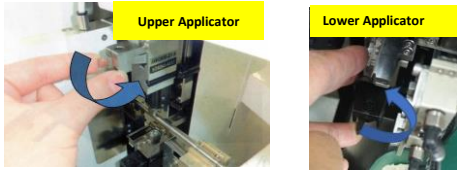
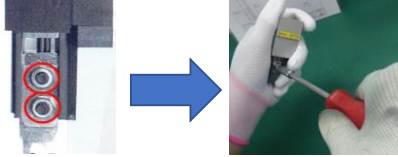





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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
⚠	<b>A. How to Remove Upper and Lower Applicator</b> 	
⚠	<b>B. How to disassemble Upper Applicator</b> 	Use screw wrench
		Make sure that the engrave parts is in the upper
⚠	<b>C. Different parts of upper applicator (Disassemble)</b> <b>Applicator Name: 8240-0182 (Levercon)</b> Remove the following. <ul style="list-style-type: none"> <li>1. Bolt</li> <li>2. Spacer</li> <li>3. Wire holder down</li> <li>4. Wire hold down spacer</li> <li>5. Spacer</li> <li>6. Wire Crimper</li> <li>7. Spacer</li> <li>8. Insulation Crimper</li> </ul> 	
⚠	<b>Applicator Name: 1827855-4 (Levercon)</b> Remove the following. <ul style="list-style-type: none"> <li>1. Bolt</li> <li>2. Spacer</li> <li>3. Wire holder down</li> <li>4. Wire hold down spacer</li> <li>5. Spacer</li> <li>6. Wire Crimper</li> <li>7. Spacer</li> <li>8. Insulation Crimper</li> </ul> 	
⚠	<b>Applicator Name: SPHD-001T-P0.5 (Steering)</b> Remove the following. <ul style="list-style-type: none"> <li>1. Bolt</li> <li>2. Spacer</li> <li>3. Wire holder down</li> <li>4. Wire hold down spacer</li> <li>5. Spacer</li> <li>6. Wire Crimper</li> <li>7. Spacer</li> <li>8. Insulation Crimper</li> </ul> 	
⚠	<b>Applicator Name: 1674311-1 (Steering)</b> Remove the following. <ul style="list-style-type: none"> <li>1. Bolt</li> <li>2. Spacer</li> <li>3. Wire holder down</li> <li>4. Wire hold down spacer</li> <li>5. Spacer</li> <li>6. Wire Crimper</li> <li>7. Insulation Crimper</li> </ul> 	

10/06/2020	⚠	Major changes in the procedure. Add details for steering applicator.	W. Valdez	W. Carbillon/Y. Yamamoto	O. Merin	W. Valdez	W. Carbillon	O. Merin
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	10/06/2020	

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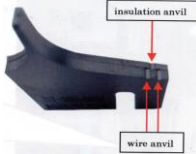

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<b>WORK INSTRUCTION</b>		Effective Date:	<b>October 6, 2020</b>
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No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
1	<b>Applicator Name: 1123343-1 (Steering)</b> Remove the following. 1. Bolt 2. Spacer 3. Wire holder down 4. Wire hold down spacer 5. Spacer 6. Wire Crimper 7. Spacer 8. Insulation Crimper		
1	<b>Applicator Name: 1376109-1 (Steering)</b> Remove the following. 1. Bolt 2. Spacer 3. Wire holder down 4. Wire hold down spacer 5. Spacer 6. Wire Crimper 7. Insulation Crimper		
	Properly clean the applicator and applicator parts using clean rags. <b>Note:</b> Change parts if needed		Make sure that there is no terminal oil and dust left.
1	<b>D. How to assemble upper applicator</b>		
	Get the last applicator parts from the tray. Put the parts in the body of applicator		Check the engrave parts, Engrave parts must be on the top.
	Get applicator parts one by one from the last number until the first number.		Engrave parts always on the top
	Lock the two bolt in applicator		
1	<b>E. Check Point after assemble Upper Applicator</b>		
	Check the tightness or lock of bolt		
	Check the alignment of wire crimper		

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No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers	
	<p>Check the wire holder down. Good set-up result good appearance of terminal, but NG set-up result deform terminal.</p>	<p>Good Set-up</p>  	<p>NG Set-up</p>  	<p>Avoid reverse the wire holder down, always check the engrave parts. Engrave parts always on top.</p>
⚠	F. How to disassemble Lower Applicator			
	<p>Loose the screw of wire anvil and insulation anvil.</p>	<div><div>Bend Up adjuster bolt</div><div>Bolt of wire anvil and insu anvil</div></div>	<p>Don't loose bend up adjuster screw.</p> <p>Use Allen wrench</p>	
	<p>Remove applicator parts one by one.Place the parts into the tray.</p> <p>1.Bend up adjuster 2.Control anvil OSA 3.Wire anvil 4.Insulation anvil</p>	  	<p>Levercon and steering Lower applicator parts is same.</p>	
	<p>Properly clean the applicator and applicator parts using clean rags.</p> <p><b>Note:</b> Change parts if needed.</p>	 	<p>Make sure that there is no terminal oil and dust left.</p>	
⚠	G. How to Assemble Lower Applicator Parts			
	<p>Get the last applicator parts from the tray. Put the parts in the body of applicator</p>	 		
	<p>Get applicator parts one by one from the last number until the first number.</p>	 	<p>Engrave parts always on the top</p>	
	<p>Lock the bolt in applicator</p>			

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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
⚠	H. Check Point after assemble Lower Applicator	
	<div>Check the tightness or lock of bolt</div> <div></div>	
	<div>Check the alignment of wire crimper and sequence of anvil</div> <div>   </div>	One line indicated by the arrow is an insulation anvil. Two line is for wire anvil.
	<div>No gap between base of applicator and bend up adjuster</div> <div></div>	To Avoid Bend Terminal
	<div>Check all over all apperance of applicator</div> <div></div>	