

# Standardized Work Instruction (SWI)

Revision Level: 1		Internal Part Number: Various		Program: KIA-MQ4A		Required Jobs per Hour: 56		Revision Date: 1/24/2024		Department Location: Rear Station 8 Prepared By: J. Williams		Production Manager: Steve Johnson Supervisor/Team Leader: Sidney Johnson	
		Customer Part Number: Various		Line: Rear Door Panel						Takt Time 64.0		Total Cycle Time	
#	Work Element Step	Hand	Auto	Walk	Notes/Details	Symbols							
1	Visually identify next in sequence door assembly located on wip rack and install to build fixture. (See picture 1)	2.0		3.0	Visually inspect door assembly A- surface for defects prior to install.	◆	<div>Process Flow</div> <div>Layout</div>						
2	Obtain door handle assembly from container, identify install location and insert to door assembly. (See pictures 2-3) (Listen for engagement sound)	4.0			Visually ensure locator pins and seating clips are properly seated. (Perform pull test afterwards to validate seated) (See picture 4)	◆							
3	Obtain window switch from container and utilize scanner to scan (2) main label bar codes, (2) Switch assembly bar codes, (1) map pocket bar code, (1) door trim bar code, and (1) handle assembly bar code.	6.0											
4	Obtain window switch assembly, locate the switch assembly attachment location on door assembly and insert to nest. (See pictures 5-7) (Listen for clips engagement sound)	2.0			Perform pull test on switch to validate all clips and assembly is properly seated.	◆	<div>1 Door Assembly Placement To Build Fixture</div> <div>2 Handle Assembly Installation</div> <div>3 Locator Pins/Clip Alignment</div> <div>4 Pull Test Seating Validation</div> <div>5 Window Switch Part #'s Y0104310 Y0096291</div> <div>6 Switch Assembly Attachment Locations Identification</div> <div>7 Torque Target (7.97) (Max 8.85/Min 4.78)</div> <div>8 (X4) Screws Attachment to Handle</div> <div>9 Chrome Script</div> <div>10 Weld Location</div> <div>11 Screw Install Location</div> <div>12 Substrate Locator Hole</div> <div>13 Label Attachment to Pre-Existing Label</div> <div>14 Pre-Existing Main Label</div> <div>15 Door Assembly Placement to WIP</div>						
5	Obtain torque tool and utilize to secure (4) screws to door handle assembly. (See picture 8-9) (Follow sequence shown in picture 9)	13.0			Visually validate all screws are properly seated to door assembly and not stripped out.	◆							
6	(Leather Option) Obtain (1) screw from container and identify install location. (See picture 10) (Install location is identified by red proximity lazer)	4.0			Install location should be located near the door handle assembly.								
7	(Leather Option) Utilize battery powered drill to secure screw to install location. (See picture 11) (Do not overtighten or strip screw, once seated a max of two revolutions)	3.0			Visually validate screw is completely seated to trim assembly.	◆							
8	(Leather Option) Visually validate chrome strip (A surface) is flush to trim assembly after screw attachment. (See picture 12)	4.0				◆							
9	Locate the lot traceability label on the HMI monitor and push to print out traceability label.	7.0											
10	Obtain lot traceability label, scan and insert on top of main door assembly label as exposed in picture 13-14.	7.0											
11	Remove assembly from fixture and place inside WIP cart. (See picture 15)	1.0		4.0									
Total		53.0	Wait	7.0			Quality Safety STD WIP Critical Characteristic				Approval Record		Date
		60.0											