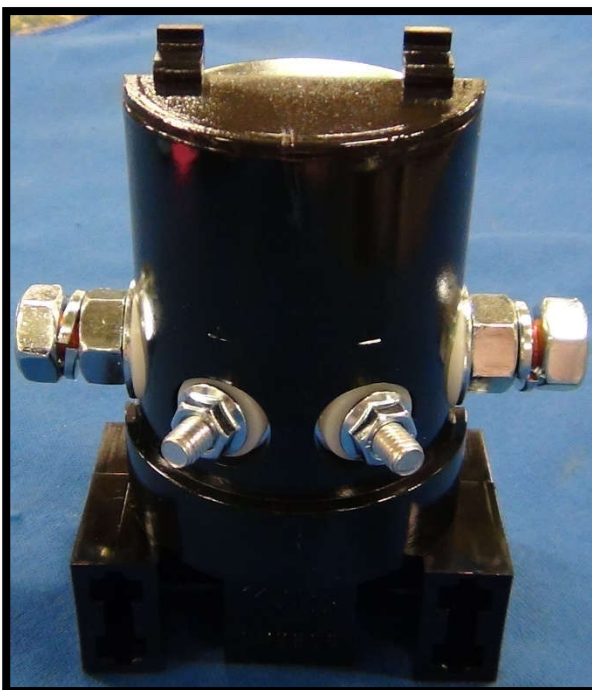
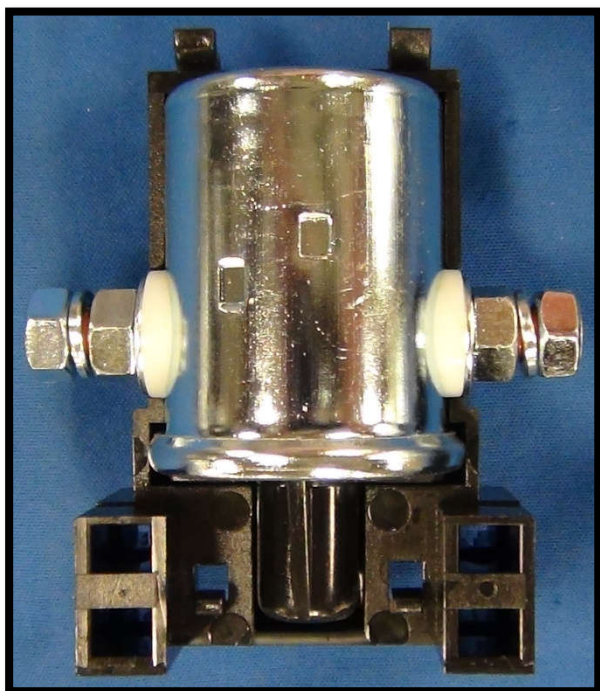


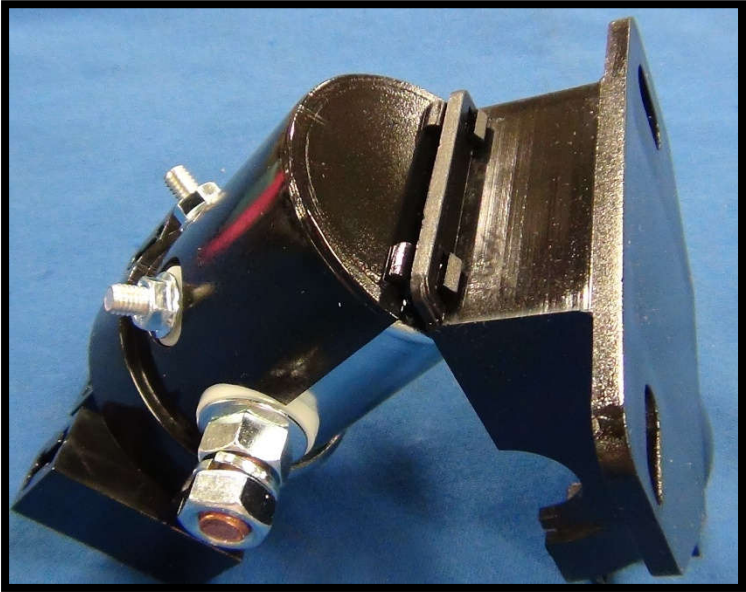
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- 1.0 Purpose:** The purpose of this Work Instruction is to provide a uniform and consistent Method of Manufacturing LR9806WB.
- 2.0 Scope:** This Work Instruction is applicable to all LR9806WB produced at KIB Electronics.
- 3.0 Responsibility:** This Document is owned and maintained by the Engineering Department. It is the Responsibility of the Group Leader and/or Production Supervisor of each Department to assure that this Instruction is followed by all Employees in that Department.
- 4.0 References/Documentation:**
 IPC-A-610 STANDARDS
 LR9806 DYNALAB TEST FIXTURE
 #1 & #2 IMPACT WRENCHES
- 5.0 Assemble PCB:**
- 5.0.1 PLACE THE RELAY (**REL26774**) INSIDE THE HALF OF THE PLASTIC HOUSING WITH THE HOLES AS SHOWN.



