





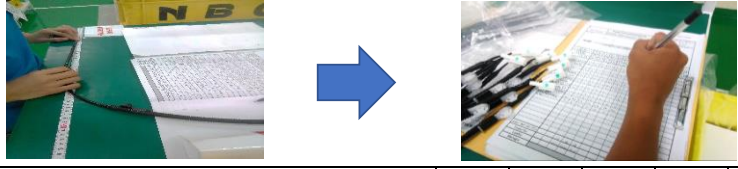









	Process Name/ Title:				Document No:		WI-QAD-QAC-031	
	<div style="text-align: center;">  SEATBELT -FG INSPECTION </div>				Effective Date:		February 17, 2024	
	<div style="text-align: center;"> WORK INSTRUCTION </div>				Rev. No.:		14	
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SEATBELT		TRJ/TRQSS/TRMX						

No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers								
①			<p>► Every start of the shift review the work Instructions and inspection standard.</p> <p>► Applicable inspection standard should also be reviewed every change of product type.</p> <table border="1"> <thead> <tr> <th>PRODUCT TYPE</th> <th>INSPECTION STANDARD CONTROL NUMBER</th> </tr> </thead> <tbody> <tr> <td>Sub Assy Inspection Points</td> <td>IS-QAD-QAC-001</td> </tr> <tr> <td>Seatbelt - Contact SW Assy</td> <td>IS-QAD-QAC-002</td> </tr> <tr> <td>Seatbelt MR SW Assy</td> <td>IS-QAD-QAC-004</td> </tr> </tbody> </table>	PRODUCT TYPE	INSPECTION STANDARD CONTROL NUMBER	Sub Assy Inspection Points	IS-QAD-QAC-001	Seatbelt - Contact SW Assy	IS-QAD-QAC-002	Seatbelt MR SW Assy	IS-QAD-QAC-004
PRODUCT TYPE	INSPECTION STANDARD CONTROL NUMBER										
Sub Assy Inspection Points	IS-QAD-QAC-001										
Seatbelt - Contact SW Assy	IS-QAD-QAC-002										
Seatbelt MR SW Assy	IS-QAD-QAC-004										
②	 <p>Turn the box upside down to make sure that there is no foreign object adhere or present inside/outside the box.</p> <p>Put the clean vinyl plastic in the box</p> <p>Turn vinyl plastic upside down to check if there is no foreign material inside</p>	<p>► Check if the Master Sample, Inspection Performance, Packaging Checklist, Packing Instruction and Jig of the corresponding model given by TP man are same to the parts to be inspect.</p> <p>► Fill in the Daily Inspection Record (F-QAC-393) the required details prior start of the inspection.</p>									
③	 <p>Counter reset will be conducted by inspector before start of each box.</p> <p>Control box reset will be performed by Senior leader/Leader/Sub leader on any abnormality encounters in the inspection area.</p>	<p>NOTE: Procedures related to punch marking is applicable for seatbelt models only.</p> <p>► Checking of master/dummy sample in punchmark jig will be conducted during the start up or prior use of jig. Please note that only those jigs with continuity has dummy sample to be tested.</p> <p>► Use 1st piece of product as reference for good punchmarking.</p> <p>► Fill-in the Daily Equipment Checksheet (F-QAC-007) for the required details.</p>									
④	 <p>Identification Tag</p>	<p>► Ensure that the details in production ID Tag versus actual parts has no discrepancy (eg. Quantity, revision level, part no., etc.)</p> <p>► Fill in the Daily Inspection Record and Inspection Performance the Lot Number, ID tag Number, Date and Revision</p>									
⑤	<p><u>DIMENSION CHECKING</u></p> <p>Dimension checking is being conducted in the first unit only for every box.</p> 	<p>Record the result in the inspection Performance Check sheet</p> <p>* USE SUB ASSY INSPECTION PERFORMANCE FOR SUB ASSY CHECKPOINTS.</p> <p>* USE FG INSPECTION PERFORMANCE FOR FG CHECKPOINTS.</p> <p>* PUT N/A FOR NOT APPLICABLE CHECKPOINTS IN INSPECTION CHECKPOINTS.</p> 	<p><u>FILL-IN INSPECTION PERFORMANCE CHECKSHEET IS BASED ON THE FIRST PIECE INSPECTION.</u></p> <p>Dimension Check - data should be written after measuring each dimension checkpoint. n= 1pc./box</p> <p>Visual Check - the result will be written after comparison of the first piece with the Master Sample. n = 100 % inspection</p>								
02/17/24	14	<p>- Major Revision - Remove related instruction for Levercon, Steering and Hazard</p> <p>- Change product code from common to seatbelt product</p> <p>- Change customer code from All Applicable to TRJ/TRQSS/TRMX</p> <p>- Change Work instruction title</p> <p>- Change comparison of first and last piece from per pack to per box.</p> <p>- Remove checking the presence of punchmark while counting.</p> <p>- Include additional quality pointers for the proper verification of inspected quantity.</p> <p>- Change instruction for the remaining piece per pack in by two's inspection.</p>	M.Garcia	D. Dadulla	R. Pascua	O.Merín	Prepare	Check	Approve	Noted	
11/18/23	13		M.Garcia	R. Pascua	O.Merín	n/a					
08/19/23	12		A. De Chavez	D. Dadulla	R. Pasqua	O.Merín					
07/31/23	11	<p>Exclude other process for TP man.</p> <p>Must put cover in aluminum profile on the right side of the table for Levercon & Steering model.</p> <p>Turn vinyl plastic bag upside down to check if there is no foreign material inside.</p>	S. Malabuyoc	D. Dadulla	O. Merin	A. Arañes					
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Noted	Est. date:	Jun 07, 2017			

