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10. YOKOTEN

Quality Circle

Kami Kaze Team

Theme : Preventing Annoyance Defects

Activity Base: SEWS-EG (6th October)



Members:

Ahmed Alaa (Shift Leader)
Abdullah Maher (Quality Engineer)
Basem Abdel Monem (Test Engineer)
Ahmed Helmy (Test Technician)

2023



Site Introduction:



TOYOTA

STELLANTIS

Our Site:



SE Wiring Systems – EGYPT (Cairo Site) SEWS Europe Division



**TMMT – Turkey
(Adapazari)**



**CHR
Harness**



**TMMCZ – Czech Republic
(Kolin)**



**Yaris
Harness**



**TMMF – France
(Onnaing)**



**Yaris/Yaris Cross
Harness**

Customer Introduction:



**CITROËN – Slovakia
(TRNAVA)**



**CITROËN
Harness**



**Opel– Hungary
(Szentgotthárd)**



**OPEL
Harness**



**Opel– Poland
(TYCHY)**



**OPEL
Harness**

What we do

Reception



Lead Prep. Area



Lead Store



Assembly Process



Shipping Process



Our Idea
Implementation

Who we are





Soldier Name: **Abdullah Maher**

SEWS-EG position: **Quality Engineer**

Task: **Plan for the mission**

First Time In QC



Sergeant Name: **Ahmed Alaa (QC Leader)**

SEWS-EG position: **Shift Leader**

Task: **Act for the mission**

First Time In QC



Soldier Name: Bassem Abd-ElMonem

SEWS-EG position: Test Engineer

Task: Check for the mission

First Time In QC



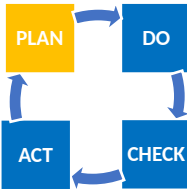
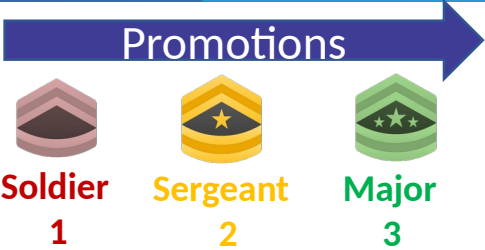
Soldier Name: Ahmed Helmy

SEWS-EG position: Test Technician

Task: Do for the mission

First Time In QC

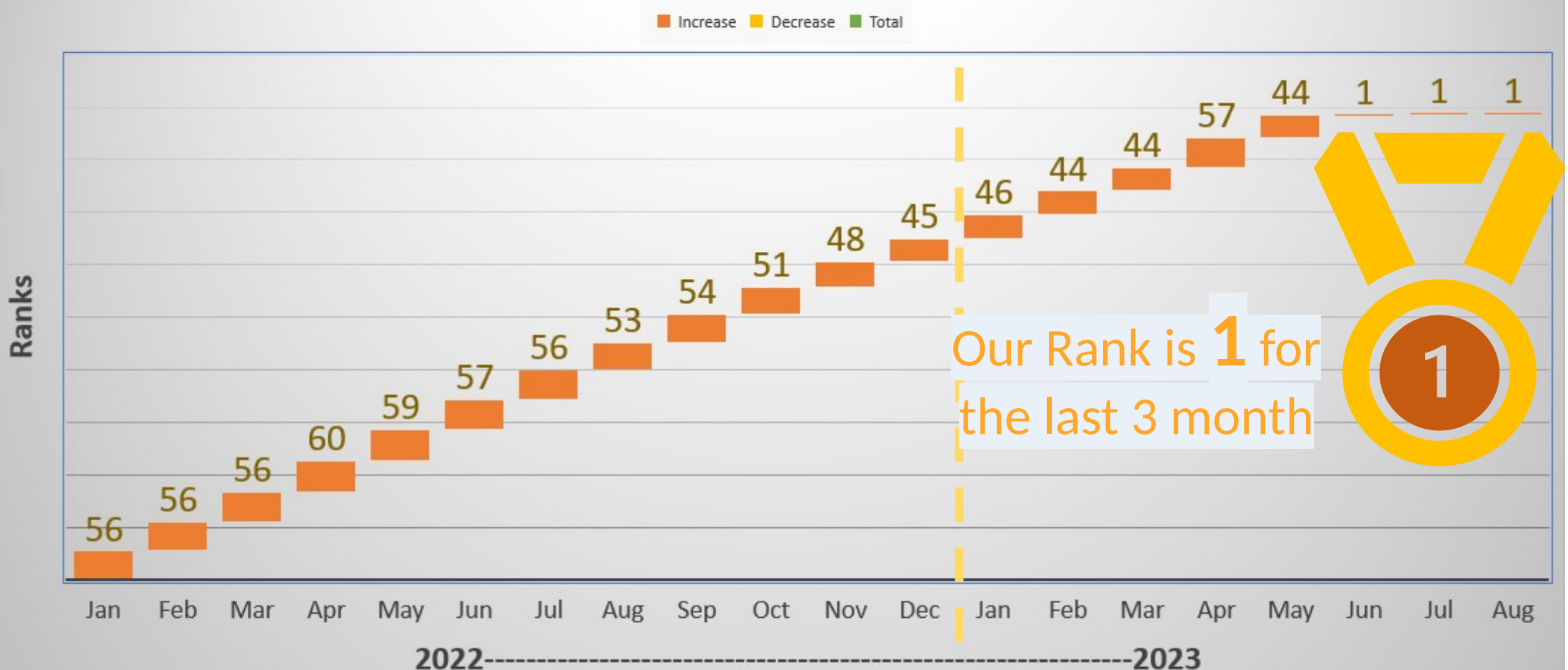
Skill Matrix Before

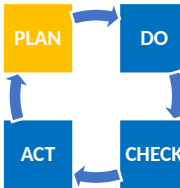


Categories	Communication	Organization	Teamwork	Trouble shooting	QC tools	Total
 Helmy						53%
 Alaa						67%
 Bassem						67%
 Abdullah						67%

From June till now we earn the **1st** rank

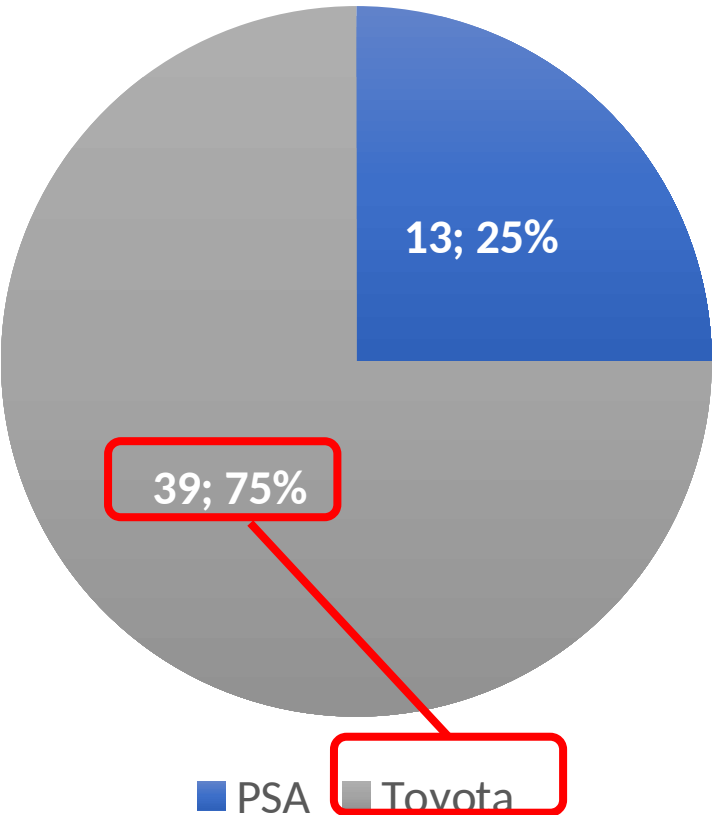
SWS Group Quality Ranking Table (61 Sites)





The graphs shows analysis for concerns 2022/2023

Official concerns per customer



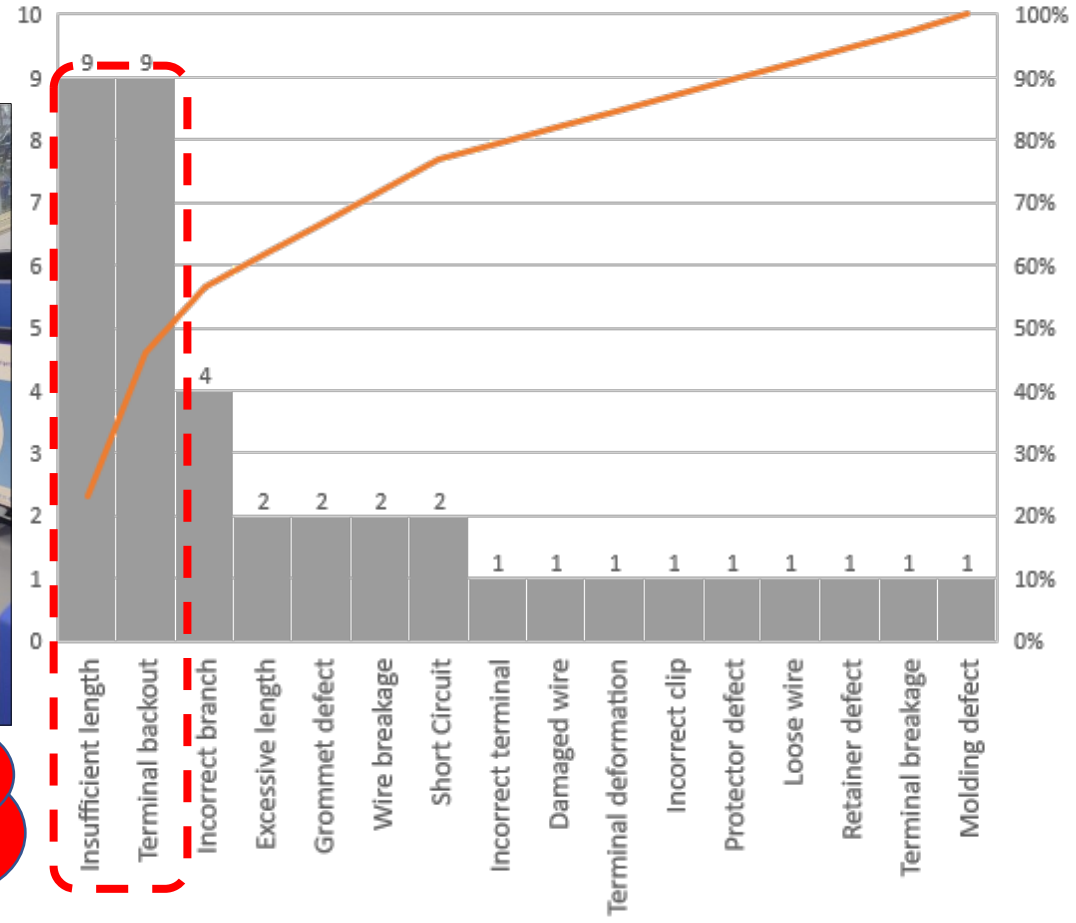
39 Concerns related to TOYOTA

What!!
9 claims related to insufficient lengths



Wait a second!!
There is more 9 claims related to Anti-back

TOYOTA official concerns per type



Theme selection:

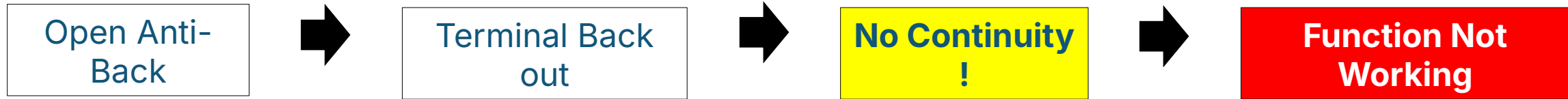
Scoring chart



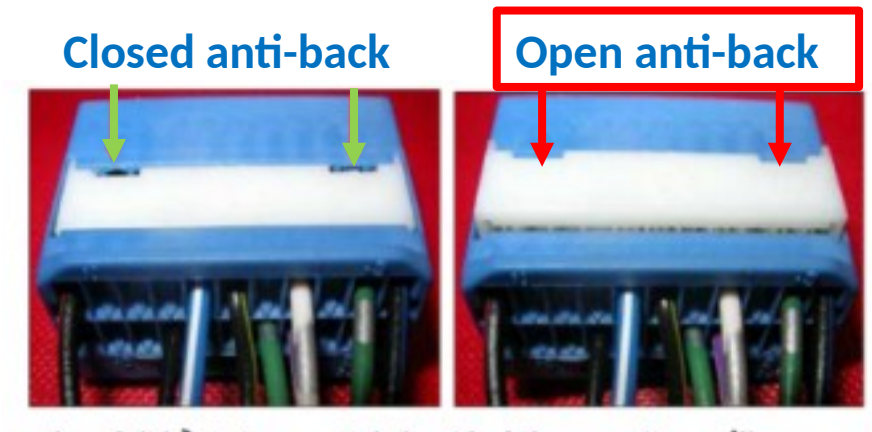
	Priority			Repeat	Expected effect	Points of evaluation
	Severity	Detection	Cost			
Terminal backout	3	2	2	3	3	13
Insufficient length	2	2	1	3	2	10
Short Circuit	3	2	1	1	3	10
Incorrect branch	2	1	2	2	2	9
Wire breakage	3	2	2	1	1	9
Damaged wire	3	2	2	1	1	9
Excessive length	2	1	2	1	1	7
Grommet defect	2	1	1	1	1	6

