

Panel

4412356

Date Printed: 03/12/2013 13:49

Standardized Work Sheet

Sequence

Part: 4412356 - Panel

Sheet: 1

Operation: Panel General Requirements

Operation Cycle Time: 0

Bill of Materials

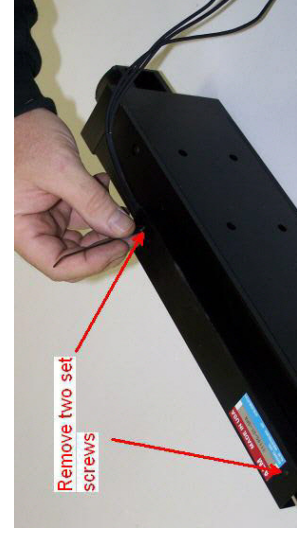
Part Number	Rev	Description	Qty	Reference Designator
777888		Housing	1.000	
456789		Cap Screw	4.000	
323232		Flat Washer	2.000	

Steps

Figure(s)	Seq	Steps	Symbol	Value Time	Waste Time	Cumulative Time
	1	General Requirements	👉	0.00	0.00	0
	2	Verify you read all required information	⚠️			
	3	Specifications - Changed Specs 1-22-13	👉	0.00	0.00	0
	4	Stage Shipping Locks	👉	0.00	0.00	0
1 2	5	Linear Stage Prep - Test Changes Made on a step in a work order 1-22-13 dew	👉	0.00	0.00	0
3	6	Clip Center Limit - Version Note test 2:12 on 1-22	👉	0.00	0.00	0
4 5	7	Solder pins	👉	0.00	0.00	0
	8	Center Limit Quality Check	🕒	0.00	0.00	0

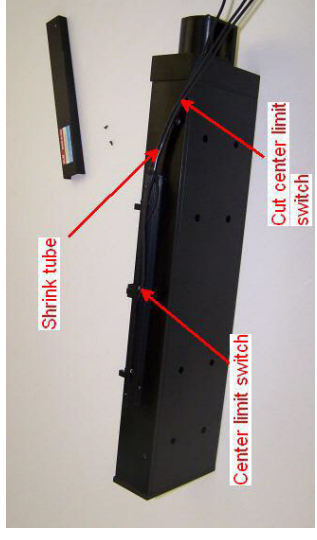
Icon:	Safety	Instruction	Alert	Quality	Environmental	Objective	Scope	Flow
	🛑	👉	⚠️	🕒	🌐	🎯	👉	📄

1



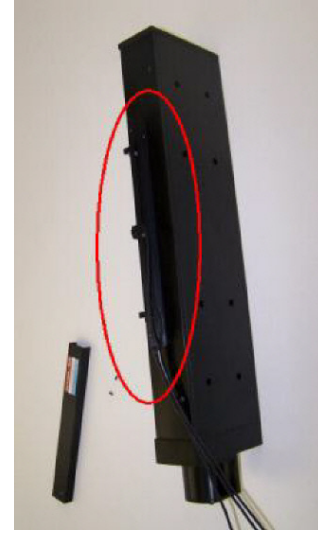
Remove Cover
Remove Cover

3



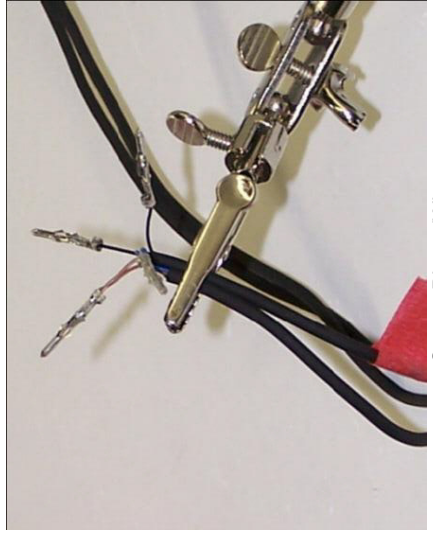
Center Limit Switch Cable
Center Limit Switch Cable

2



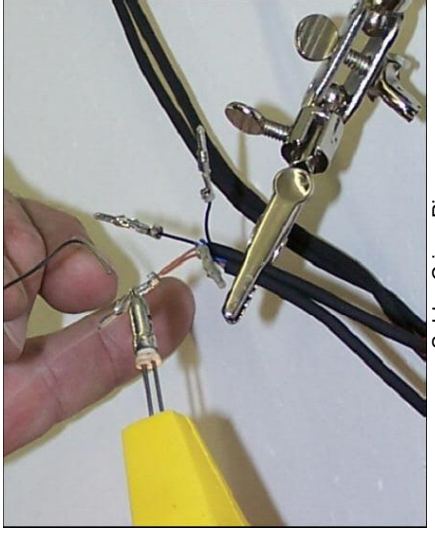
Limit Switch Cover Removed
Limit Switch Cover Removed