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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
⑥	<p>CONDUCT DIMENSION/VISUAL INSPECTION</p> <p>COMPARISON WITH THE MASTER SAMPLE *FOR FIRST AND LAST PIECE PER BOX</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>SIDE-BY-SIDE COMPARISON</p> </div> <div style="text-align: center;">  <p>BY TWO'S INSPECTION</p> <div style="background-color: yellow; padding: 5px; border: 1px solid black;"> SEATBELT MODELS * Each components is compared during by two's inspection </div> </div> </div> <p>CONDUCT VISUAL CHECKING (BY TWO'S INSPECTION)</p> <div style="display: flex; align-items: center;">  <div style="margin-left: 20px;"> <p>AFTER INSPECTION (right side)</p> <p>Holder</p> <p>BEFORE INSPECTION (left side)</p> </div> </div> <p>One Bundle flow</p>  <p>Get 2 pcs of harness to conduct 100% dimension checking of end tape to end of holder using measuring template for applicable models only</p> <p>↓</p>  <p>Finish the inspection of every bundle before proceeding to FG inspection checkpoints.</p> <p>↓</p>  <p>After visual comparison (by two's inspection) put it on the holder or plastic.</p> <p>↓</p>  <p>Get the parts in the holder and conduct Switch assy inspection one-by-one/per piece after by two's inspection.</p>	<div style="text-align: right;">14</div> <ul style="list-style-type: none"> ▶ Check the appearance and accessories of parts. ▶ First piece and last piece per box shall be compared with the master sample. ▶ Every remaining piece in a pack shall be compared to the same unit that was inspected in by two's inspection in the same pack. ▶ Count visually the number of clamp (if applicable to the model for inspection) while comparing with the master sample. ▶ Use Sub Assy Inspection Performance for sub assy checkpoints ▶ Use FG Inspection Performance for FG checkpoints ▶ Put N/A for not applicable checkpoints in inspection performance. ▶ If the inspected part is GOOD, place the part in "After Inspection" area. ▶ If the inspected part is NG, press the alarm button to call the attention of the Leader. Then, follow the Control of Non-conforming and Corrective Action Procedure (NBP-OP-003). <p>REFERENCE GUIDELINES</p> <p>GL-QAD-QAC-017 Handling Defect and Abnormality Treatment Flow</p> <p>GL-QAD-QAC-018 QC Replenish Requisition Flow</p> <p>GL-QAD-QAC-034 Recording and Traceability of 4M Char Application</p>