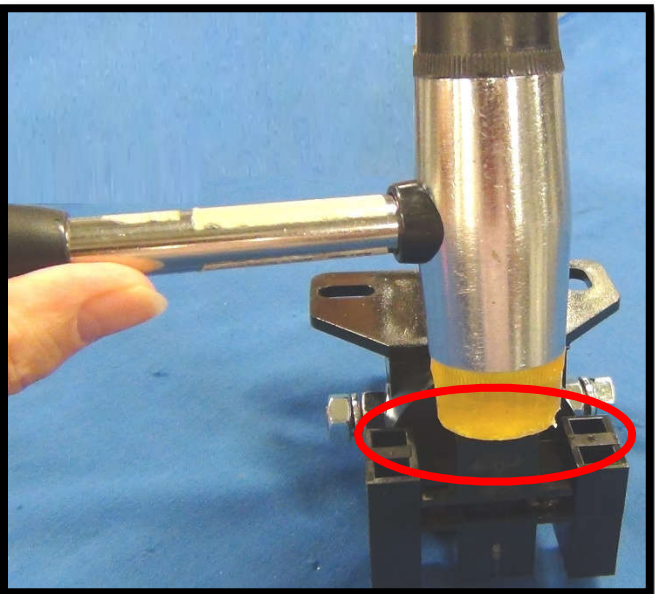
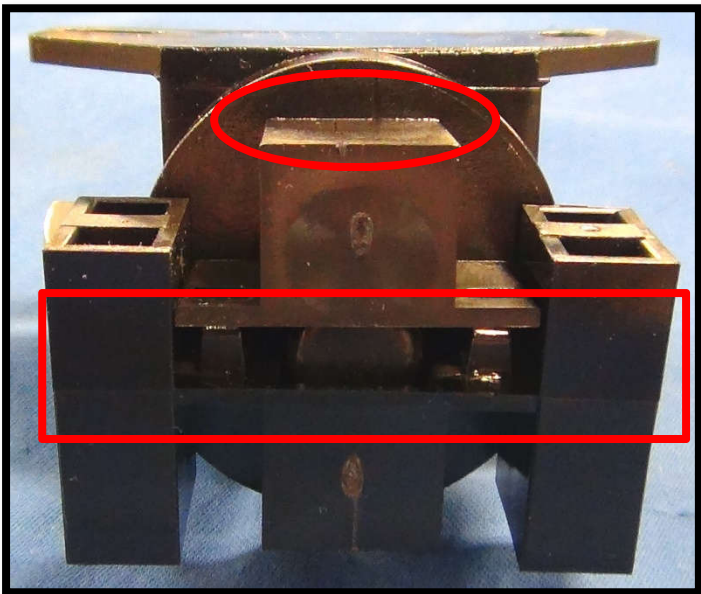
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5.0.2 ATTACH THE OTHER HALF OF THE HOUSING AS SHOWN.



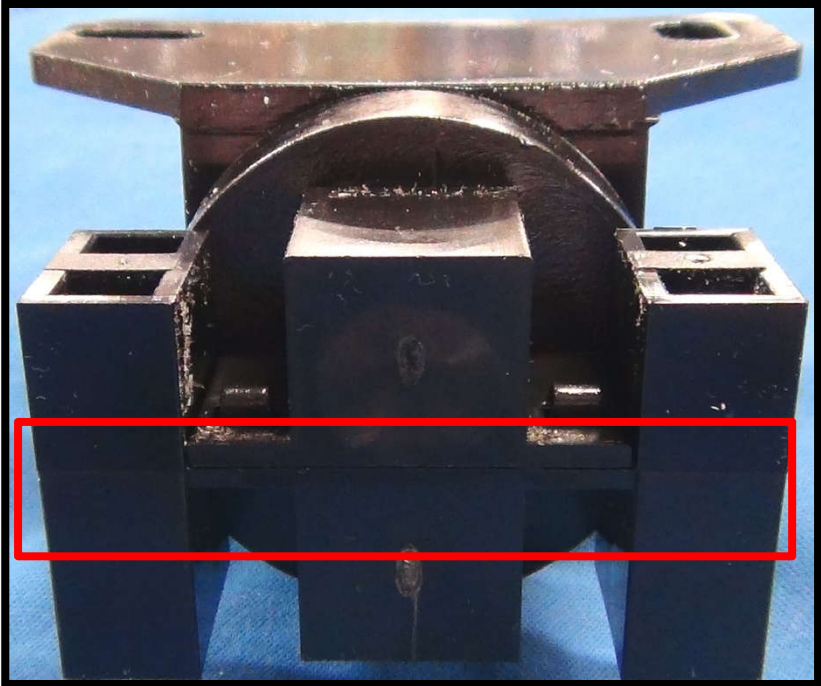
5.0.3 BY HAND CLOSE THE HOUSING AROUND THE RELAY AS MUCH AS POSSIBLE. THERE WILL STILL BE A GAP BETWEEN THE HALVES.

5.0.4 USING A RUBBER Mallet TAP THE AREA CIRCLED TO CLOSE THE HOUSING AND REMOVE THE GAP.



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5.0.5 VISUALLY VERIFY THAT THE GAP IS COMPLETELY CLOSED.