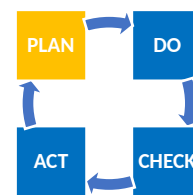
Legend:
 3 = High
 2 = Middle
 1 = Low

Theme Selection : Severity

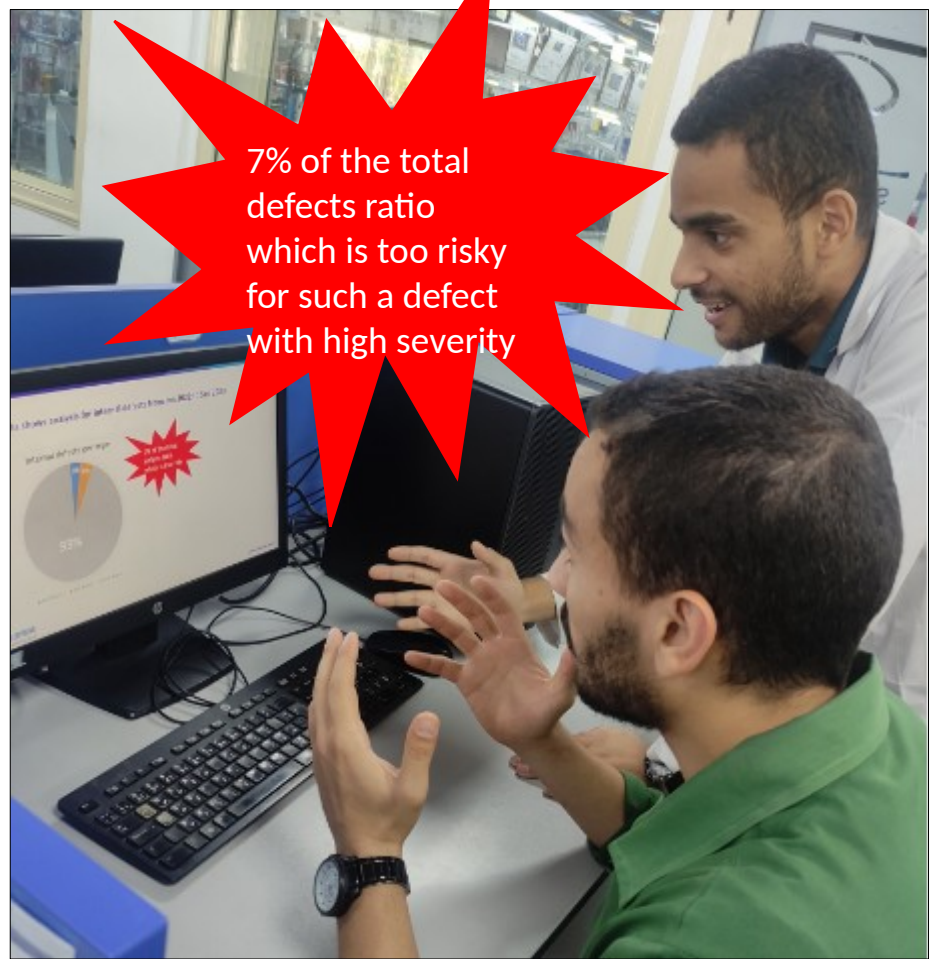
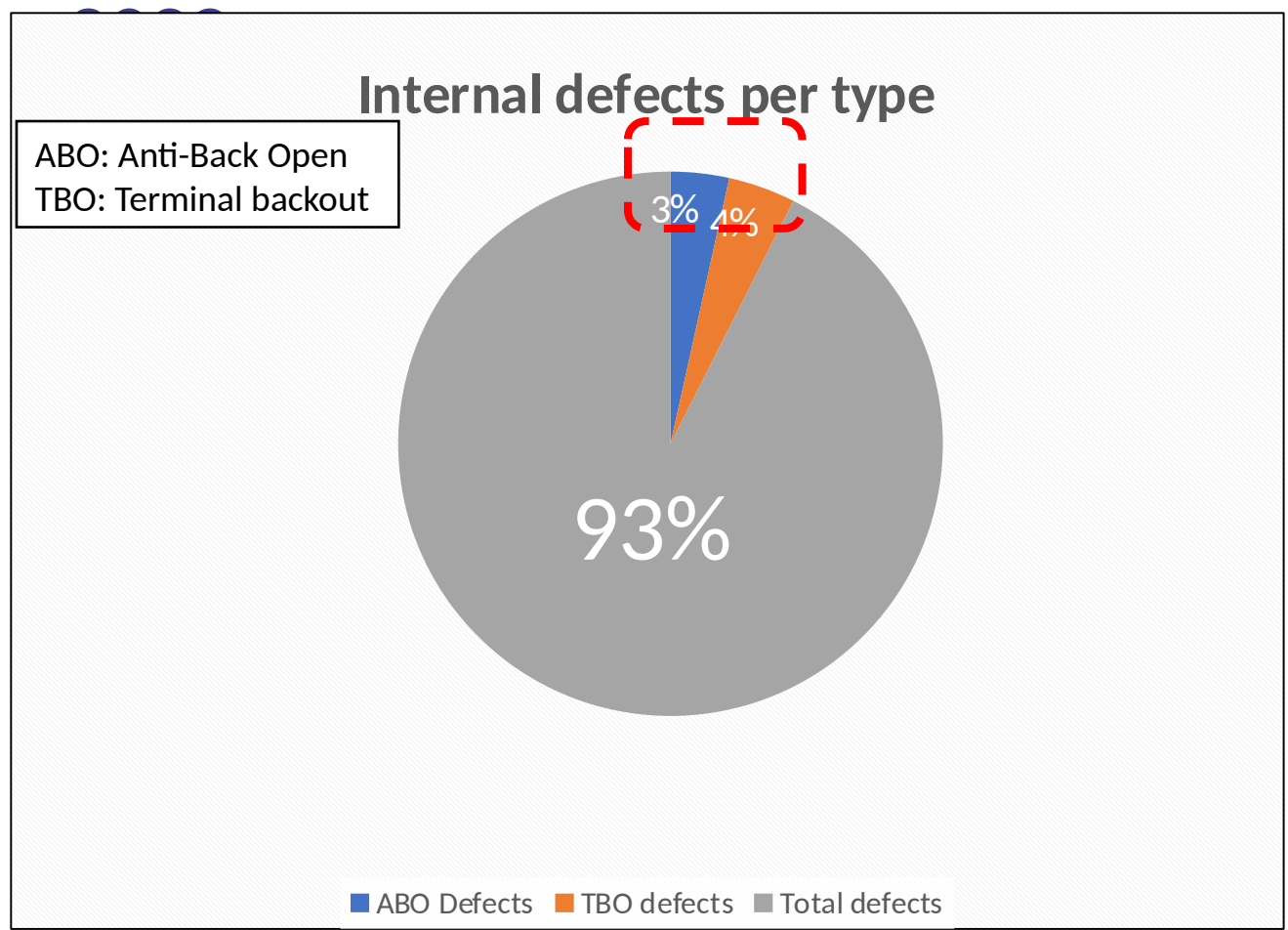


- Hard to be detected on electric test board !
- Hard to be detected at customer continuity test !
- Annoyance for the customer





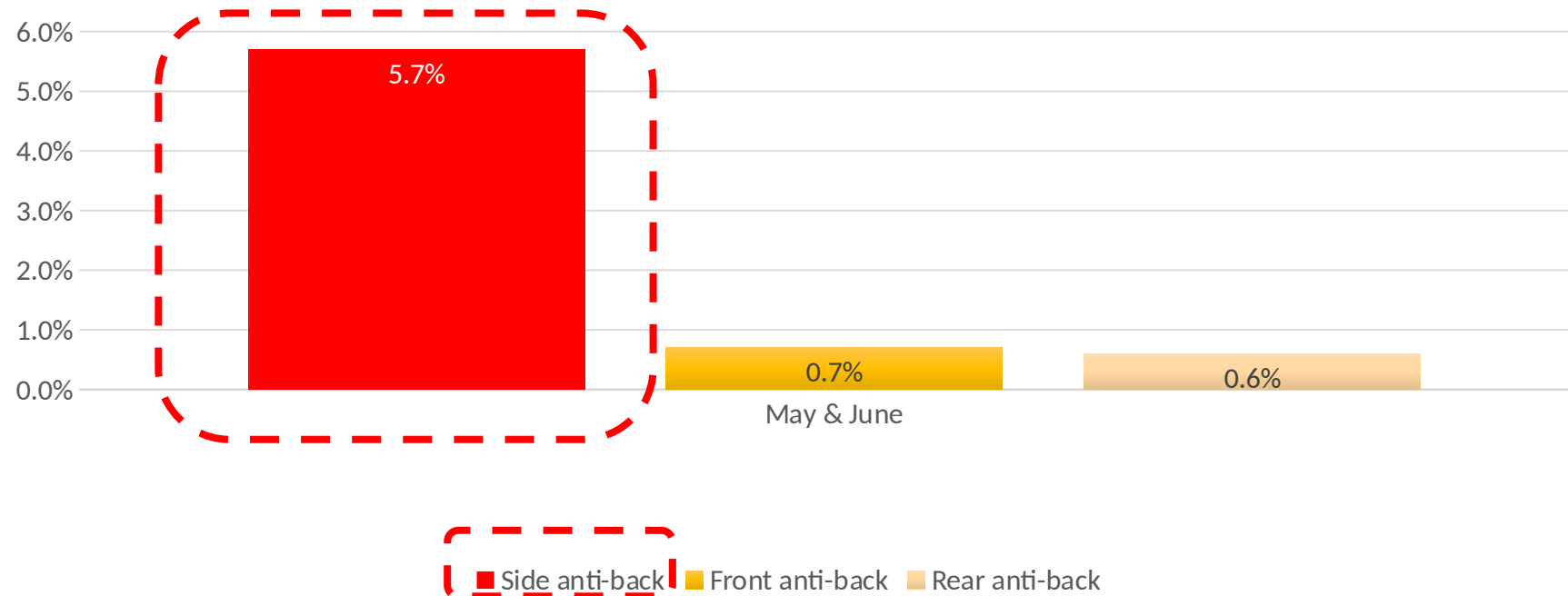
The graphs shows analysis for internal defects for May & June



Conclusion: 7% from total internal defects and 9 official concerns related to anti-back



Defect per anti-back type for May and June



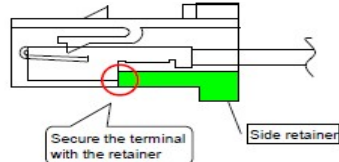
We mainly have a problem with the connectors with side anti-back

Theme Selection: Problem Definition

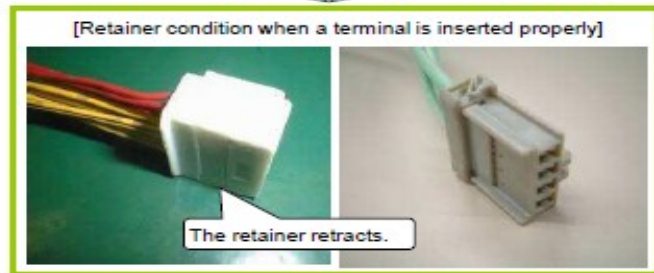
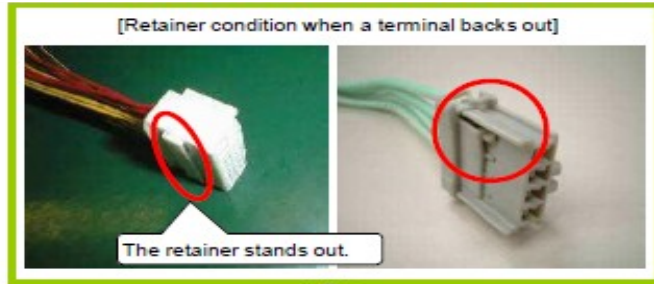
Types Of The Connector's Anti-Back:

(1) Side anti-back Type

- The anti-back is set on the **Side** of the connector.
- Main Type for the non-waterproof connector.

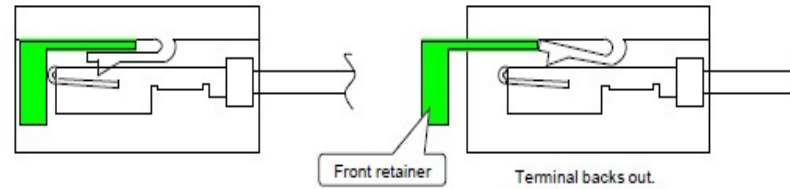


[Function for checking terminal back-out]
If any terminal is not inserted completely, the retainer cannot be set correctly (retainer protrudes from connector surface) when pressing it, and operators can notice terminal back-out.



(2) Front anti-back type

- The anti-back is set on the **front** of the connector.
- Main type for the waterproof connector.



- Because both the connector and retainer are made of resin, the retainer is not inserted even if the terminal backs out when the retainer is pushed in forcibly. **Interference**
- Never have too much confidence in the connector configuration.

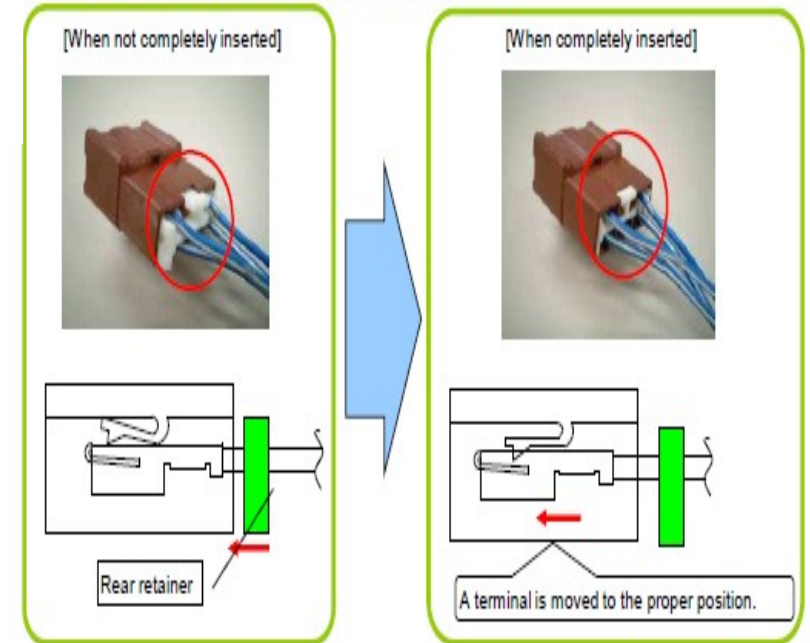


(3) Rear anti-back type

- The anti-back is set on the **rear** of the connector.

[Function for checking terminal back-out]

If any terminals are not inserted completely, the retainer automatically inserts them to the normal position. Or if they cannot be set correctly (the retainer protrudes from the connector surface) when passed, the operator will be able to notice the terminal back-out.