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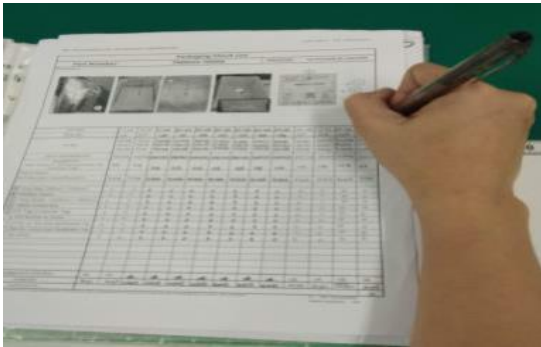
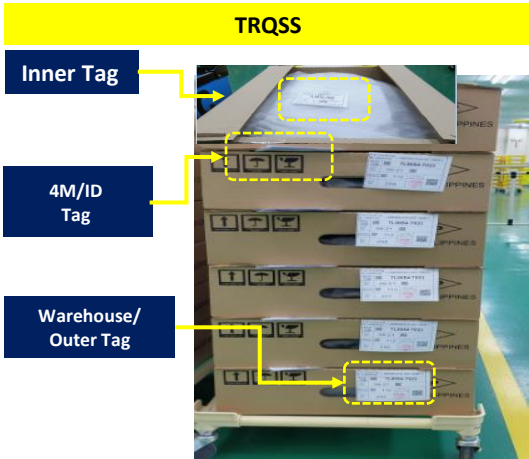
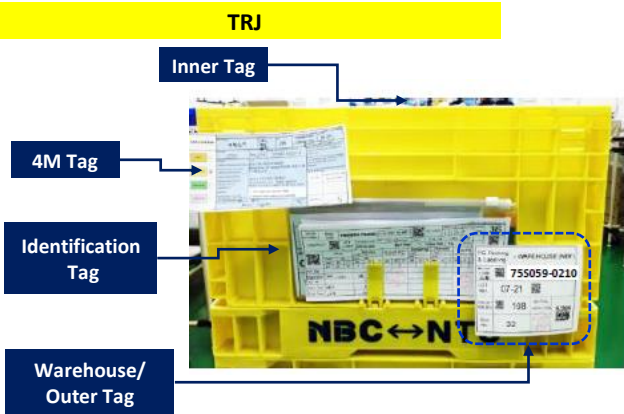
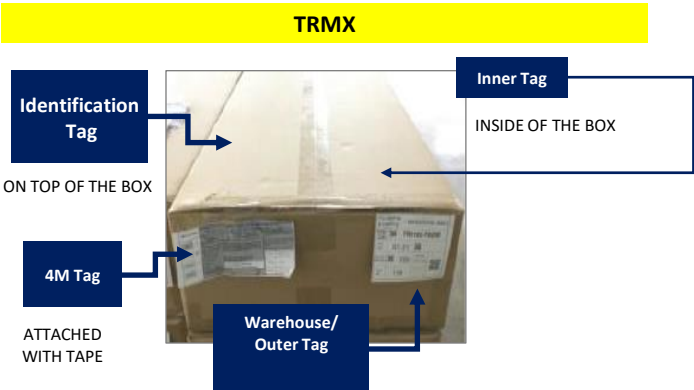
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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
⑦	<p>Punchmarking is conducted one-by-one/per piece right after Switch assy inspection.</p>  <p><i>For long harness, avoid switch assy parts to make contact or touch the inspection table or other objects. And keep the switch assy parts to avoid the accidental application of external force that will cause bent/deformed terminal/stator.</i></p>  <p><i>Left hand must be on coupler and right hand must be on the button of the jig during punchmark</i></p> <p>Always check the presence and appearance of punchmark after process.</p>	<p>► Punchmark must be visible.</p> <p>► Avoid putting stress on contact switch assy part that will cause bent/deformed terminal/stator.</p>   <p>► Connector must have no damage or not cracked.</p> <p>► Manual or no continuity detection jig identification (with button)</p> <p>► Continuity jig or with continuity checker (without button)</p>
⑧	 <p>14 Count the parts</p>  <p>Put the parts in the box</p>  <p>Flip the portion board to check if there is no foreign material before putting it to finished good box (for applicable models only)</p>	<p>► Parts should be place in the box located in after inspection</p> <p>► Make sure that manual counting is matched with the controller box counter.</p> <p>For any abnormality, Follow one-cycle stop, do the STOP-CALL and WAIT .</p>
⑨	<p>Fill in the Inspection Performance Check sheet the result of inspection</p>  <p>*** Write the total inspected quantity and judgment***</p>	<p>► Write legibly and correctly.</p>
⑩	<p>Pack the inspected parts</p> 	<p>► Ensure to get the Packaging Checklist and Packing Instruction of the corresponding model</p> <p>► Refer to packaging Checklist of each model for packaging checkpoints.</p> <p>► Refer to packing Instruction of each model for standard packaging</p>
⑪	<p>Stamp the tags with QC passed</p> <p>* Identification Tag - label attached by production</p> <p>*Inner tag -label to be attached on op of the box</p> <p>* Warehouse Tag - label to be attached outside the box</p> <div style="display: flex; justify-content: space-around;"> <div> <p>Inner Tag</p>  <p>QC STAMP</p> </div> <div> <p>Warehouse/Outer Tag</p>  <p>QC STAMP</p> </div> </div>	<p>► For QC stamping, it shall follow the format date-month-year</p> <p>► Lot number in inner and outer tag must correspond with the current month and year (mm-yy)</p> <p>► Check the details of ID tag, Inner tag and Warehouse tag if no discrepancy before stamp.</p>

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12	<p>Fill in the required details in packaging checklist.</p> 	<p>► FG tag no.'s must be in sequential order.</p>
13	<p>Conduct proper labeling</p> <p>LOCATION OF TAGS PER PACKAGING:</p> <div> <p>TRQSS</p>  </div> <div> <p>TRJ</p>  </div> <div> <p>TRMX</p>  </div>	<p>► Check the Lot Number, Box Number and Quantity in production Identification Tag vs. Inner Tag vs. Warehouse Tag</p> <p>► Put the Inner Tag on the top of plasticbag and attached the Warehouse Tag outside the box for warehouse reference.</p> <p>► Only external 4M shall be attached in FG boxes.</p>

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