5.0.6 REMOVE THE (2) NUTS & (2) WASHERS FROM THE LARGE BOLTS AND PLACE INTO CONTAINERS TO USE LATER.

5.0.7 PLACE THE LABEL (**LABBDWL100**) ON THE FRONT OF THE HOUSING AS SHOWN.



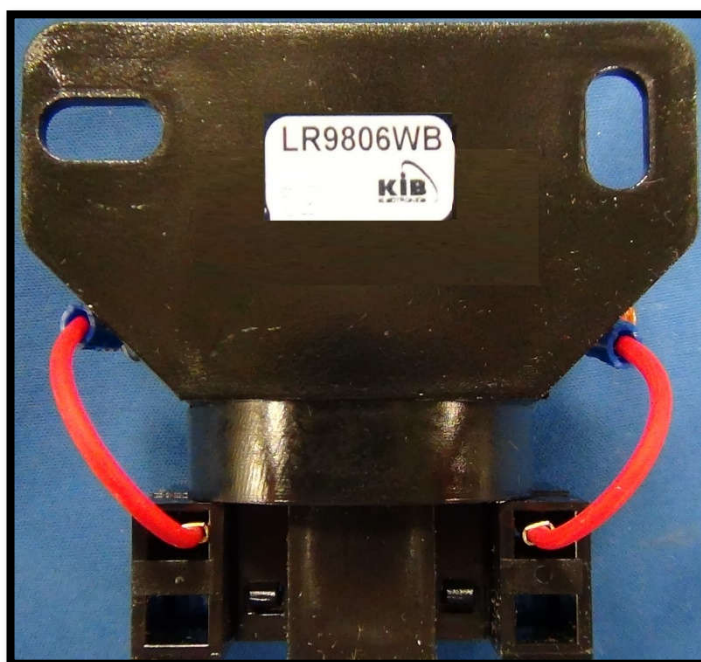
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5.0.8 PLACE AN IDENTIFICATION LABEL ON THE BACK OF THE HOUSING AS SHOWN.

5.0.9 PLACE A (**5 AMP**) FUSE LABEL ON BOTH SIDES OF THE HOUSING AS SHOWN.

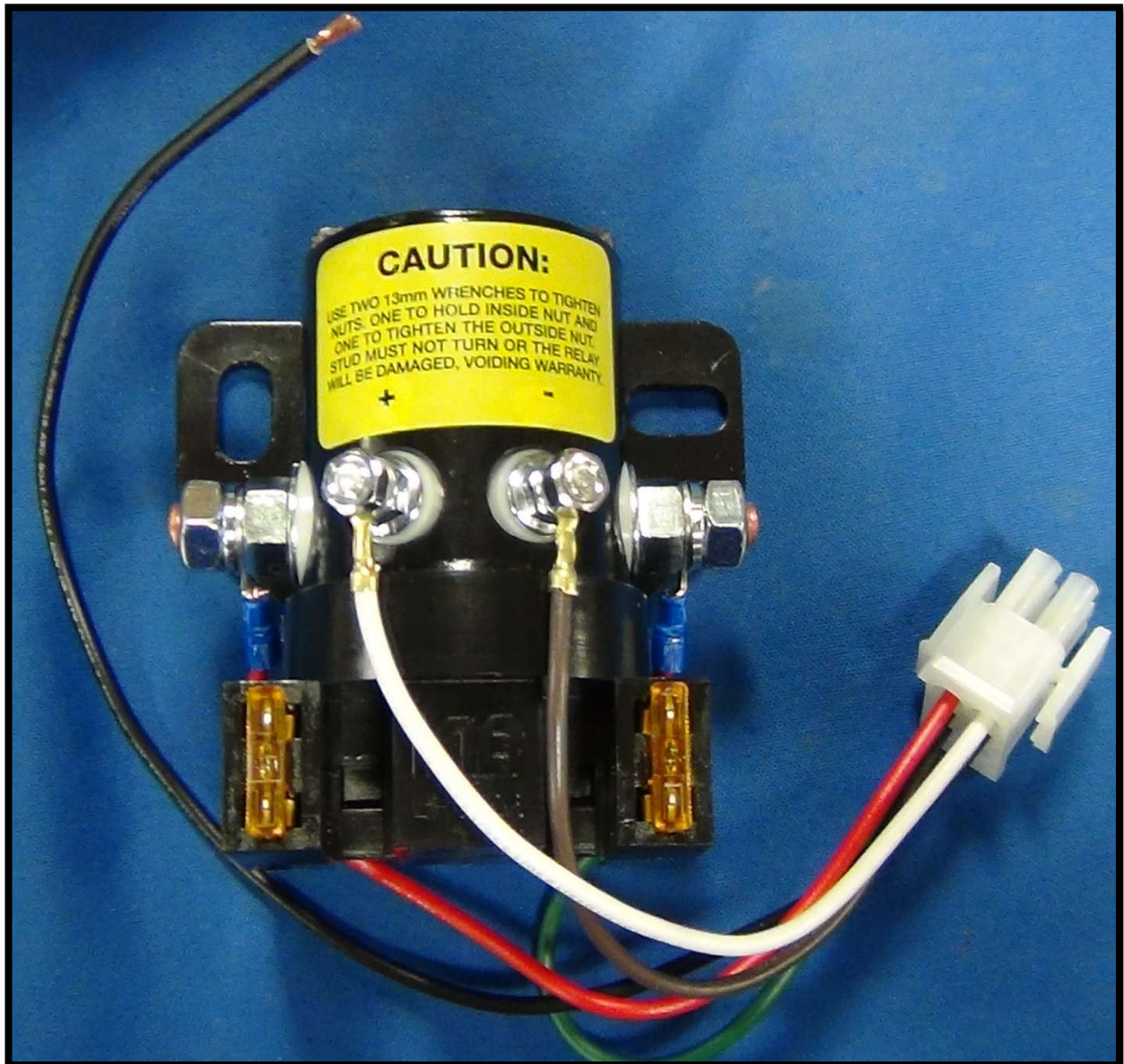


5.0.10 INSERT THE (2) WIRE HARNESSES (**400-000042**) INTO THE TOP (2) OPENINGS IN THE BACK OF THE HOUSING AS SHOWN. BE SURE THEY ARE SECURELY INSERTED.