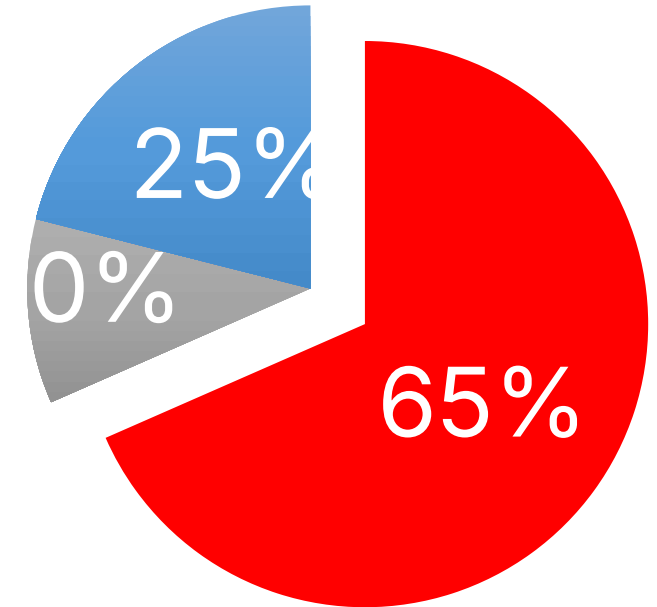


With reference to central test training material

C



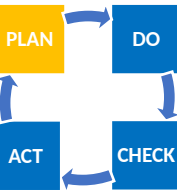
 DE Writing Egypt 2025 Assessment of Academic English Proficiency	 DE Writing Egypt 2025 Assessment of Academic English Proficiency
Survey № ٩٤٣٩ Name: <u>محمد حامد</u> Station: <u>PB(50)</u>	Survey № ١١٤٤٢ Name: <u>سارة محمد</u> Station: <u>PB(60)</u>
Subject Open Attch back ما هي أكثر مشكلة تواجهك أثناء العمل ؟ صعوبة نقل طلباتك إلى الكمبيوتر ما هي مصادقات العمل بأدوية الله ؟ عدم حل مشكلة بسرعة وهذا يوقف العملية الإنتاجية ما توجد صعوبة في انقل العمل اليومية ؟ تغير توجيه مشكلة بسبب كثرة الاخطاء والمؤثرات إلى اخطاء ما اوجه الصعوبات التي تعيق العمل اليومية ؟ تغير الجدول الزمني فانه لم يتكيف الفكرة في وقتها فكلما تغير جدول العمل فكلما تغيرت الفكرة في وقتها فكلما تغير الجدول الزمني فانه لم يتكيف الفكرة في وقتها فكلما تغير اوقات العمل وانما العمل في وقتها فكلما	Subject أشياء باله مفتوح ما أكثر مشكلة تواجهك أثناء العمل ؟ تغير اتجاه العمل أثناء العمل ما هي مصادقات العمل بأدوية الله ؟ تغير الوقت وزيادة العمل ما توجد صعوبة في انقل العمل اليومية ؟ تغير توجيه مشكلة بسبب كثرة الاخطاء والمؤثرات إلى اخطاء ما اوجه الصعوبات التي تعيق العمل اليومية ؟ تغير الجدول الزمني فانه لم يتكيف الفكرة في وقتها فكلما تغير الجدول الزمني فانه لم يتكيف الفكرة في وقتها فكلما تغير الجدول الزمني فانه لم يتكيف الفكرة في وقتها فكلما تغير اوقات العمل وانما العمل في وقتها فكلما
 Trainer Name: <u>Ahmed Elmaghrabi</u>	 Trainer Name: <u>Ahmed Elmaghrabi</u>

[illegible]

- Misjudgment for the instructions for different types of anti back
- Electric Board is regularly passing Open Anti back !
It's hard to Close the Anti Back.

Survey: Mentors

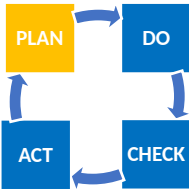
We received advice from different experienced directors for the area



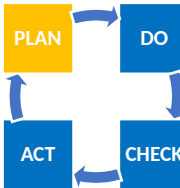


Brainstorming:
We tried to find a solution for our issue

Timeline for our mission



Plan	May				June				July				August				September			
	WK 19	WK 20	WK 21	WK 22	WK 23	WK 24	WK 25	WK 26	WK 27	WK 28	WK 29	WK 30	WK 31	WK 32	WK 33	WK 34	WK 35	WK 36	WK 37	WK 38
Activity Planning	Plan	Plan												Holiday						
	Done	Done																		
Theme Selection			Plan	Plan																
			Done	Done																
Problem Define					Plan	Plan														
					Done	Done														
Current Situation investigation							Plan	Plan												
							Done	Done												
Root Cause Identification									Plan	Plan	Plan	Plan	Plan							
									Done	Done	Done	Done	Done							
Countermeasure Development											Plan	Plan	Plan							
											Done	Done	Done							
Countermeasure Implementation														Holiday	Plan	Plan	Plan			
															Done	Done	Done			
Confirm Effectiveness															Plan	Plan	Plan			
															Done	Done	Done			
Countermeasure Validation																		Plan	Plan	
																		Done	Done	
Control Establishment										Plan				Ongoing		Late			Plan	
										Done								Done	Done	



We have planned our goals based on SMART objectives



Specific

Measurable

Achievable

Relevant

Time Bound

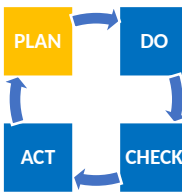
Target is **decreasing**
Anti-back defects

0 Customer concerns
95% decrease in ABO
and semi-ABO internal
defects
70% decrease in TBO
internal defects

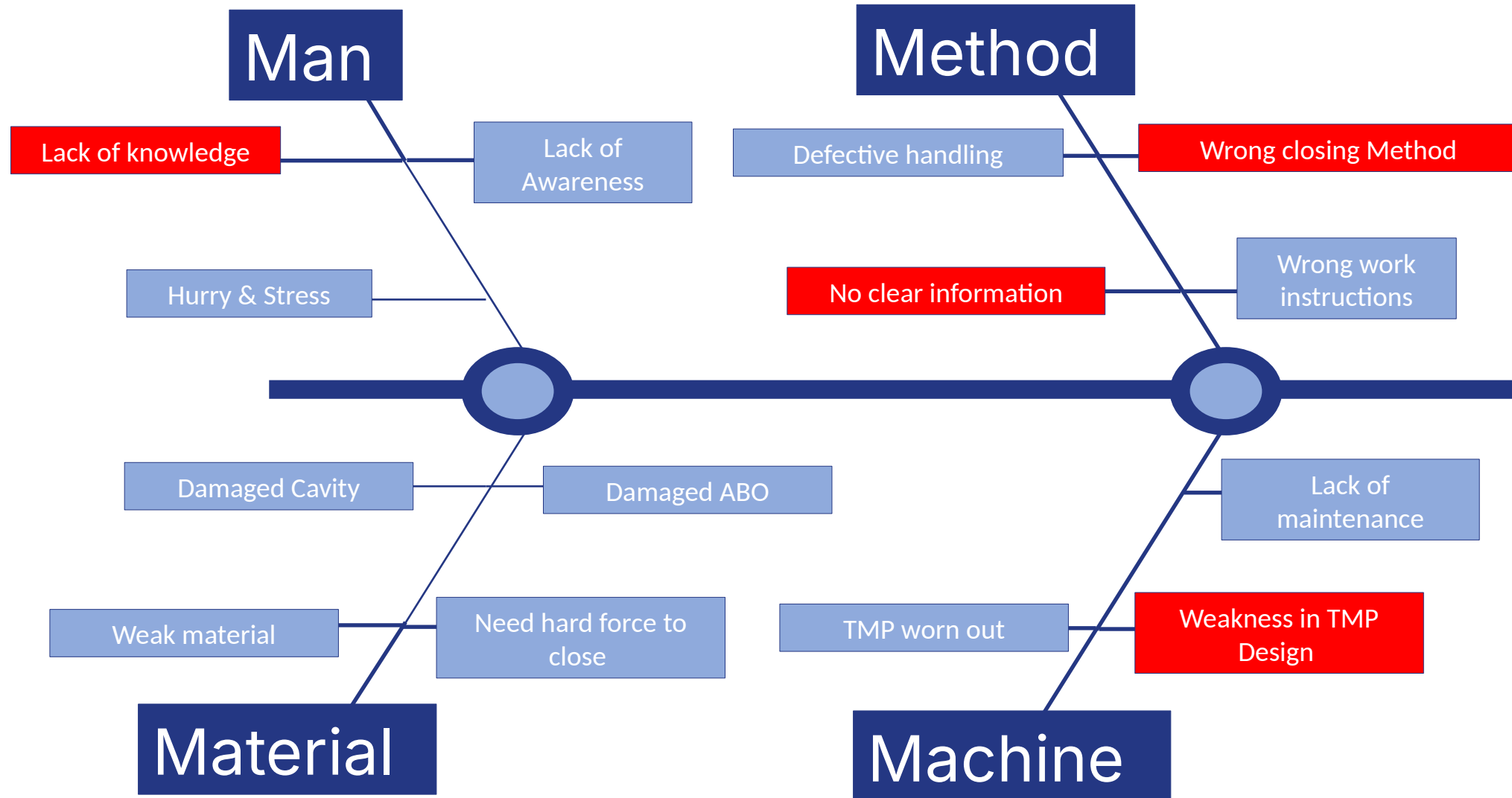
Tools and steps are
ensured to achieve the
targets

Done by our team

Before end of
Sep. 2023



4M analysis:

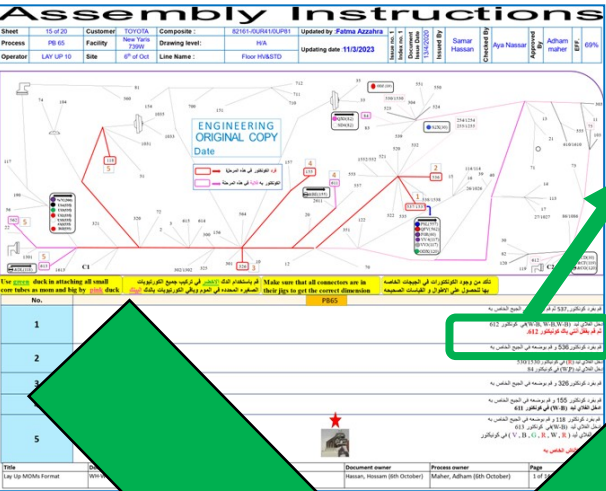


Current Situation For Occurrence :

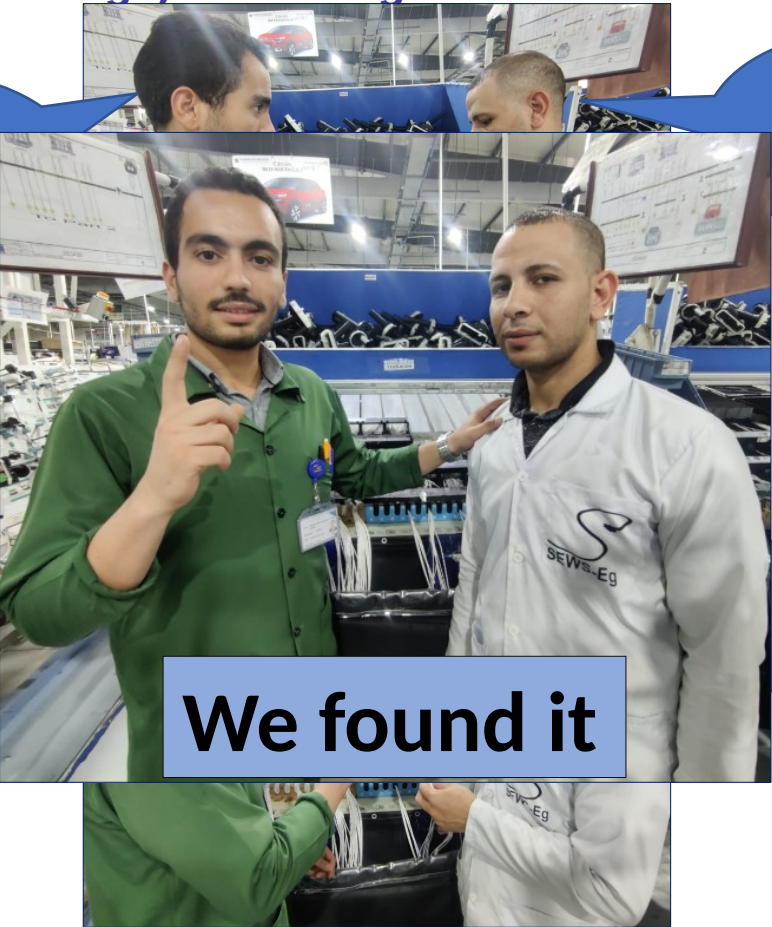
For this part, we need to ask 2 questions:

Did the operator know about the anti-back that he needs to close ?

Did the operator know the different methods (depending on connector design) for closing the anti-back ?



Due to MOM a Pre-block diagram is provided to the operator to indicate which connector to close back



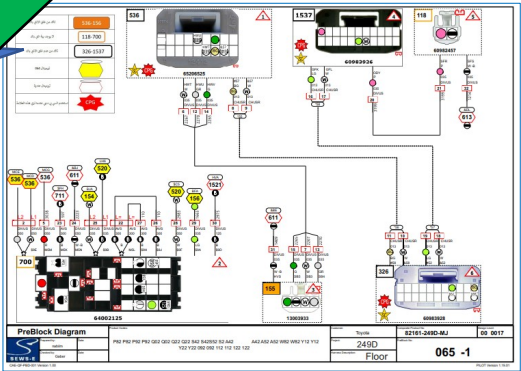
Which method did you use to close it?

Mmm, method for what !

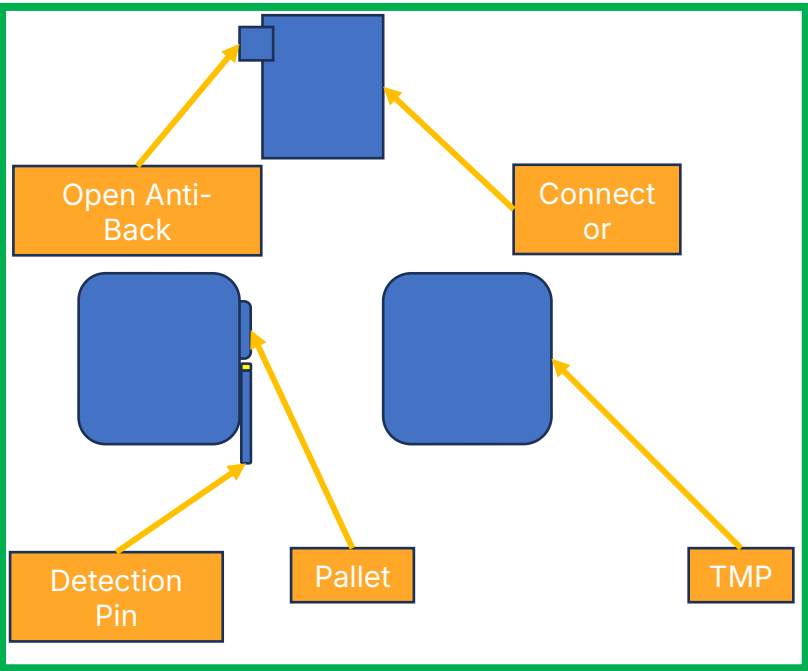
There is a different method (depending on connector design)

Really!

