

# [BR167] - [2nd Row] Standard Work Instructions

## 60% Cushion Trim to Foam

Rev Date: 15-Mar-23 REV.: 7 Line: Low Lock (L1) STATION NO.: L1-261-20

STEP NO.	STEP DESCRIPTION	TOOL	VISUAL AID
1	Evaluate pick list to determine foam variant, obtain from container and insert to fixture mold. (See picture 1)		
2	<b>(Heat Option)</b> Obtain heat pad from container, align to foam and remove tape backing attaching heat pad to foam following sequence exposed in pictures 2-3. (Visually validate no bulges, wrinkles, or other damages are present after placement)		
3	<b>Trim to Foam:</b> A) Evaluate pick list to determine trim variant, obtain from cart and align center hog ring listings to foam hog ring listings. (See picture 4) B) Obtain hog ring gun and attach (5) hog rings to trim listing and foam listing following sequence shown in pictures 4-5. (5 seater Option would only have 3 Hog rings) (Perform pull test to hog rings after attachment to validate properly attached) (1 hog ring per window) C) Obtain (2) listing wires and insert inside of two trim pouches. (One on the left and one on the right) (See picture 6-8)	Hog ring Gun	
4	<b>Trim to Foam</b> Obtain hog ring gun and hog ring left and right side trim listings to foam listing following sequence exposed in pictures 9-10. (Perform pull test to hog rings after attachment to validate properly attached) (1 hog ring per window)	Hog ring Gun	
5	<b>Trim To Foam</b> A) Obtain hogring gun and attach trim listing to foam listings following sequence exposed in pictures 9 and 11. B) Obtain (1) trim listing wire (small) and insert inside lower 20% trim pouch. (See pictures 12-13) C) Obtain hog ring gun and attach listing to foam listing following sequences exposed in pictures 9 and 14. (Perform pull test to hog rings after attachment to validate properly attached) (1 hog ring per window)	Hog ring Gun	
6	<b>Trim Roll to Foam</b> Align 20% trim seams to foam edge and initiate roll process starting from the right and moving counter-clockwise. (See pictures 15-16) (Visually validate seam alignment after roll process)		

7	Flip assembly over to back side and attach (2) velcro strips, (2) push pins, and 1 trim grommet to foam. (See picture 17) (Visually validate velcro alignment and push pin seating after attachment)		
8	Inspect the cushion sub-assembly for seam alignment, missing hog rings, finessed corners, cuts, scratches or any other unusual defects and move finished assembly to sequence cart. (See pictures 18-19)		
	RECYCLE TODAY FOR BETTER TOMORROW  REDUCE, REUSE, RECYCLE !		

SYMBOLOLOGY				AP QA	SELF INSPECTION	SAFETY INSTRUCTIONS	GENERAL INSTRUCTIONS
 <b>TUSCALOOSA PLANT I</b>	KEY PRODUCT CHARACTERISTIC	LGK-SC	FMVSS / SAFETY CRITICAL	ENG.	1. ENSURE ALL FASTENERS AND CONNECTORS ARE SECURE.	1. PROPER EPP REQ'D IN POSTED WORK AREAS.	1. KEEP WORK AREA CLEAN.
	SAFETY			Q.C.	2. ENSURE ALL POKAYOKES ARE OPERATIONAL WHERE APPLICABLE.	2. FOLLOW SAFETY PROCEDURES AS SPECIFIED.	2. FOLLOW STANDARD WORK INSTRUCTIONS.
	PPE			PROD	3. ENSURE ALL WITNESS MARKS ARE PRESENT AS APPLICABLE.	3. CLOSED TOE SHOES REQ'D AT ALL TIMES.	3. PERFORM OTHER DUTIES AS DIRECTED BY SUPERVISOR.
			KEY FIT AND FUNCTION CHARACTERISTIC				4. NOTIFY SUPERVISOR OF DEFECTS AS REQUIRED.