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- 5.0.11 PLACE THE RING TERMINAL ON THE (**WHITE**) WIRE COMING FROM THE HARNESS (**WHLR9806WB**) ON THE SMALL BOLT ON THE LEFT FRONT OF THE RELAY. ADD (1) SMALL WASHER & (1) SMALL NUT AND TIGHTEN USING #1 IMPACT WRENCH.
- 5.0.12 PLACE THE RING TERMINAL ON THE (**BROWN**) WIRE COMING FROM THE HARNESS (**WHLR9806WB**) ON THE SMALL BOLT ON

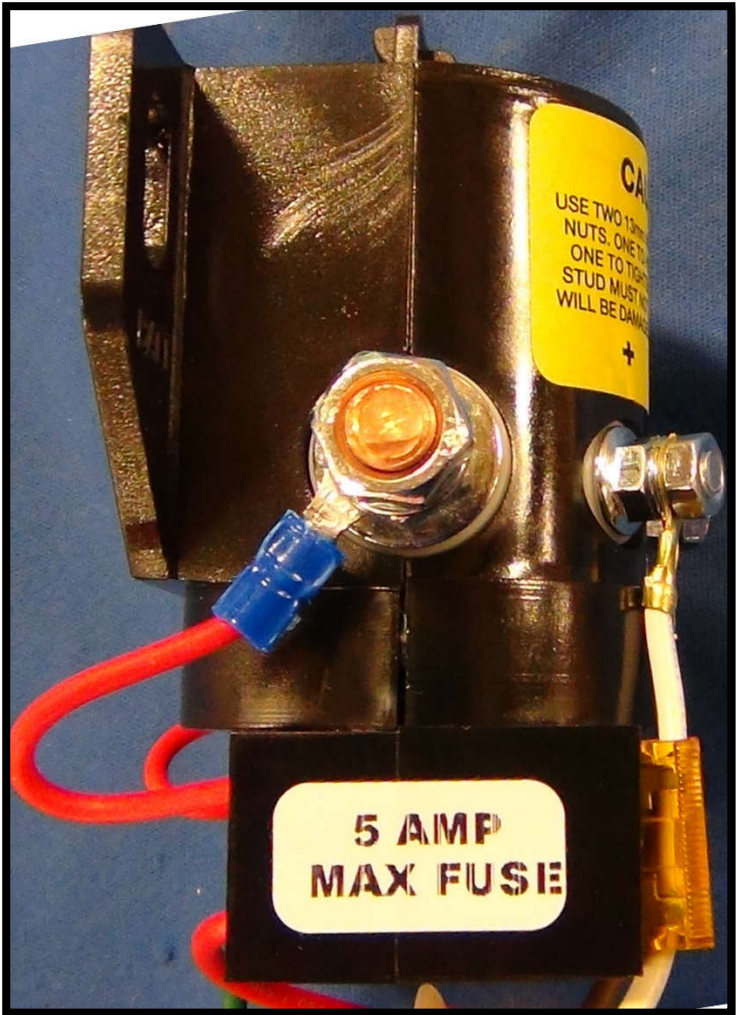
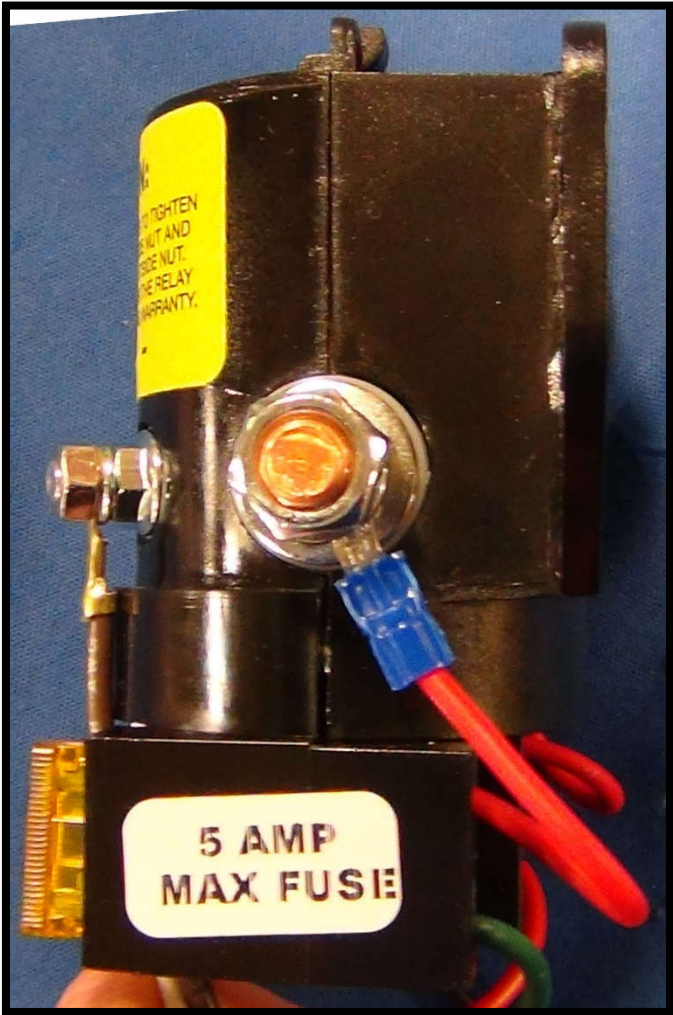


