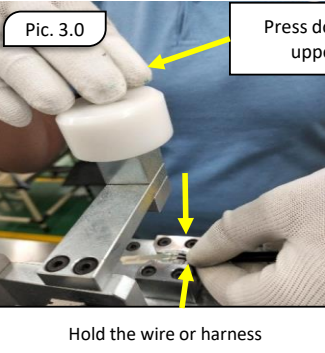
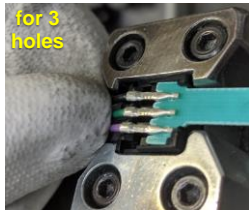

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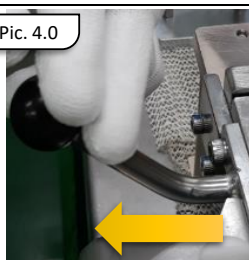

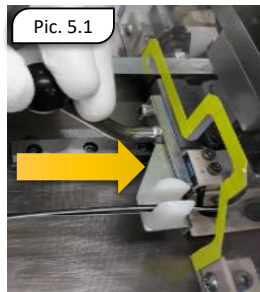

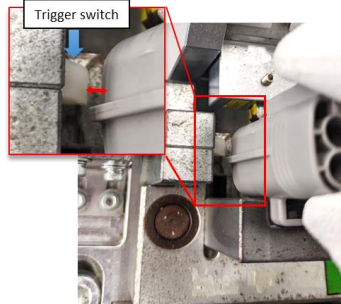

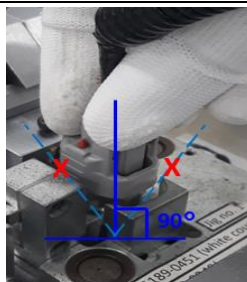


Parts:	1. Holder: 7K0575-0031, 7K0639-0030	Jig:	1. Holder jig 2. Engraving jig
No.	Work Procedure/ Illustration	Records / Remarks / Quality Pointers	

HOLDER and ENGRAVING ASSEMBLY			
1	<p>Simultaneously:</p> <p>Right hand: Get and insert the holder (Pic. 1.0) in the holder jig (Pic. 1.1).</p> <p>Left Hand: Get product with soldered stator from the box (Pic. 1.2).</p> <p>Inspect the soldering condition according to IS-PRO-COS-009.</p>	  	<p>Ensure to wear white gloves.</p> <p>Ensure to conduct hatsumono and owarimono every start up and change model.</p> <p>Check the alignment marking of the stopper bolt and all the screw in the jig.</p> <p>Correct position of holder in jig:</p>  <p>Note: <u>Use 7K0639-0030 holder for 3 holes model</u></p>
2	P1 <p>Left and Right Hand: Slide the soldered stator slantly (from top to bottom Fig.1) in the holder (Pic.2.0)</p> <p>Refer to Pic 2.1 for Good Sample of wire position.</p> <p>Pic. 2.2 and Fig. 2 for NG Sample of wire position.</p>	 	<p>Pattern should be facing downward.</p> <p>Ensure to lock the stator in holder before pressing the jig.</p> <p>Ensure to position the wire properly before pressing or punching the jig</p> <p>Refer to Pic 5.1 for Good Sample of wire position.</p> <p>Pic. 5.2 and Fig. 1 for NG Sample of wire position.</p>
	  		
3	<p>Left Hand: Hold the wire or harness.</p> <p>Right Hand: Press the down the holder jig. (Pic.3.0)</p> <p>Note : Use 2 to 3 Fingers upon pressing the holder jig to apply enough force.</p>	 	<p>If encountered bend stator after holder assembly, call the attention of the Leader.</p>

