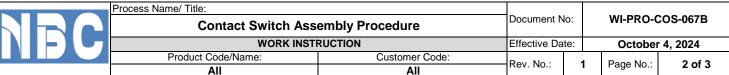


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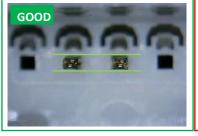


	H	-] 57	V	VORK INST	RUCTION		Effective Da	te:	October	4, 2024
			Product Code/Name:		Customer All		Rev. No.:	1	Page No.:	2 of 3
No.			<u></u> ∰ Wor	k Procedure	/ Illustration				In-Ch	arge
6		Focus o perform * for the Jig Wire ma	will be marked once function test is GOOD. (Pic. 6.0) In the alarm / green light, then in YOSH once GO green light appeared. (Pic. 6.1) If set up per model please refer to trix for jig conversion set up of function test machine.	Pic. 6.0		Pic. 6.1			Check if the set based on following set	the tings:
7	the stat (i Right Ha After func	the stator. ((for a Right Hand: After function Left Hand: g	connector from the FT jig first, then (Caution: Stator is in lock condition intil connector is remove) (Pic. 7.0). After function test: all models except 2 heads) : Put the product to the WIP holder. (for 2 heads models) It test inspect the product in reference to IS-PRO-COS-009. get another product from WIP holder cosess 2. Follow step no. 1 - 4.		Pic.	7.0			NO / NC (n	NO/NC

Note:

If encounter deformed terminal during insertion, STOP-CALL-WAIT. Check the mating connector condition and replace if damaged.

DEFORMED TERMINAL ILLUSTRATION





MATING CONNECTOR ILLUSTRATION





FIRST and LAST Piece Tag

Attach first and last piece away from the connector where green mark is located.

Sample location of first/last piece tag:





	Process Name/ Title:					_	
١	Contact Switch Asse	embly Procedure	Document No:		WI-PRO-COS-067B		
1	WORK INSTE	Effective Date:		October 4, 2024			
Product Code/Name:		Customer Code:	Day No.	4	Dogo No.	2 -4 2	

AII

Mire matrix for jig conversion set-up of function test machine	Λ	Wire	matrix	for jig	conversion	set-up o	f function	test machine
--	-----------	------	--------	---------	------------	----------	------------	--------------

All

Reminders
If encountered abnormality conduct STOP - CALL - WAIT for
Leader / Freeman. If Freeman cannot decide on the
judgement put on hold the affected FG box with proper labelling and
product for verification should be put
on top with plastic.

Page No.:

3 of 3

		FUNCTION TEST	JIG CONVERTION				
MODEL	CATEGORY	FUNCTION TEST SET-UP	CATEGORY	SLOT NO.	WIRE COLOR SET-UP	WIRE COLOR SET-UP	
			CONTACT	1	BLACK		
	MR+CONTACT	NO	CONTACT	3	BLACK		
			MR	9	BLACK/WHITE		
				8	GREEN		
2 WIRES	CONTACT		CONTACT	1	BLACK		
2 WIKES		NC	CONTACT	2	BLACK		
			CONTACT	1	BLACK		
				2	BLACK		
			2 HEADS	9	VIOLET		
				8	VIOLET		
	MR+CONTACT	NO/NC	CONTACT	1	BLACK		
				2	VIOLET		
				3	GREEN		
2.14//DEC			MR	9	BLACK/WHITE		
3 WIRES				8	GREEN		
	CONTACT			1	BLACK		
		NO/NC	CONTACT	2	VIOLET		
				3	GREEN		

Work Procedure/ Illustration

SAFE KEEPING OF MARKER

In the event of taking a long break, the marker should be taken out from the jig and cover it to avoid dryness.







uncover the marker and LEADER will conduct Hatsumono prior production and fill up the Product Check sheet (F-PRO-COS-020) (F-PRO-COS-021).

Rev. No.:

Take out

Set aside When resuming the task, return back the marker to the marker's jig and proceed with the operation.







NOTE: Disposition of marker should be decided by LEADER (GOOD or NO GOOD) before replacing with a NEW one. Product produced before and after replacement must be checked prior transfer to FG box.

Records/Remarks/

Quality Pointers

NOTE: Only FREEMAN is allowed to

REPLACE AND REFILLING MARKER

REPLACE of NEW MARKER



Operator press the Yellow Andon to call the attention of Leader/ Freeman



Leader/ Freeman remove the marker from tester jig.



Leader/ Freeman uncover the NEW Marker, and put to the Tester Jig.

Condition of green mark to be used as reference when need to replace / refill



* Green mark condition already faded .

Used PPE during refilling of Marking

REFILLING OF MARKER

Leader / Freeman give the Marker to Assist for Refill.







When Assist refilling the marker, the first one to use is the sachihata (green Ink) and last is the Solvent.



Assist will give back the marker to Leader / Freeman after refilling.

NOTE: Sachihata and Solvent refilling depends on the Leader/ Freeman order on how many drops needed.

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