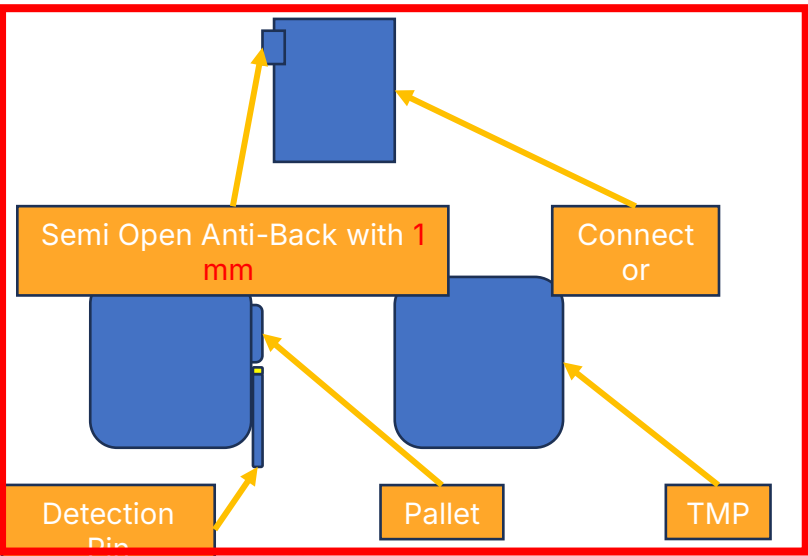
We found it



Current Situation For Detection:

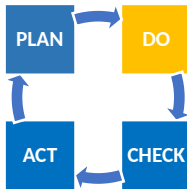


For Open Anti Back



For Semi Open Anti Back with 1 mm

For this part, we need to know how it works and the design issue:

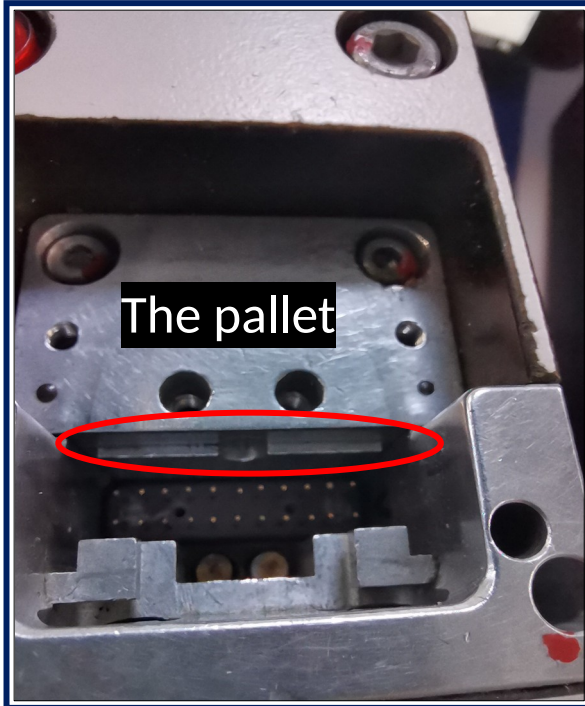


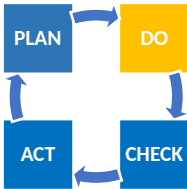
How it Works ?

If the anti-back Open, it will push the Pallet as shown to activate the Spacer-Open detector so it wouldn't Pass.

Weakness Point

This Design Can't detect Semi Open anti back with 1 mm





5 Why Analysis to find the root cause

Why 5	Why 4	Why 3	Why 2	Root cause for the defect	
Training method for anti-back, it's not dedicated for each closing type	There is a variation of the methods for closing different types of anti-back	The operator didn't follow the standard method for closing the anti-back	The operator didn't close the anti-back correctly	Open anti-back defects	Occurrence (PreBlock or layup)
The TMP design had several weakness points	TMP was needing a continues Corrective Maintenance	The TMP was worn out before Monthly Preventive Maintenance	TMP had a loose nut in the cylinder that detects open anti-back		Detection (E.T board)

1st solution: Training Operators



We used a sample board with the training manual to make it easy to understand types of anti-backs (side anti-back , front anti-back & rear anti-back) regarding to anti-back position and the different methods to close it.

Cairo-Training Center

Confidential

Anti Back Out مضادات الخروج او الرجوع

وهو عبارة عن قفل للكونكتور ووظيفته هو التأكد من ان دخول الترمينال قد تم بشكل صحيح فاذا دخلت الترمينال بشكل خاطئ ان لمصلحة اقل مضادات الرجوع بشكل صحيح كما هي الصورة

وهو لا يسمح للترمينال بالخروج من تحريف فتحه الكونكتور

OK NO

ملحوظة هامة : ممنوع منعا باتا محاولة فتح الاتني باله او اخراج ليد بنفسه ولا يتم ذلك الا عن طريق الديبليوكر

NG OK

Confidential

يجب على عامل الانتاج التأكد من دخول الترمينال داخل الكونكتور عن طريق اتباع الاجراءات : (كليك - بيل - سويچ - بيل) حتى لا يحدث خروج للترمينال من الكونكتور

8- تلك عامل الانتاج من عمله : يجب ان تتأكد من ذلك بعينك على الطريقة الصحيحة وبعد الفحص بعد ادخال الترمينال داخل الكونكتور وخلق الكونكتور.

قبل القلق بعد القلق

2- نوع يعلق بإصبع واحد مع دخول الالتفات الجانبية في الفتحات

3- نوع يعلق من المفارطين الامامي والخلفي

وهذا النوع يجب التأكد منه جيدا بعد فله لأنه سهل النسيان

4- نوع يتم إغلاقه بواسطة اداة او Tool موجود على الذي يلوكة

الاداء يتم بظهور عملية (كليك - بيل - سويچ - بيل) عليه اقل الكونكتور ان تتم بشكل صحيح

Confidential

يوجد أنواع كثيرة من مضادات الرجوع منها:

1- نوع يعلق بإصبعين

2- نوع يعلق بإصبع واحد مع دخول الالتفات الجانبية في الفتحات

3- نوع يعلق من المفارطين الامامي والخلفي

وهذا النوع يجب التأكد منه جيدا بعد فله لأنه سهل النسيان

4- نوع يتم إغلاقه بواسطة اداة او Tool موجود على الذي يلوكة

الاداء يتم بظهور عملية (كليك - بيل - سويچ - بيل) عليه اقل الكونكتور ان تتم بشكل صحيح

Confidential

2- أنواع مضادات الخروج في الموصلات: "anti back out"

1) جانبي

2) امامي

3) خلفي

مضاد الخروج الجانبي

يعلق هذا النوع من مضادات العودة من الجنب

هو النوع الرئيسي الذي يستخدم مع الكونكتورات الغير مضادة لعودة

Example

مضاد العودة الجانبي

التي لا يسمح للترمينال بالخروج من تحريف الفتح الكونكتور

OK NO

Confidential

2) مضاد الرجوع الامامي

يأتي مضاد الرجوع الامامي في امد الكونكتور

هو النوع الرئيسي الذي يستخدم مع الكونكتورات المضادة لعودة

ان وظيفة مضادات الرجوع هي التأكد من ان نهاية الترمينال قد تم ادخالها بازا

اذا تم ادخال الترمينال بشكل خاطئ فان مضادات الرجوع تم تقفل جيدا فلا سوف يلاحظ خطأ عند ادخال الترمينال

ان هذا الشكل لمضاد الرجوع لنجح عن اد خال الترمينال

OK NO

ان هذا الشكل لمضاد الرجوع لنجح عن ادخال الترمينال

OK NO

Result of the 1st solution:

Training evidence

TRAINING EVIDENCE RECORD

Date: 11-9-2022 Duration: 157 Location: Ho20, Floor 2 (K)

Training Subject: Strategic Action Plan

Training document (Name, Reference No, Version, Page of document, specify all documents included)

Title	Reference	Version
Training on ABO document		
ERP and ABO	by KIT team	

The following persons attended training:

Name and Surname	Clock No.	Job Title	Signature	Comments
1. محمد ع. محمد	10828	P.B.30		5-2
2. محمد ع. محمد	9615	...		
3. محمد ع. محمد	5880	P.B.70		
4. محمد ع. محمد	9331	P.B.70		
5. محمد ع. محمد	3-117	P.B.60		
6. محمد ع. محمد	5510	P.B.60		
7. محمد ع. محمد	10818	P.B.30		
8. محمد ع. محمد	413	P.B.80		
9. محمد ع. محمد	9461	P.B.10		
10. محمد ع. محمد	988	P.B.10		

Trainer (Name): ... Signature: ...

EVIDENCE RECORD

Location: Floor 1, 3

Action Plan

of document, specify all documents included

Reference	Version
by KIT team	

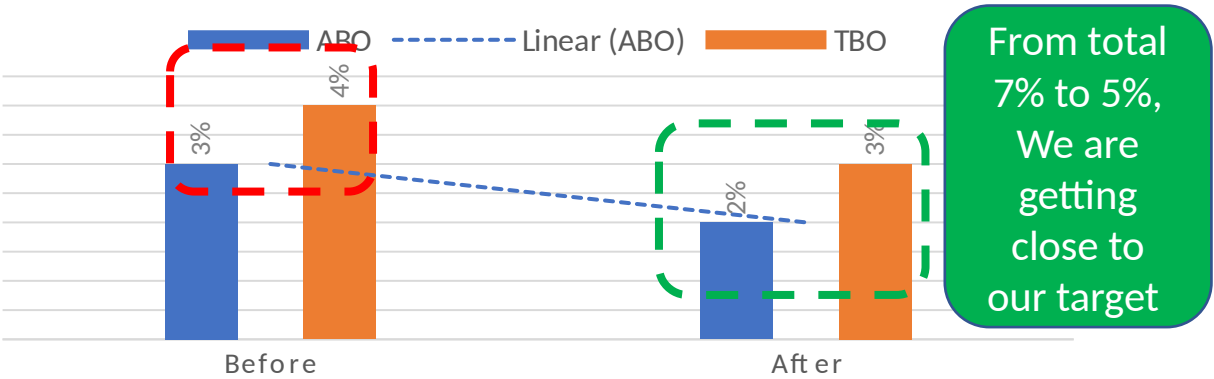
The following persons attended training:

Name and Surname	Clock No.	Job Title	Signature	Comments
11. محمد ع. محمد	15193	P.B.20		
12. محمد ع. محمد	10980	P.B.40		
13. محمد ع. محمد	13191	...		
14. محمد ع. محمد	13191	P.B.5		
15. محمد ع. محمد	13191	P.B.7		
16. محمد ع. محمد	13191	P.B.8		
17. محمد ع. محمد	13191	P.B.10		
18. محمد ع. محمد	13191	P.B.10		
19. محمد ع. محمد	13191	P.B.10		
20. محمد ع. محمد	13191	P.B.10		
21. محمد ع. محمد	13191	P.B.10		
22. محمد ع. محمد	13191	P.B.10		
23. محمد ع. محمد	13191	P.B.10		
24. محمد ع. محمد	13191	P.B.10		
25. محمد ع. محمد	13191	P.B.10		
26. محمد ع. محمد	13191	P.B.10		
27. محمد ع. محمد	13191	P.B.10		
28. محمد ع. محمد	13191	P.B.10		
29. محمد ع. محمد	13191	P.B.10		
30. محمد ع. محمد	13191	P.B.10		
31. محمد ع. محمد	13191	P.B.10		
32. محمد ع. محمد	13191	P.B.10		
33. محمد ع. محمد	13191	P.B.10		
34. محمد ع. محمد	13191	P.B.10		
35. محمد ع. محمد	13191	P.B.10		

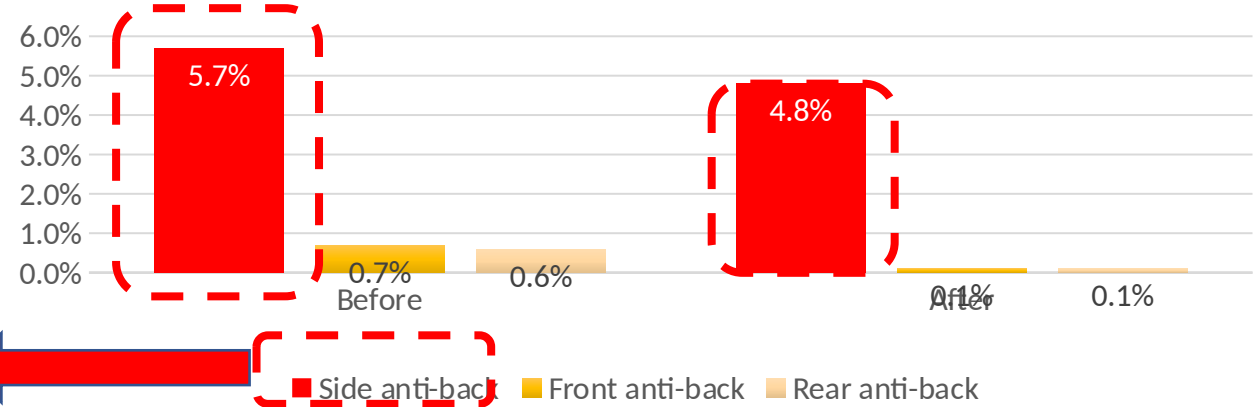
Trainer (Name): ... Signature: ...