THE RIGHT FRONT OF THE RELAY. ADD (1) SMALL WASHER & (1) SMALL NUT AND TIGHTEN USING #1 IMPACT WRENCH.



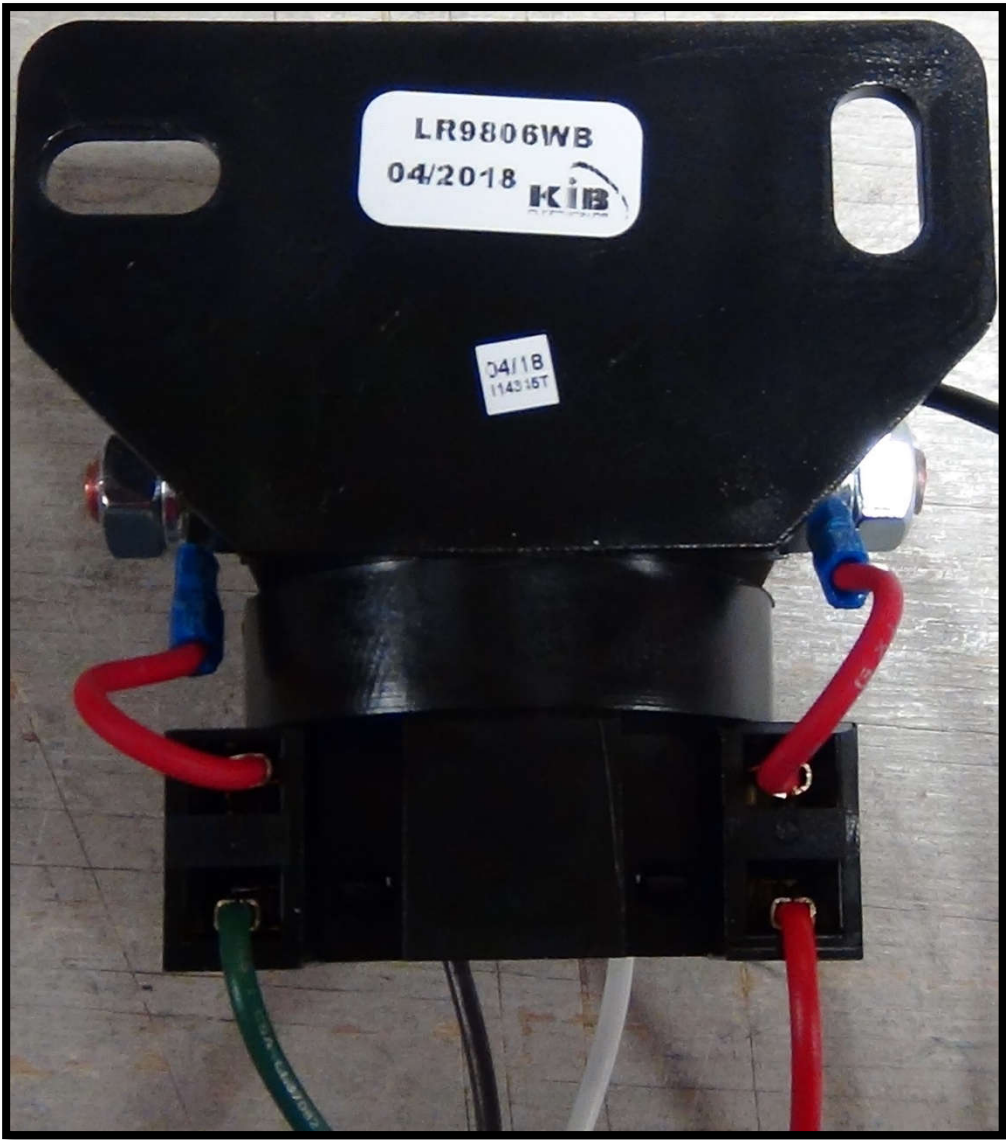
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5.0.13 PLACE THE TERMINAL RINGS ON THE ENDS OF THE WIRE HARNESSES (400-000042) ON THE LARGE BOLTS ON BOTH SIDES OF THE HOUSING. PLACE (1) LARGE WASHER AND (1) LARGE NUT BACK ON EACH BOLT. TIGHTEN USING THE #2 IMPACT WRENCH.