4



Secure Pins w/Wires
Secure Pins w/Wires

5



Solder Crimp Pins
Solder Crimp Pins

Approval Date: 3/12/2013

Sequence Admin

Approval By:

Sequence Admin

12/7/2012

Sequence Admin

12/7/2012

Sequence Admin

Standardized Work Sheet



Part: 4412356 - Panel

Sheet: 1

Operation: Panel

Operation Cycle Time: 0

Version:

1

2

1

1

Bill of Materials

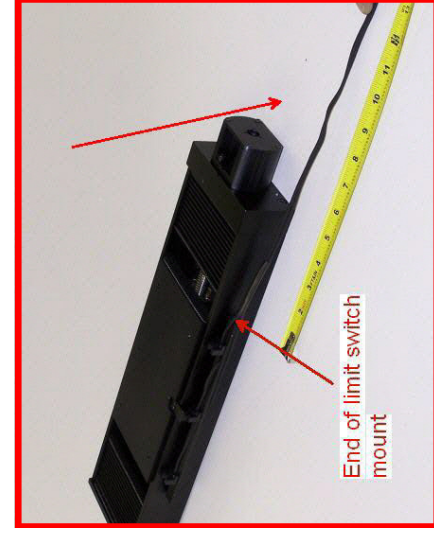
Part Number	Rev	Description	Qty	Reference Designator
456789		Cap Screw	8.000	
323232		Flat Washer	8.000	

Steps

Figure(s)	Seq	Steps	Symbol	Value Time	Waste Time	Cumulative Time
1	1	Clip other two wires	↗	0.00	0.00	0
2	2	Strip Insulation	↗	0.00	0.00	0
3 4	3	White Wires	↗	0.00	0.00	0
5 6	4	Mark Bottom Cable	↗	0.00	0.00	0

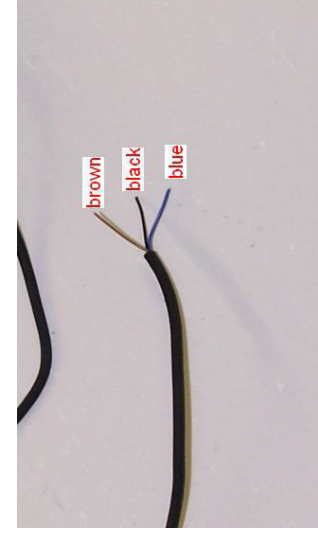
Icon:	Safety	Instruction	Alert	Quality	Environmental	Objective	Scope	Flow
	STOP	↗	⚠	6σ	🌍	🎯	👉	📄