Internal defects percentage from all defects

Defect REDUCTION per type



Defect per anti-back type



We still have a problem with the connectors with side anti-back

2nd solution: Change the design of TMP

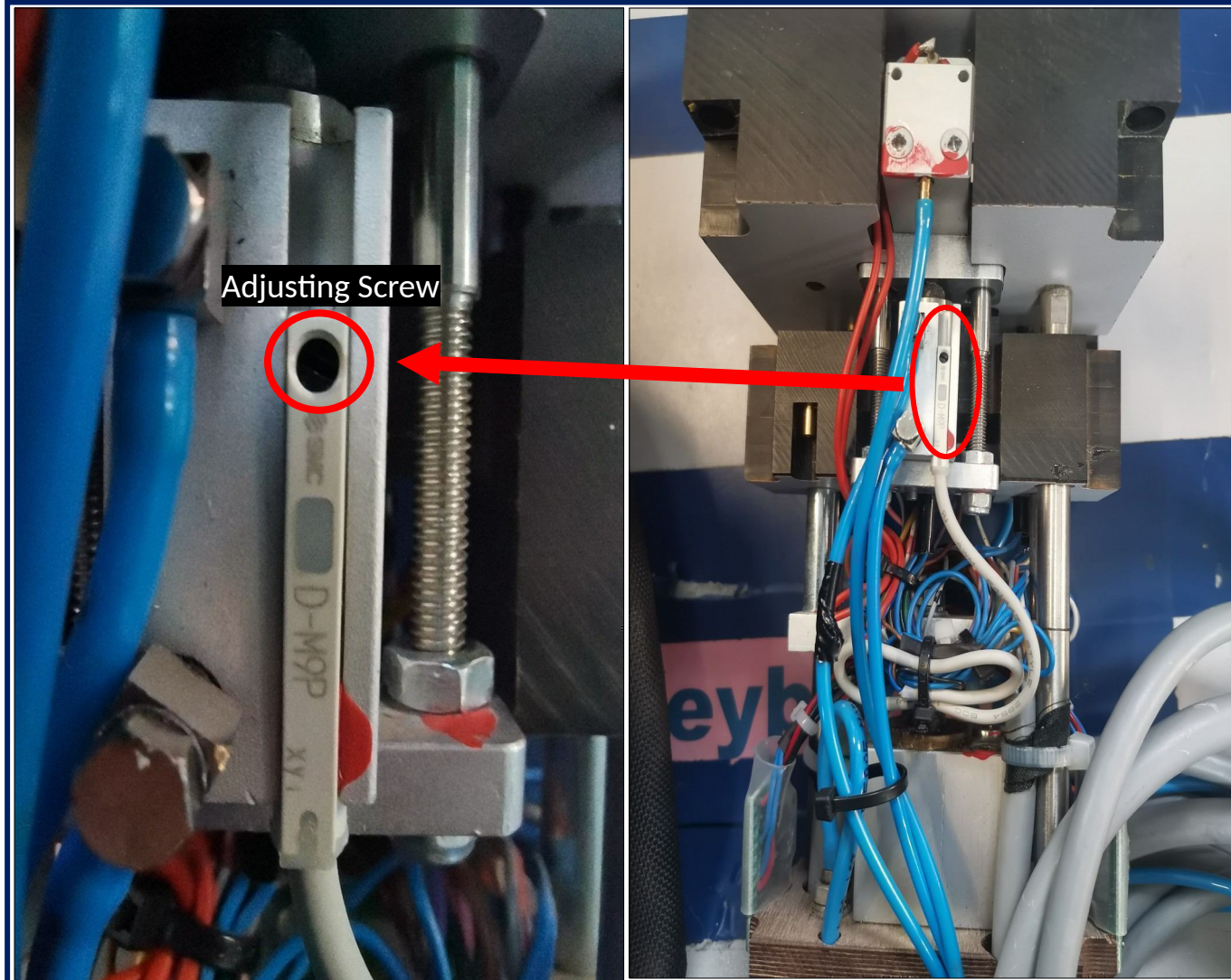


How it Work ?

We adjusting the Cylinder's stroke With Sensor to Only Pass the Closed Anti Back into the Required Level

Weakness Point

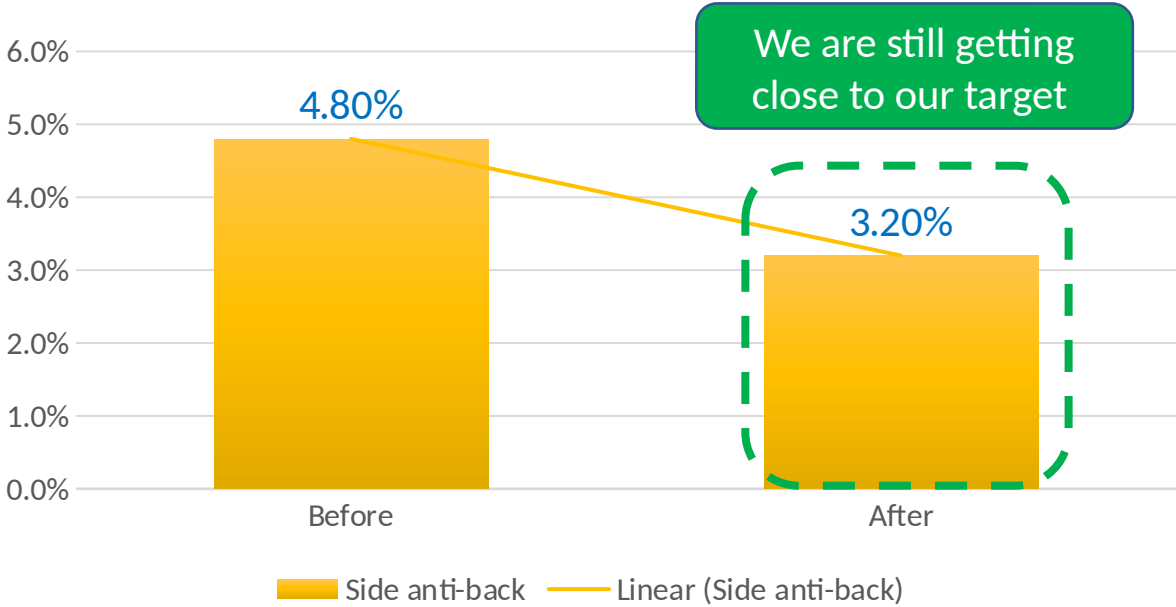
After the continuous usage, the Adjusting screw of the sensor could be Loose so,we have a Risk to Pass Open-Anti Back.

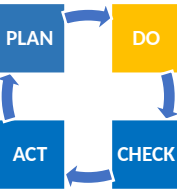


Result of the 2nd solution:



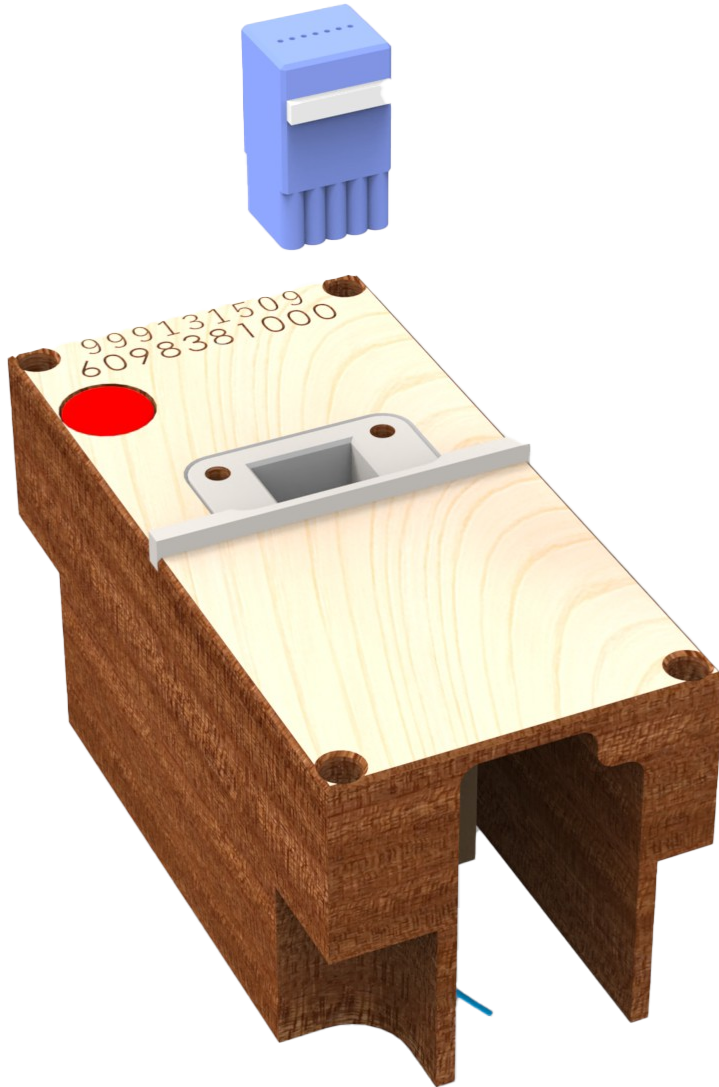
Defects for side anti-back



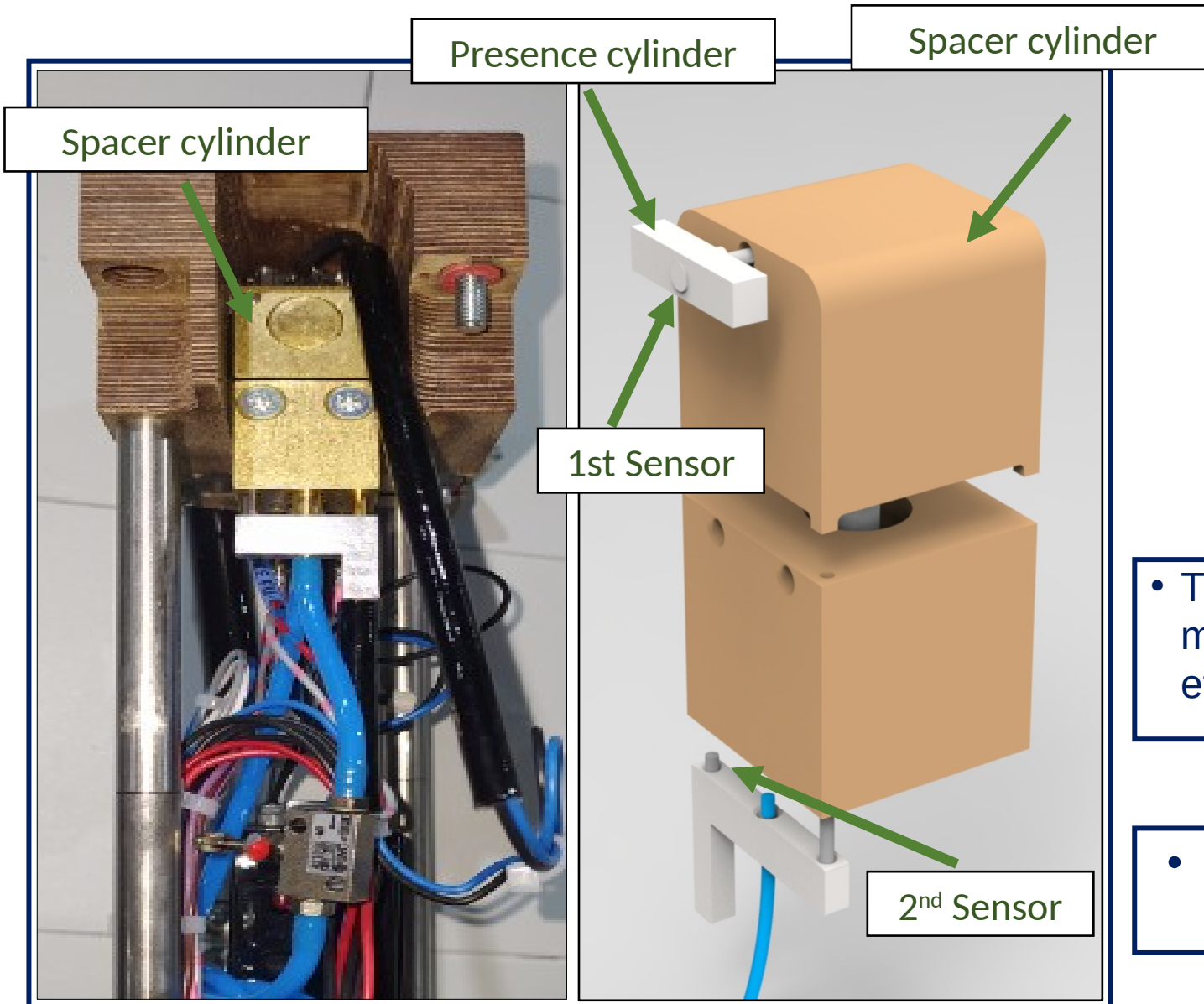


Birth Of Our Idea

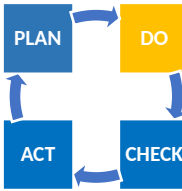
3rd solution: Change the design of TMP
Again



Detection solution: 1.Cylinder Design



How it Work ?



- We have 2 cylinders controlled by 2 sensors.
 - The presence cylinder moves till the 1st sensor detects the connector's body.
 - Then the spacer cylinder slide over the anti-back to check the anti-back status with 2nd sensor.

Weakness Point

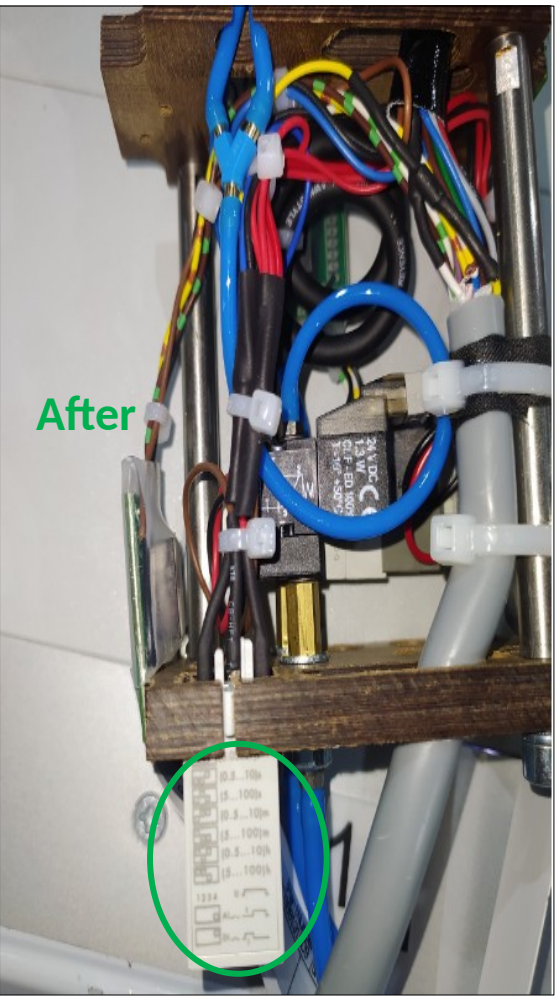
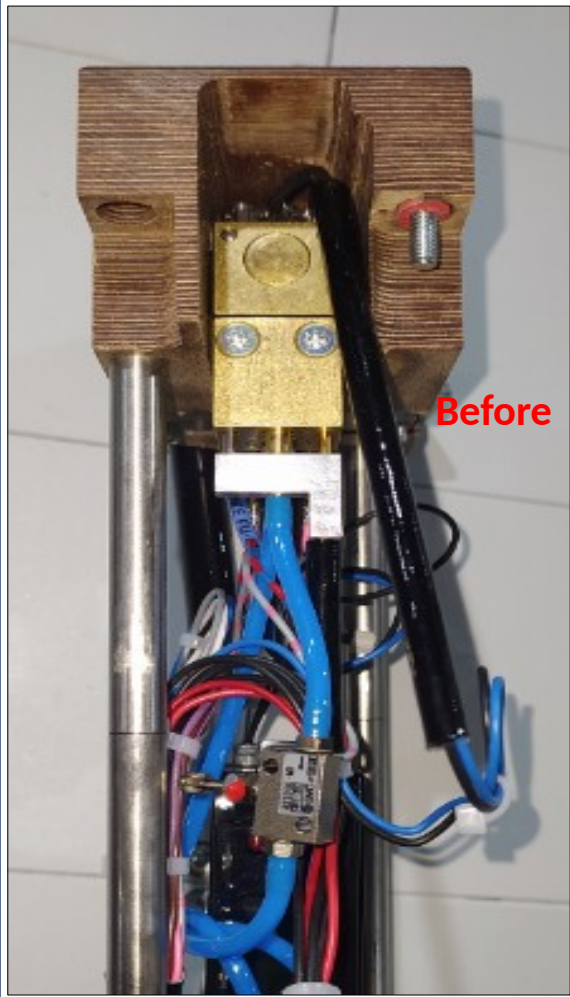
- The cylinder which checking the anti back was moving with **zero** delay ,which reduces the efficiency of checking ABO defect.