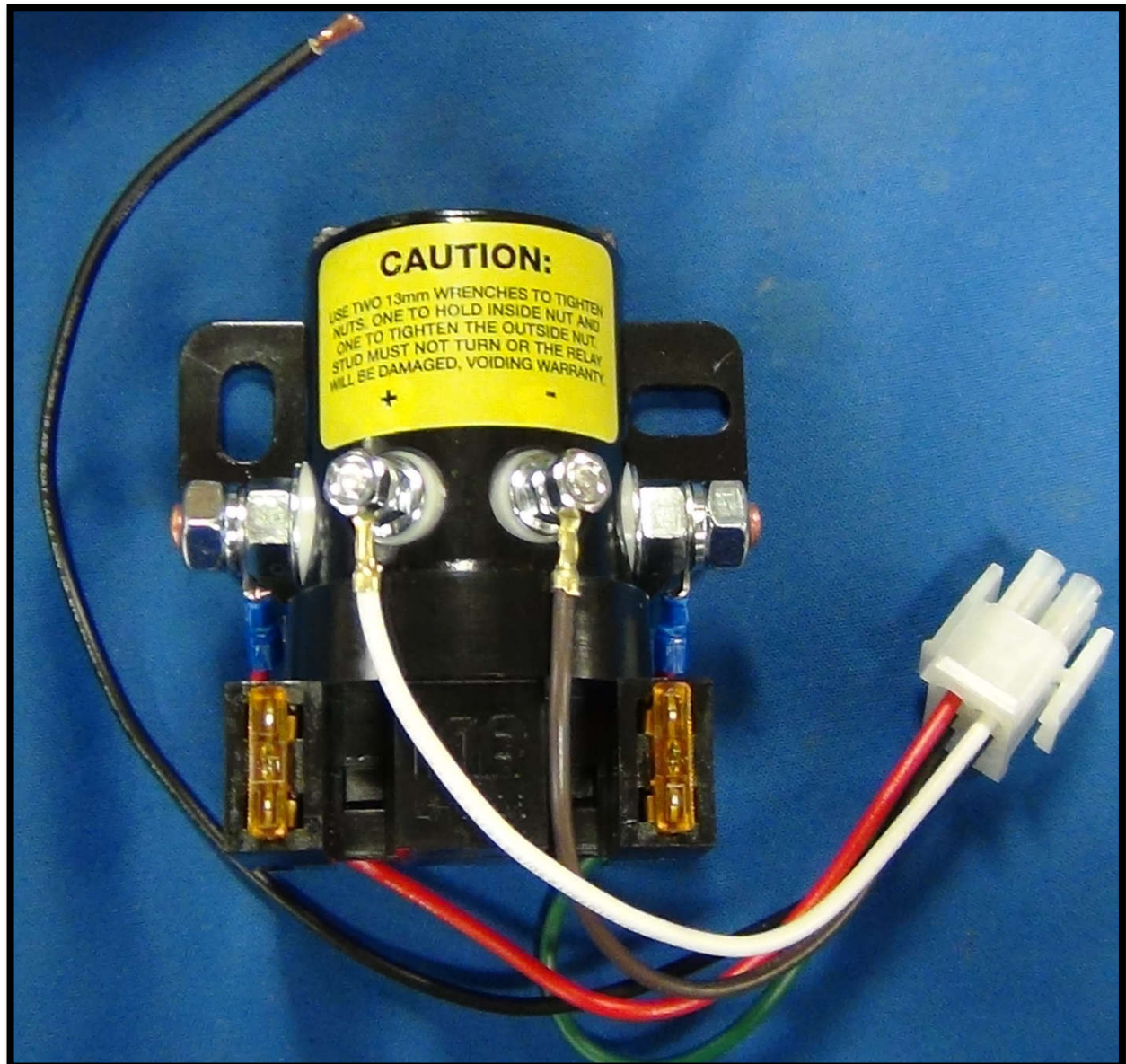
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- 5.0.14 INSERT THE GREEN WIRE OF HARNESS (**WHLR9806WB**) INTO THE BOTTOM LEFT OPENING IN THE BACK OF THE HOUSING AS SHOWN. BE SURE THE WIRE IS SECURELY INSERTED.
- 5.0.15 INSERT THE RED WIRE OF HARNESS (**WHLR9806WB**) INTO THE BOTTOM RIGHT OPENING IN THE BACK OF THE HOUSING AS SHOWN. BE SURE THE WIRE IS SECURELY INSERTED.



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5.0.16 INSERT (2) FUSES (**FATC5A**), ONE ON EACH SIDE AS SHOWN. BE SURE THEY ARE INSERTED AS FAR AS POSSIBLE.