04/25/2025	14	Change "Continue to conduct Item no. 1 to 4" to "Continue to conduct Item no. 1 to 3".	A.Ayop	W.Carbillon	W.Carbillon	Prepare	Check	Approve
03/14/2025	13	Change sequence to grease application then engrave and add wait for jig to lock prior release of lever.	A.Ayop	W.Carbillon	W.Carbillon			
10/04/2024	12	Add process of P2 (old sequence) to P1.	A.Ayop	W.Carbillon	W.Carbillon			
06/03/2024	11	Change model that uses 7K0639-0030 from 7M0516-7021 to 3 holes model	A.Ayop	W.Carbillon	W.Carbillon			
05/23/2024	10	Separate WI into individual process, added parts and jig and process (P1).	A.Ayop	W.Carbillon	W.Carbillon			
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	November 5, 2021	

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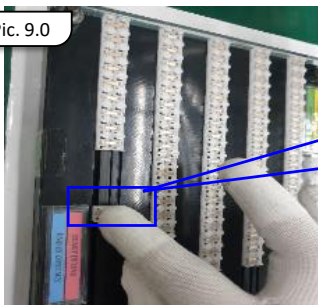


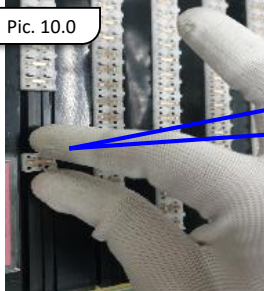


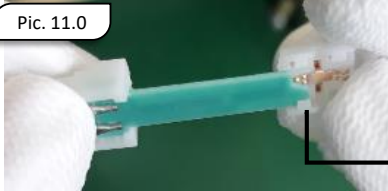
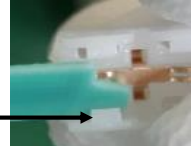
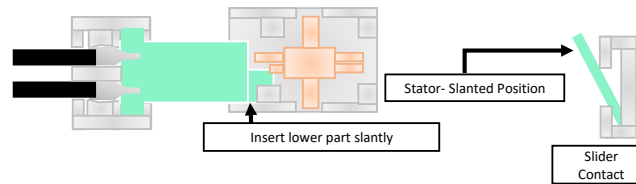
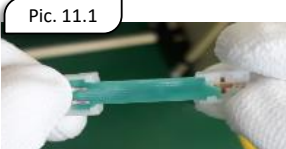
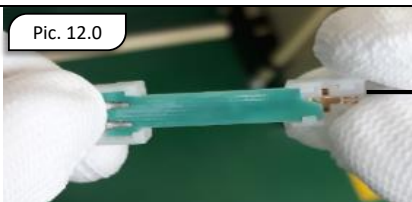

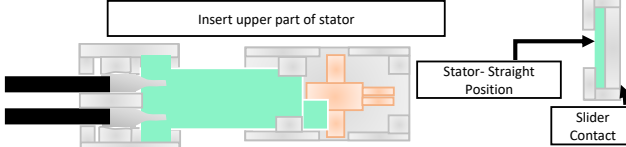


No.	Work Procedure/ Illustration		In-Charge
4	Left Hand: Transfer the product to the right hand then pull the lever of grease applicator jig (Pic. 4.0)		
5	Rigth hand: Insert the soldered stator with holder and lock the jig (Pic. 5.0) Left Hand: Push in the lever of grease applicator jig (Pic. 5.1) to commence grease application.	 	*Wait for the machine to lock the jig prior release of lever to avoid misaligned grease application.
6	While waiting for grease machine to finish: For long length harness: Put on the connector in the engraving jig. (Pic.5.0)	 	
7	After setting the connector, slowly push down the connector for engrave. (Refer to Pic.6.0)	 	
8	Put the assembled stator to the WIP holder between P1 and P2 (Pic. 7.0).		
9	For short to medium length harness: ⚠ Continue to conduct Item no. 1 to 3. Then while holding the product with holder (left hand) get the product from grease machine (right hand) then transfer to left hand (Pic 8.0).		