Proposal

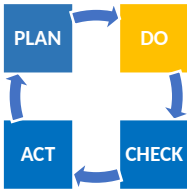
- We need to increase the time of the spacer cylinder to check the anti-back by 100%.

Detection solution: 2.Cylinder Timer Design

Before\After



Contacting with supplier



Timer Idea.pptx
2 MB

Trial.pptx
1 MB

From: AbdElmoneam, Bassem (6th October)
Sent: Thursday, September 21, 2023 12:35 PM
To: Wittemeier, Olaf <olaf.wittemeier@komaxgroup.com>; Ciulianu, Florin <florin.ciulianu@komaxgroup.com>
Cc: 6th October Electrical Test <6thOctoberElectricalTest@sews-e.com>; Adam, Mohamed (6th October) <Mohamed.Adam@sews-e.com>; Maher, Adham (6th October) <Adham.Maher@sews-e.com>
Subject: Preventing Semi Open Anti Back

Dear Olaf,

We Have an improvement Idea on Electric Jig and I need you to install it on all Electric Jigs.

We're Facing a Semi-open Anti back Concern which it Pass on Many Electric Jigs on Floor Lines of a New Design of Jigs [Push-Up Design].

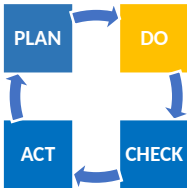
when the Jig active, the Cylinder of Presence response too Fast checking which can't catch up the Semi Open Anti back and press on Spacer Probe to Pass ,so we make a installed a Timer on the Spacer Detection on Electric Jig which it allow 3 sec. to check the anti-back of the Connector.

Regards,
Bassem Abdel Monem
Test Engineer – SE Wiring System Egypt S.A.E
+201125719801

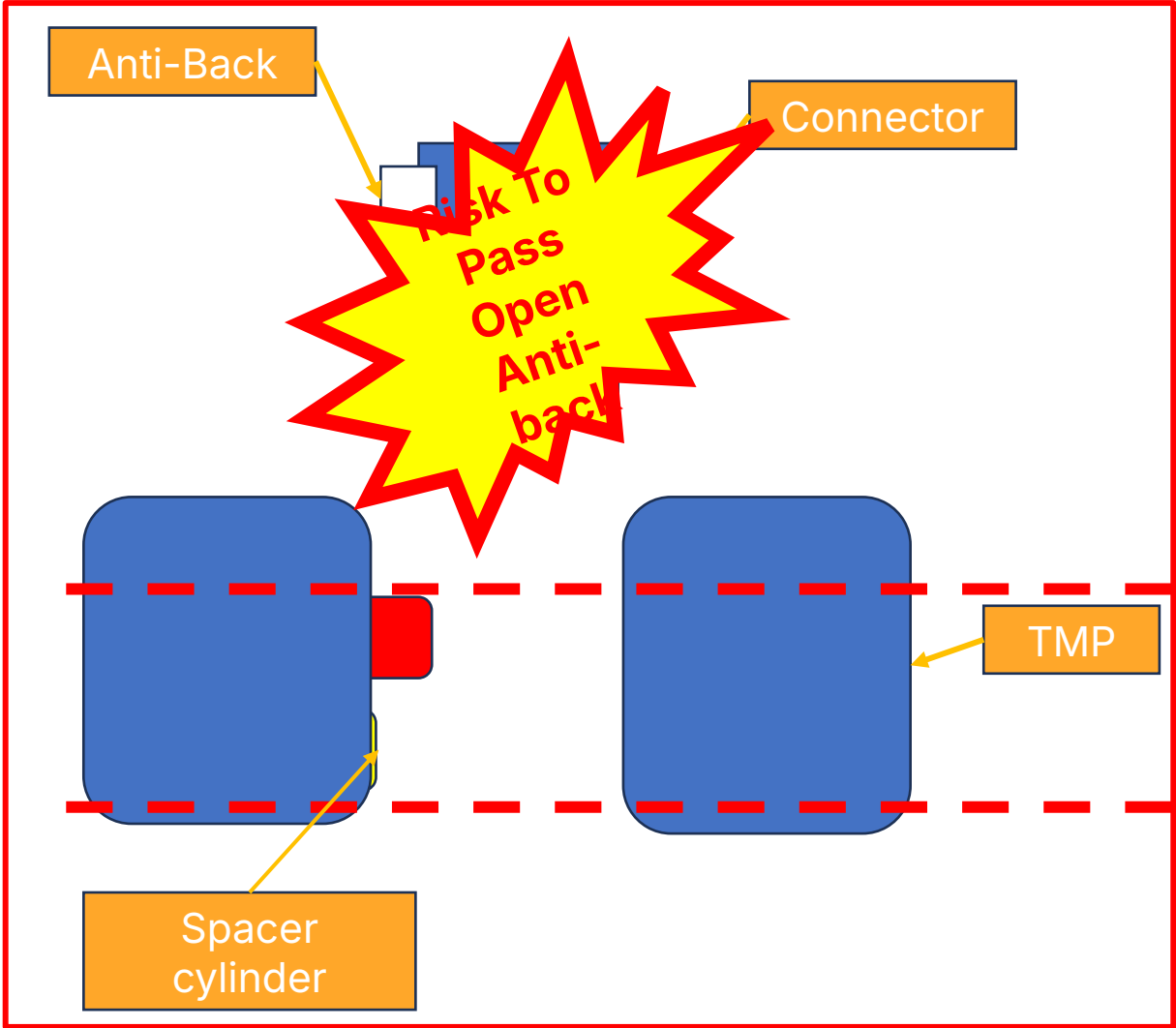
Result\Plan

- So, we added a timer for the spacer cylinder to reduce its speed by **3 seconds** as the supplier recommended to check the anti-back by 100%

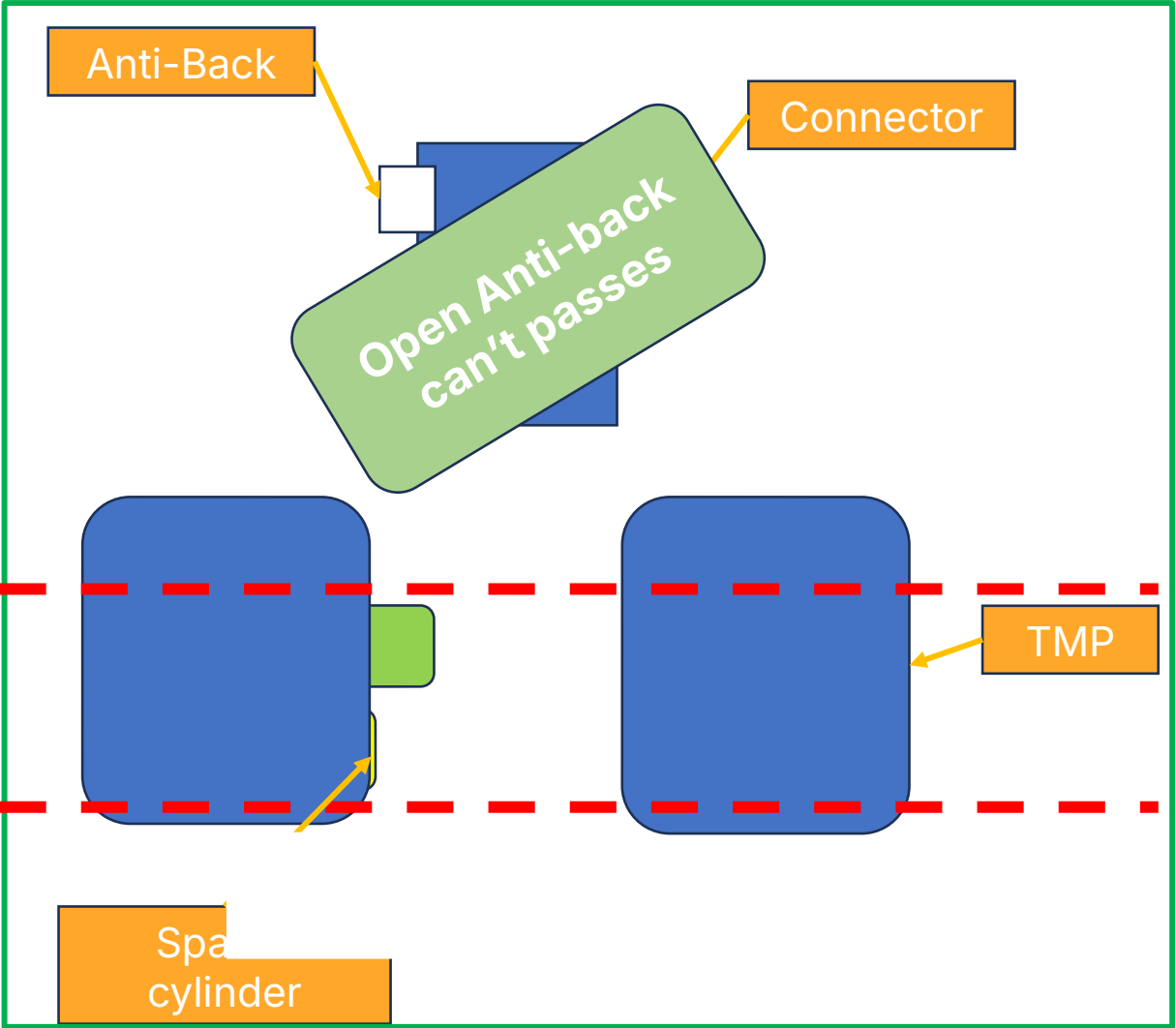
Detection solution: 2.Cylinder Timer Design