1



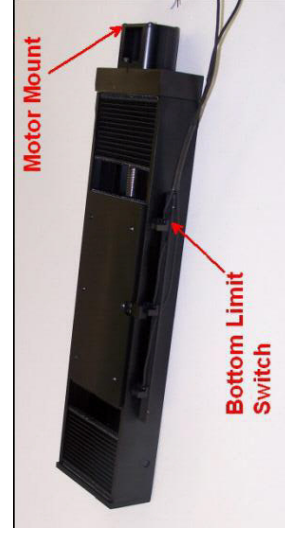
Cut Limit Switch Wires

3



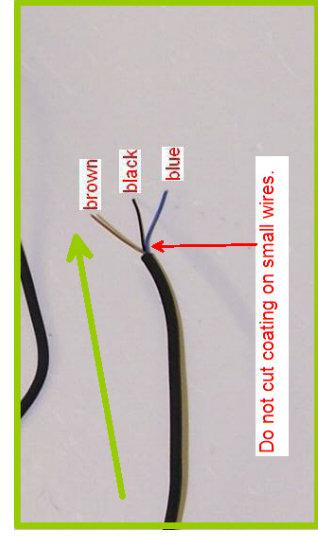
Cut off white wire

5



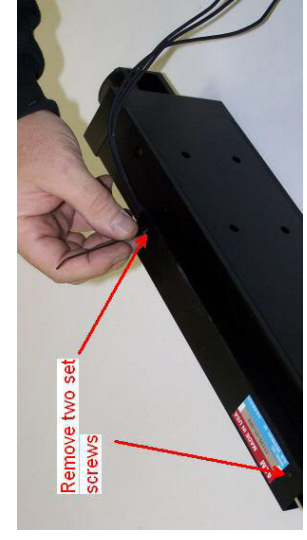
Identify Bottom Limit Switch

2



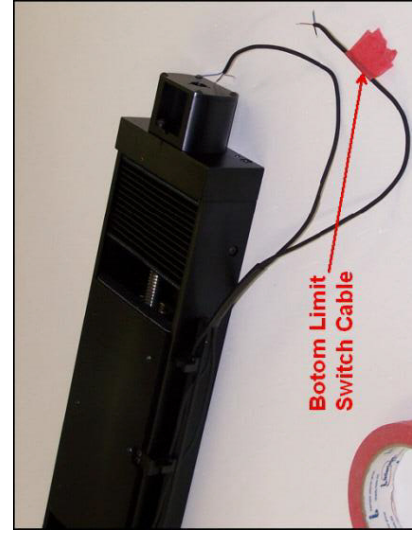
Strip Insulation exposing 3 wires

4



Remove Cover

6



Mark Cable

Standardized Work Sheet

Sequence

Part: 4412356 - Panel

Sheet: 2

Operation: Panel

Operation Cycle Time: 0

Version:

2

1

1

Approval Date:

3/12/2013

12/7/2012

12/7/2012

Approval By:

Admin

Admin

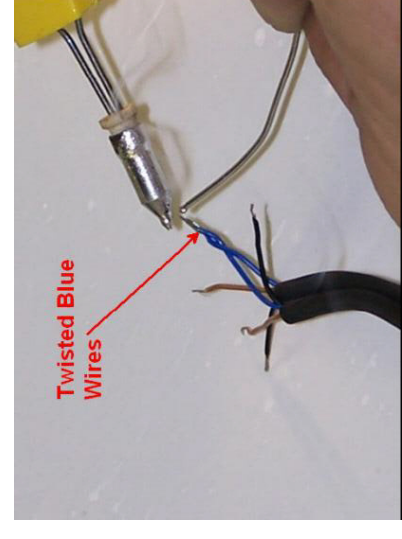
Admin

1

2

Figure(s)	Seq	Steps	Symbol	Value Time	Waste Time	Cumulative Time
1	5	Solder Wire Pairs	↗	0.00	0.00	0
2	6	Connector plug	↗	0.00	0.00	0
3	7	Crimp Pins - Needed to be ,....	↗	0.00	0.00	0
4	8	Solder wires	↗	0.00	0.00	0
5	9	Motor Mount Plate	↗	0.00	0.00	0

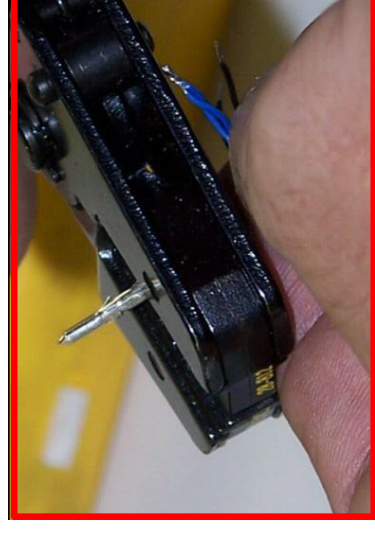
Icon:	STOP	↗	⚠	6σ	🌐	🌍	🔍	📈
Meaning:	Safety	Instruction	Alert	Quality	Environmental	Objective	Scope	Flow



Solder Twisted Blue Wires

Solder Twisted Blue Wires

3



Install Male Pins

Install Male Pins

5

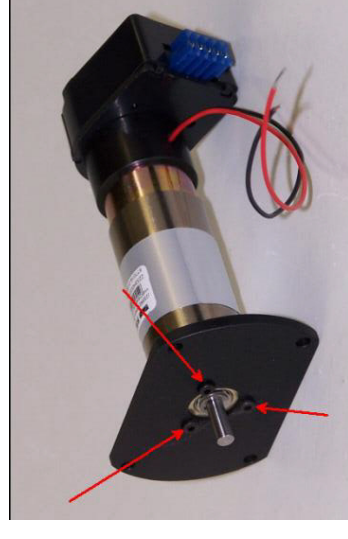
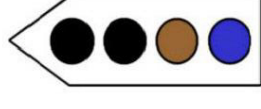


Plate Orientation

Plate Orientation



Black (bottom switch)

Black (top switch)

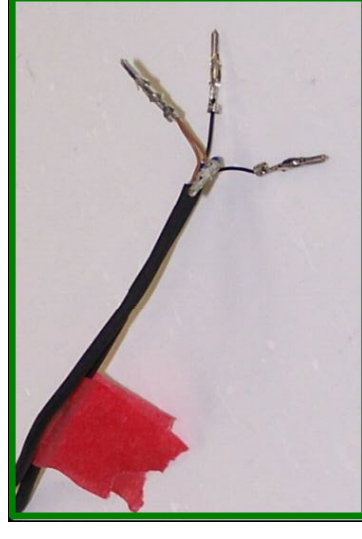
Brown

Blue

Molex

Molex

4



Installed crimp Pins

Installed crimp Pins