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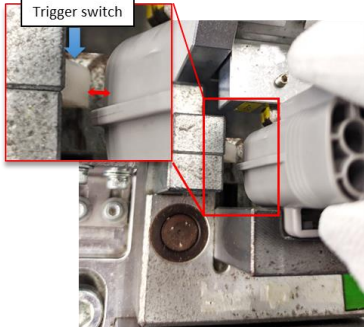

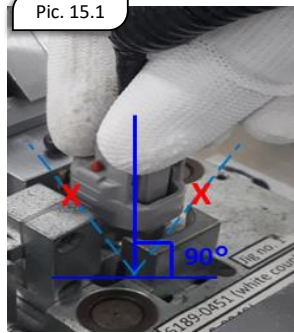
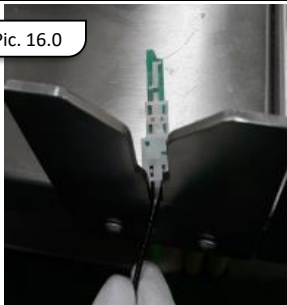
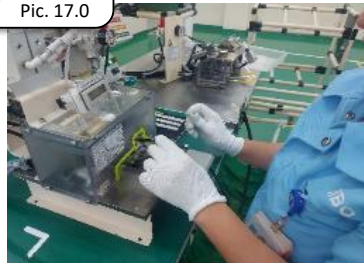
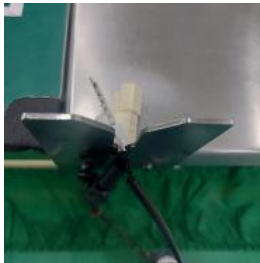
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No.	Work Procedure/ Illustration		In-Charge
10	Right Hand: Slide the slider contact towards operator prior picking.(Pic. 9.0) Finger must be positioned at the top of slider contact.(Pic. 9.1)	 	Plate must be positioned where contact slider side is facing the operator.(Pic.9.2)  <i>*If slider contact detach from plate, it must be returned to plate prior use in product to ensure correct orientation.</i>
11	Get the slider contact. It must be picked up at the side of slider to avoiding hitting the contact tip. (Pic.10.0)	 	Avoiding hitting the contact tip: 
12	Left and Right: Hold the soldered stator with grease slantly insert to the lower part of the slider grip (Pic. 11.0).	  	Ensure to follow the proper face and positioning of the stator in inserting the slider.  Proper facing: Silver plating should facing backward while inserting the slider contact (Refer to Pic. 11.1)
13	Insert the upper part of the stator to the upper slider grip (Pic.12.0)	  	The slider is securely fitted to the stator. Forcing the stator to insert to slider contact during the assembly may lead to NG product (deform contact, damage stator). <i>*Re-insertion of slider contact is strictly prohibited. Only Leader and abnormality is allowed to conduct re-insertion of slider contact.</i>
14	Insert the slider to stator (Pic.13.0) If 2 heads repeat No. 10 (2nd stator) simultaneously insert slider contact to 1 stator with grease	 	

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No.	Work Procedure/ Illustration		In-Charge
15	Put on the connector in the engraving jig. (Pic.14.0)	<div><div>Pic. 14.0</div></div> <div><div>Trigger switch</div></div>	Re-insertion of connector is prohibited. Connector should not touch the trigger switch when setting the Connector prior engraving. Should have at least small clearance between Connector and trigger switch. (Pic.7)
16	After setting the connector, slowly push down the connector for engrave. (Refer to Pic.15.0)	<div><div>Pic. 15.0</div></div> <div><div>Pic. 15.1</div></div>	
17	Put the assembled stator to the WIP holder between P1 and P2 (Pic. 16.0).	<div><div>Pic. 16.0</div></div>	NOTE : "REWORK /RE-INSERTION OF SLIDER IN PROCESS IS STRICTLY PROHIBITED, FOLLOW ABNORMALITY PROCEDURE"
18	Put the product with holder to grease machine (Pic. 17.0) then repeat item no. 1 to 10.	<div><div>Pic. 17.0</div></div> 	

Change sequence to grease application then engrave and add wait for jig to lock prior release of lever.

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