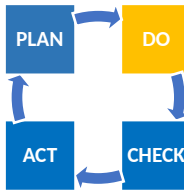
Before



After

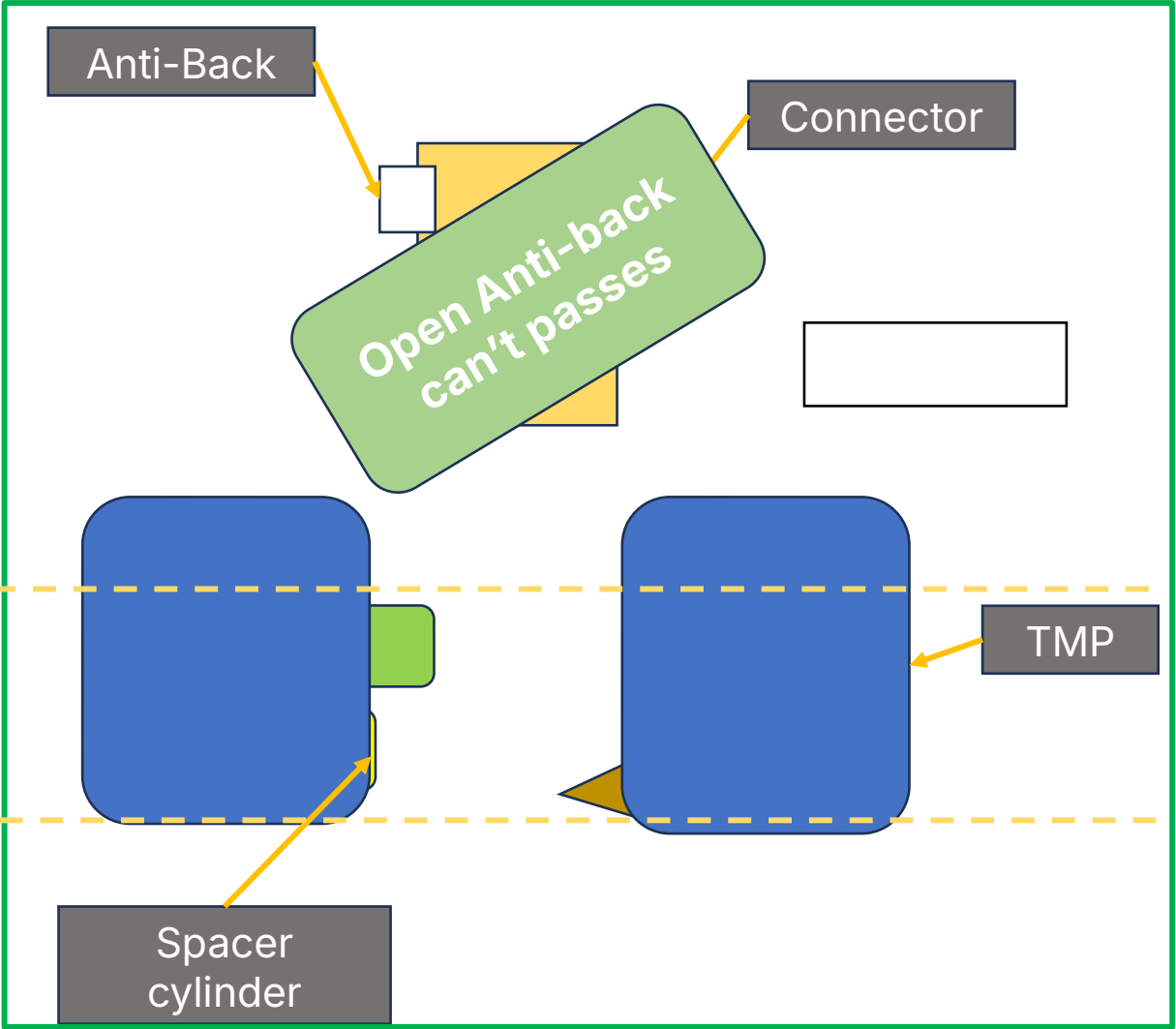
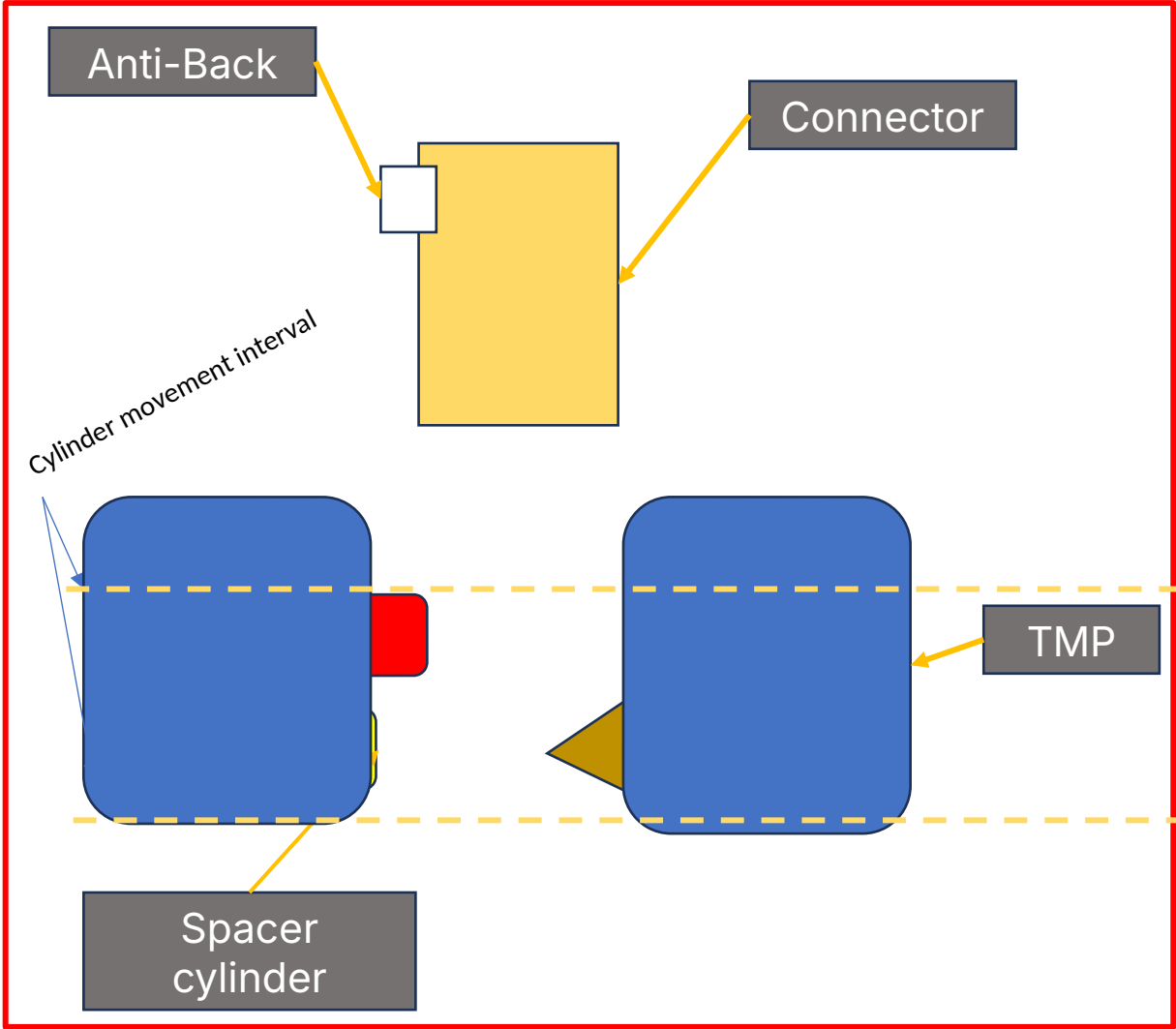


Detection solution: 2.Cylinder Timer Design



Before

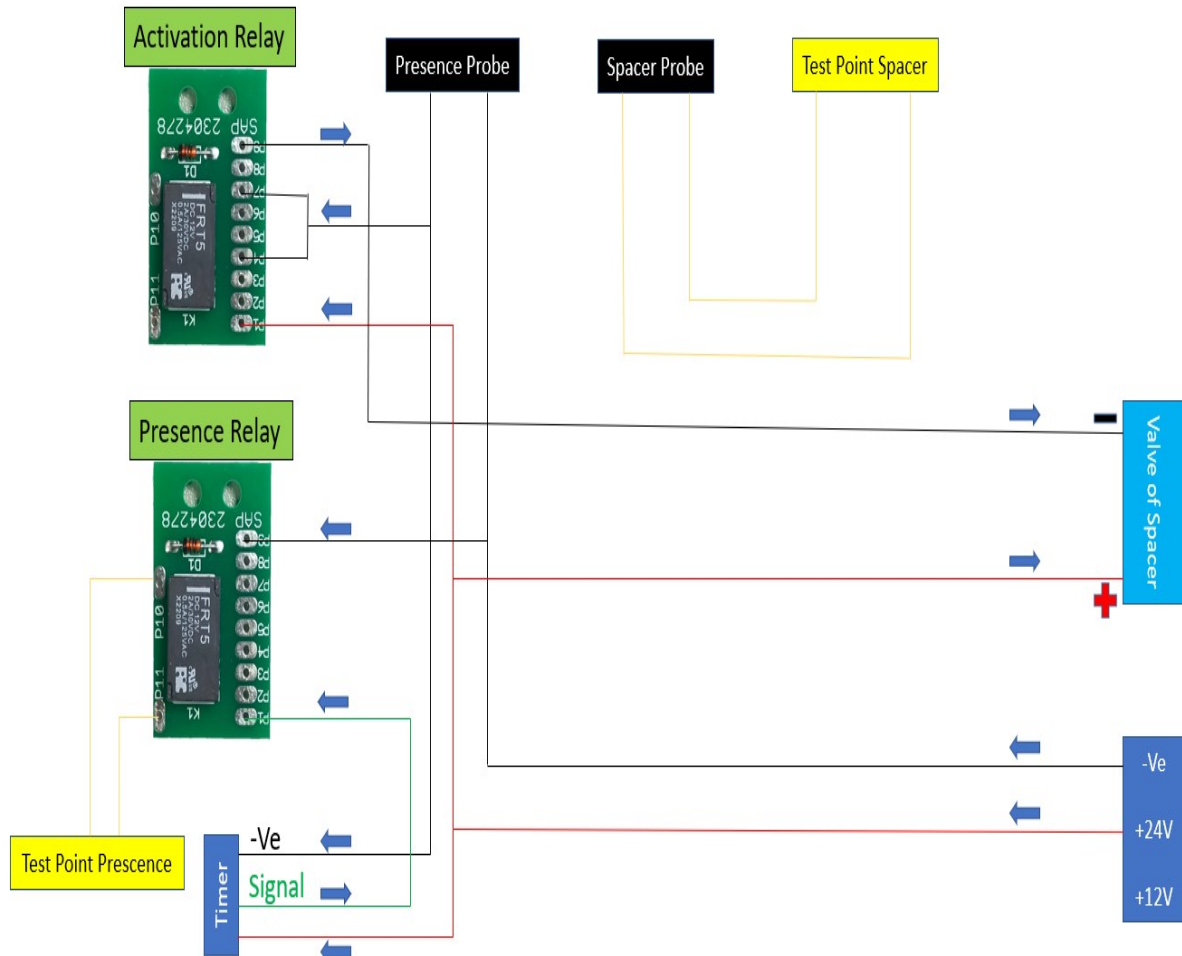
After



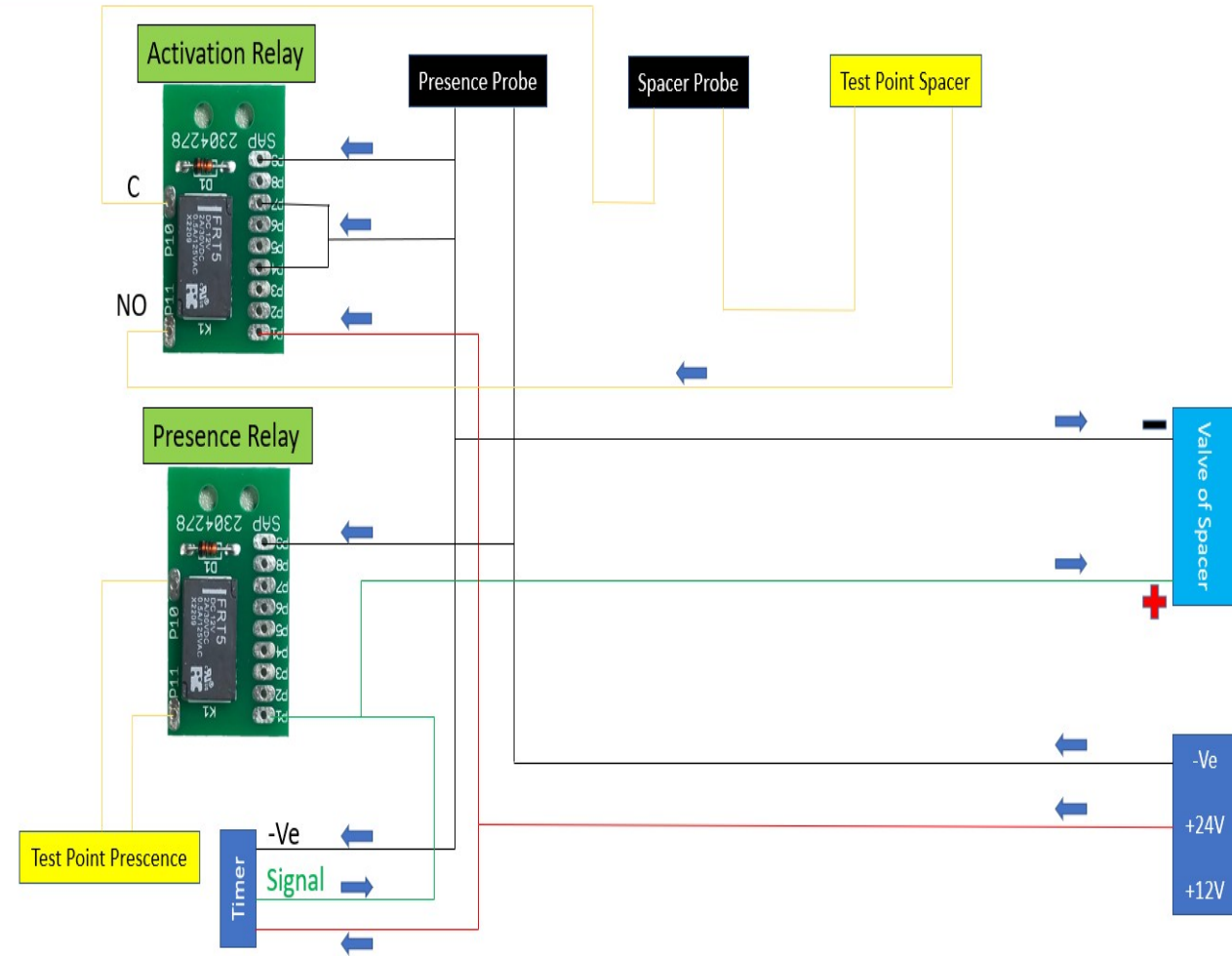


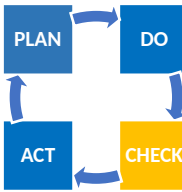
The Electronic Circuit

Before Adjusting



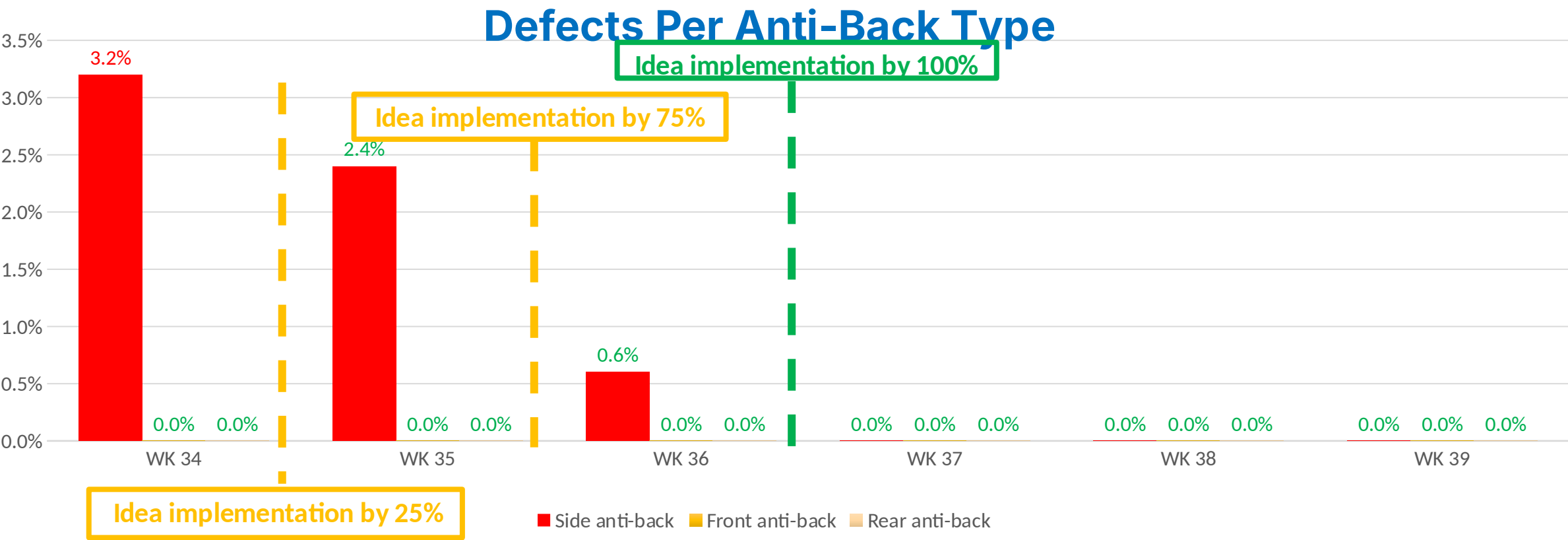
After Adjusting





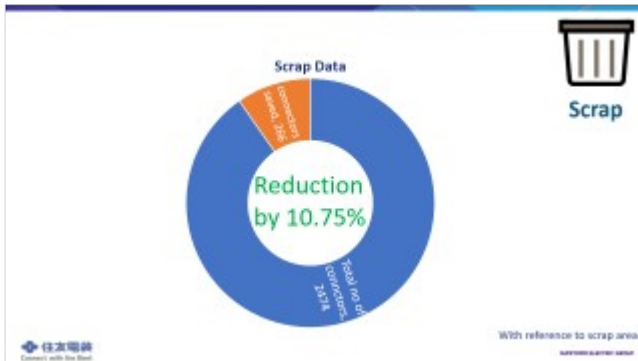
Internal defects by percentage from the total defects during idea implementation:

We started to implement our idea on **CHR** Roof, Right door and left door.





