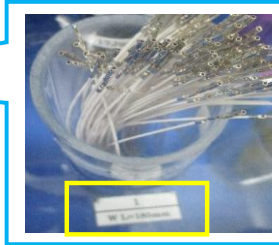


No.	Work Procedure/ Illustration
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- 1) During start-up operator must check the actual parts delivered if tally vs. the parts preparation card inserted on the box.
Note: For crimped wires, ensure that tube labels are facing the operator before setup

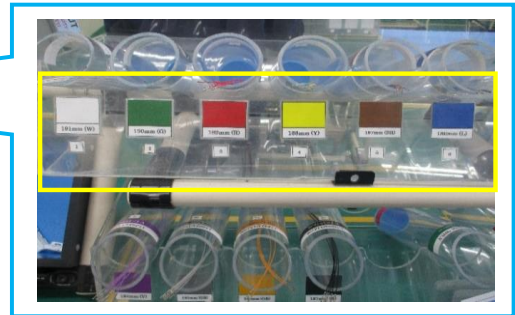


4

Note:

1. Conduct 5S every end of shift including cleaning of jig.
2. P1 to P6 set-up parts simultaneously

- 2) Operator simultaneously get the empty tubes on rack and tubes with wires on parts box until all empty tubes are replaced.
Note: Operator must check the group of wires to be used based on the model's requirements
 Labels on tube rack must be tally with the tube label of prepared parts







- 3) Replace the empty blue bin on levercon line with bin containing prepared parts.



- 4) Return parts preparation card on parts box once all parts are set.
- 5) P1, P3, and P4 should check connector if good or half-locked/ locked. If half-locked/ locked, operator will call the attention of leader.
- Note:** Operator must fill-up change product checklist (F-PRO-ASY-020) given by line leader once there is a need for change of line setup due to change of product/ model to be produced.

[illegible]

05/06/2024		Removal of checking first piece (P1-P5)	K.Hernandez	K.Aquino	W.Carbillon	Prepare	Check	Approve
12/14/2021	3	Add details on note/ Add andon light during set-up/ Add process no. 5	A.Morcozo	W.Carbillon	O. Merin	  		
06/07/2021	2	Add note and change illustration.	J. Silang	W.Carbillon	O. Merin			
09/07/2018	1	Add note and sample form picture on no. 4.	A.Morcozo	W.Carbillon	O. Merin			
12/18/2017	0	Initial issue	A.Morcozo	O. Merin	T. Sugiyama			
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	12/18/2017	

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