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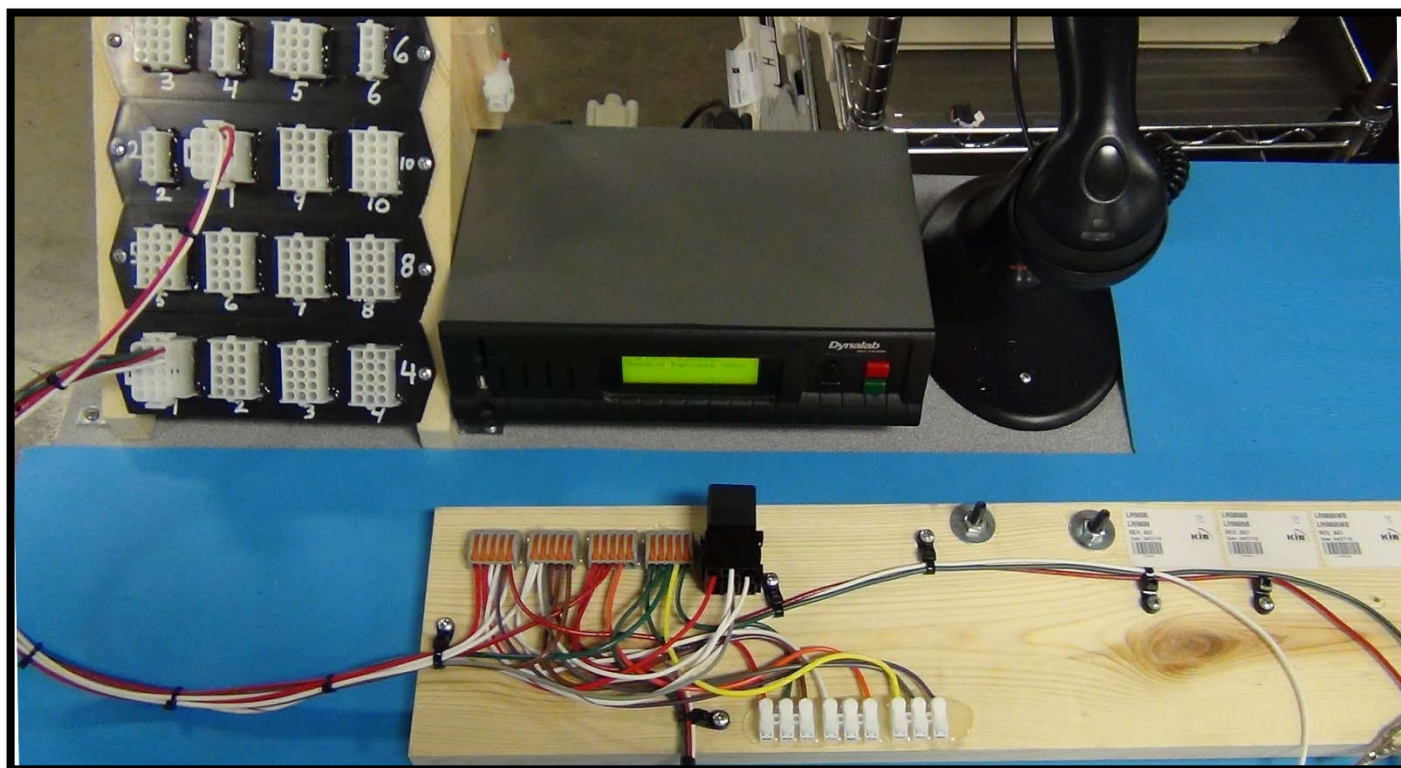
6.0 PCB Testing:

Equipment Required:

DYNALAB TESTER

LR9806 TEST HARNESS WITH BAR CODE

6.0.1 CONNECT THE LR9806 TEST HARNESS TO THE DYNALAB TESTER USING THE (2) CONNECTORS AS SHOWN IN THE PICTURE.



6.0.2 PRESS THE RED BUTTON ON TESTER.

6.0.3 SCAN THIS BAR CODE ON THE TEST HARNESS BOARD.

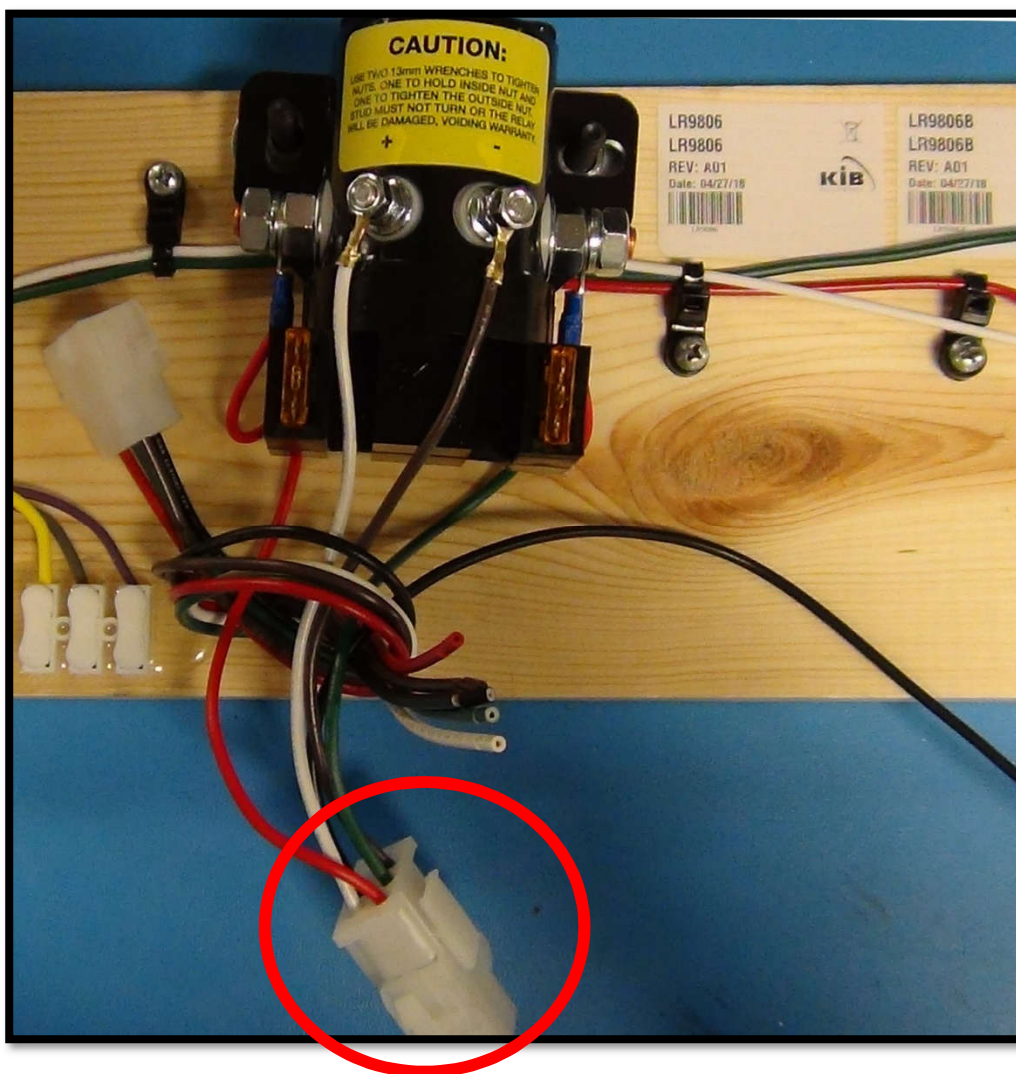


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- 6.0.4 PRESS THE RED BUTTON ON TESTER AGAIN.
 6.0.5 THE DISPLAY SHOULD LOOK LIKE THE PICTURE.



- 6.0.6 PLACE THE PART ON THE FIXTURE AND CONNECT THE CONNECTOR FROM THE **LR9806WB** TO BE TESTED TO THE CONNECTOR ON THE TEST FIXTURE AS SHOWN.



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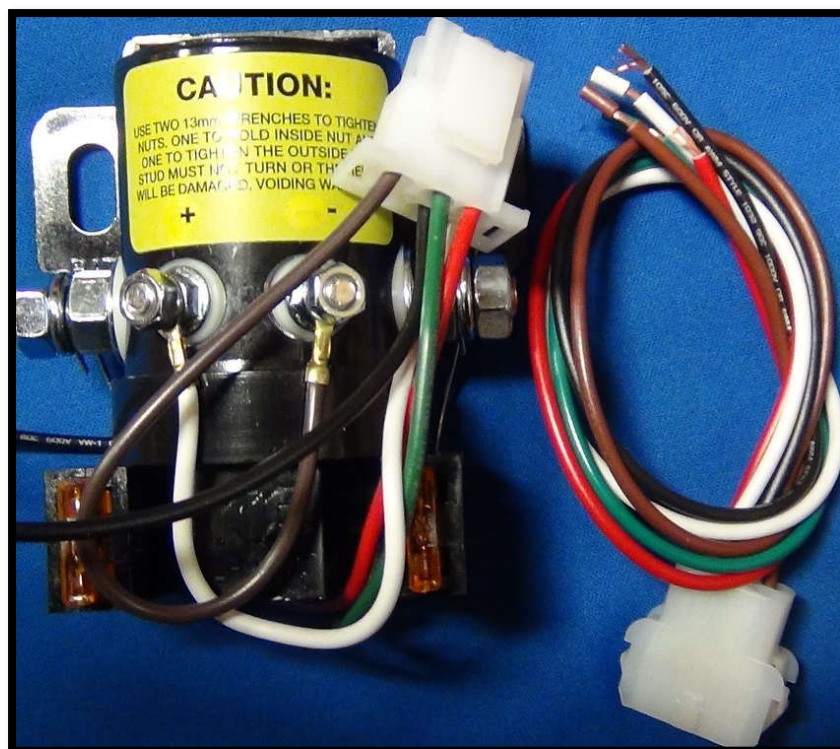
- 6.0.7 PRESS THE GREEN BUTTON ON THE TESTER AND THE TEST WILL RUN. CHECK THE DISPLAY ON THE DYNALAB TESTER, THE DISPLAY SHOULD LOOK LIKE THE PICTURE.



- 6.0.8 IF THE BOARD PASSES DISCONNECT THE BOARD AND PLACE A TESTED LABEL ON EACH BOARD IN AN OPEN AREA.
 6.0.9 IF THE BOARD FAILS SET ASIDE FOR REPAIR.

7.0 PCB – Bag & Pack:

- 7.0.1 PLACE THE WIRE HARNESS (**WHLR12PIG**) WITH THE TESTED PART, NEATLY WRAP THE WIRES AND PLACE THE PART AND THE HARNESS IN A (PK4X12P) STATIC SAFE BAG AND TUCK THE END IN.
 7.0.2 PLACE 15 PARTS IN A (MOTION TECHNOLOGY) BOX AS SHOWN IN THE PICTURE
 7.0.3 TAKE THE BOARDS TO THE SHIPPING DEPARTMENT.



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Revision Record:

<u>Revision</u>	<u>By</u>	<u>Date</u>	<u>Description of Change</u>
rB01	Cindy DeLong	04/25/17	Original
rB01	Cindy DeLong	10/03/17	UPDATE PICTURES AND TEXT
rB01	Cindy DeLong	05/09/18	CHANGE TESTING TO DYNALAB TESTING