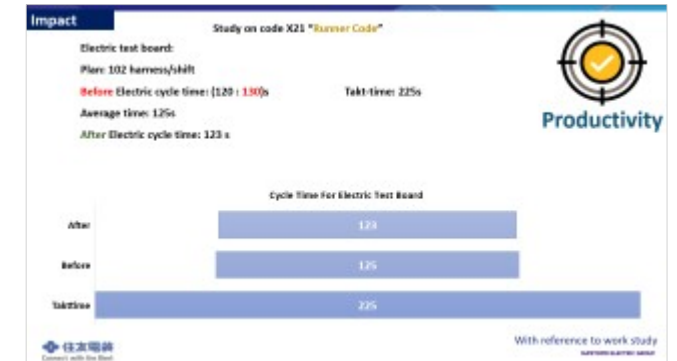
Scrap



Downtime



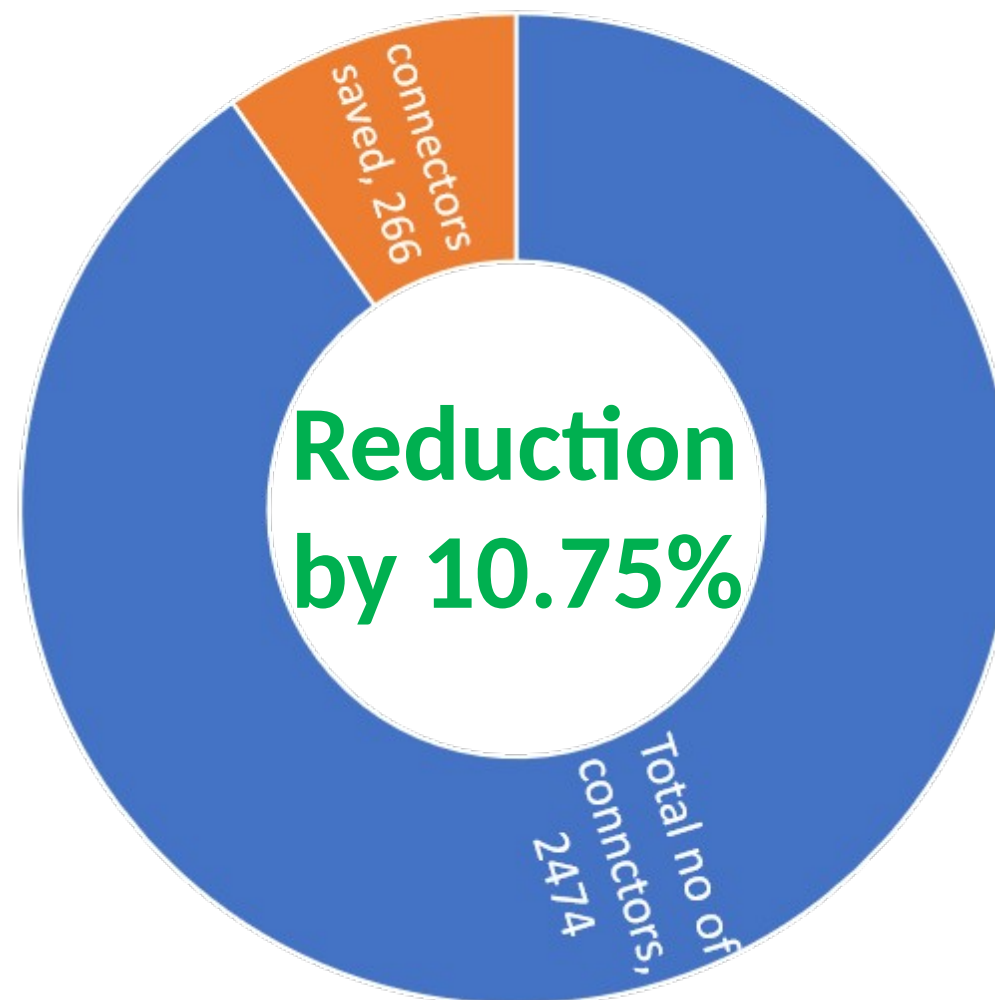
Productivity





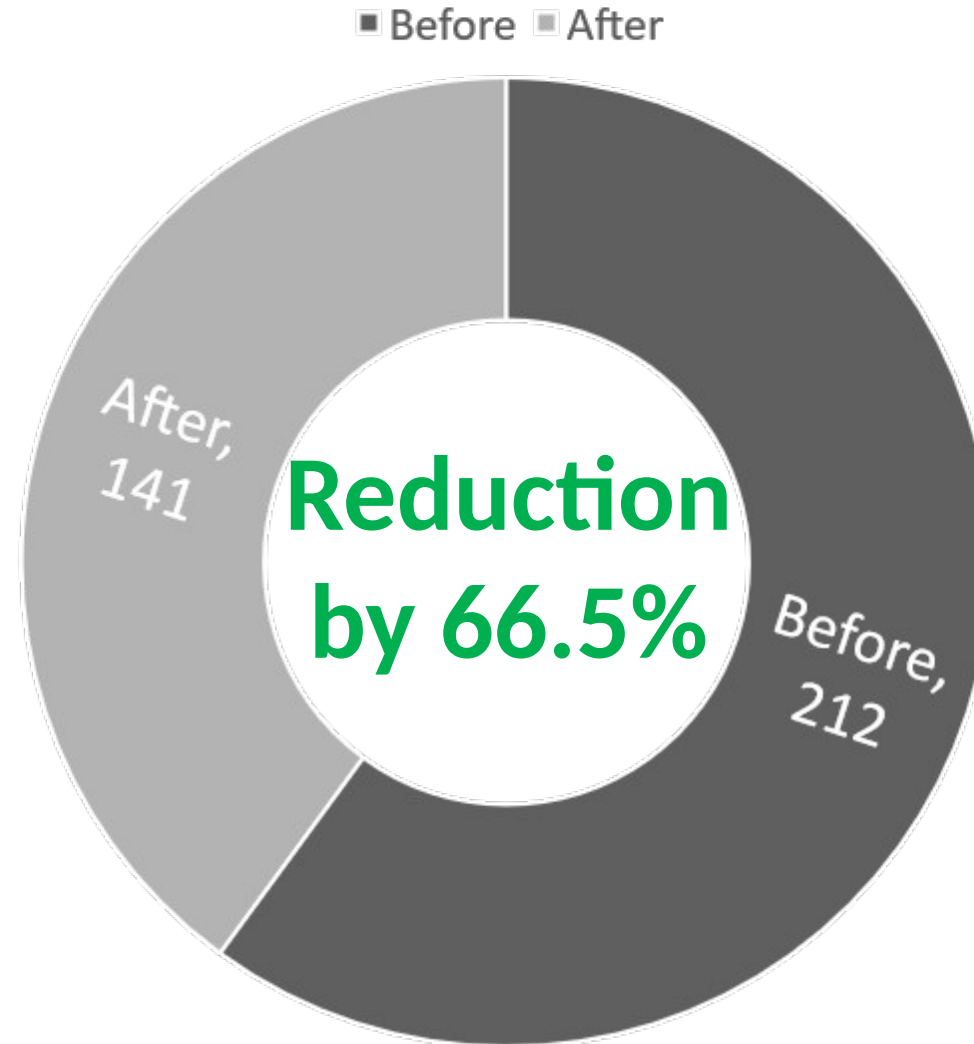
Scrap

Connectors Scrap Data for July vs Sep.(Before & After)



With reference to scrap area

Down Time Per Min for July vs Sep.



Downtime

Study on code X21 “Runner Code”

Electric test board:

Plan: 102 harness/shift

Before Electric cycle time: (120 : 130)seconds

Takt-time: 225 seconds

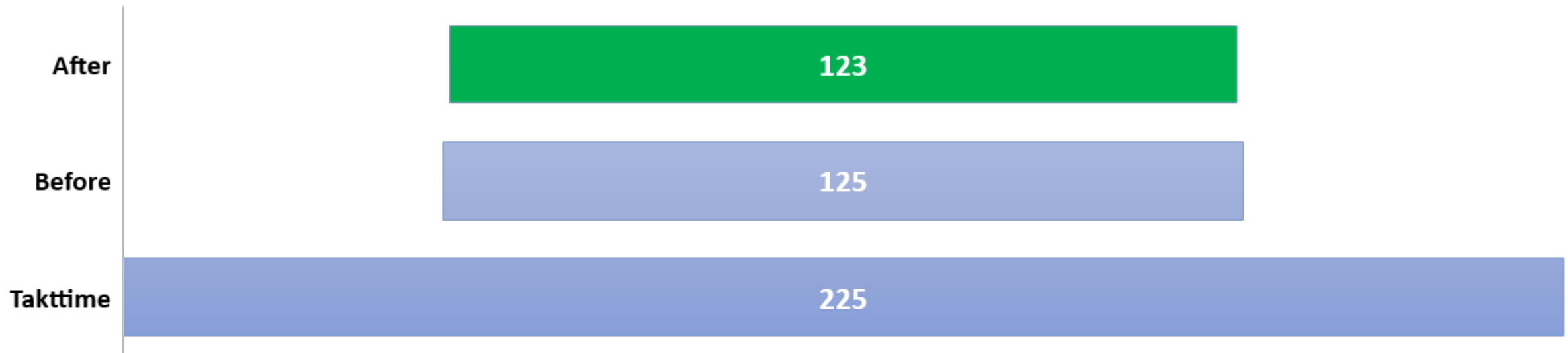
Average time: 125 seconds

After Electric cycle time: 123 seconds



Productivity

Cycle Time For Electric Test Board Per Second





We have achieved our goals based on SMART objectives



Specific

Target is **decreasing anti-back defects**



Measurable

0 Customer concerns
95% decrease in ABO and semi-ABO internal defects
70% decrease in TBO internal defects



Achievable

Tools and steps are ensured to achieve the targets



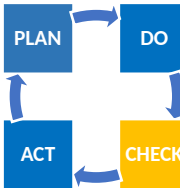
Relevant

Done by our team



Time Bound

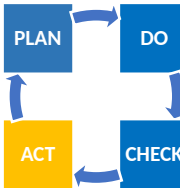
Before end of Sep. 2023



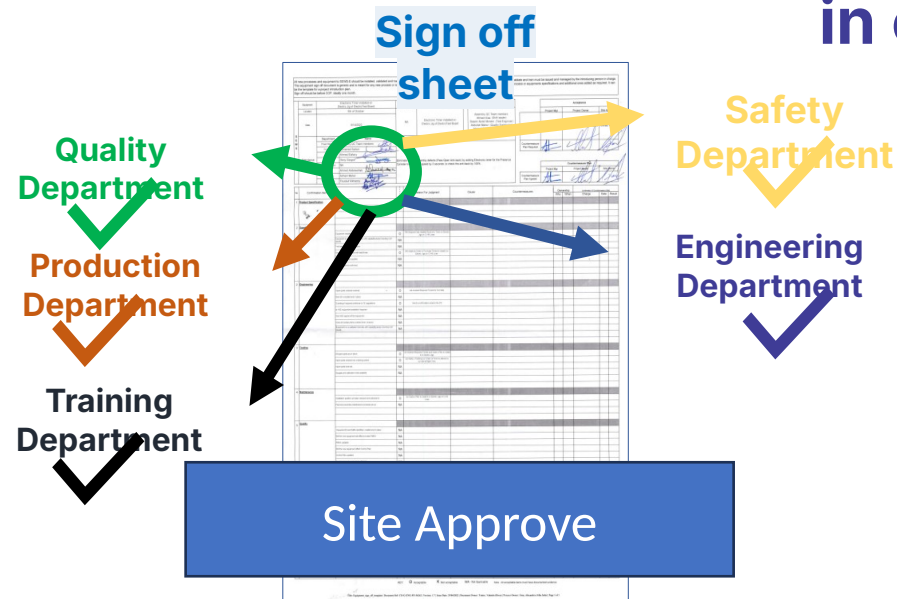
QCDMS & E :



Standardization and Validation:



We have confirmed the standardization and validation for our improvement regarding all the changes in the process to be reflected in company standards

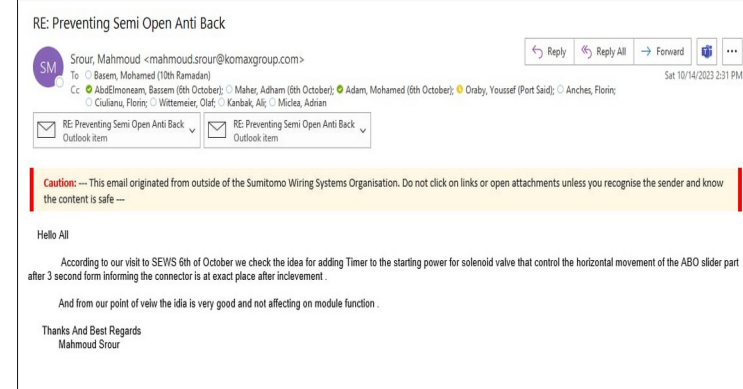


Validate with Central Engineering

Risk assessment

Item	Risk	Control	Residual Risk
1	High	Low	Medium
2	Medium	Medium	Low
3	Low	High	Very Low
4	Medium	Low	Medium
5	High	Medium	Medium
6	Low	High	Very Low
7	Medium	Medium	Low
8	High	Low	Medium
9	Medium	High	Low
10	Low	Medium	Low

All is on ok conditions

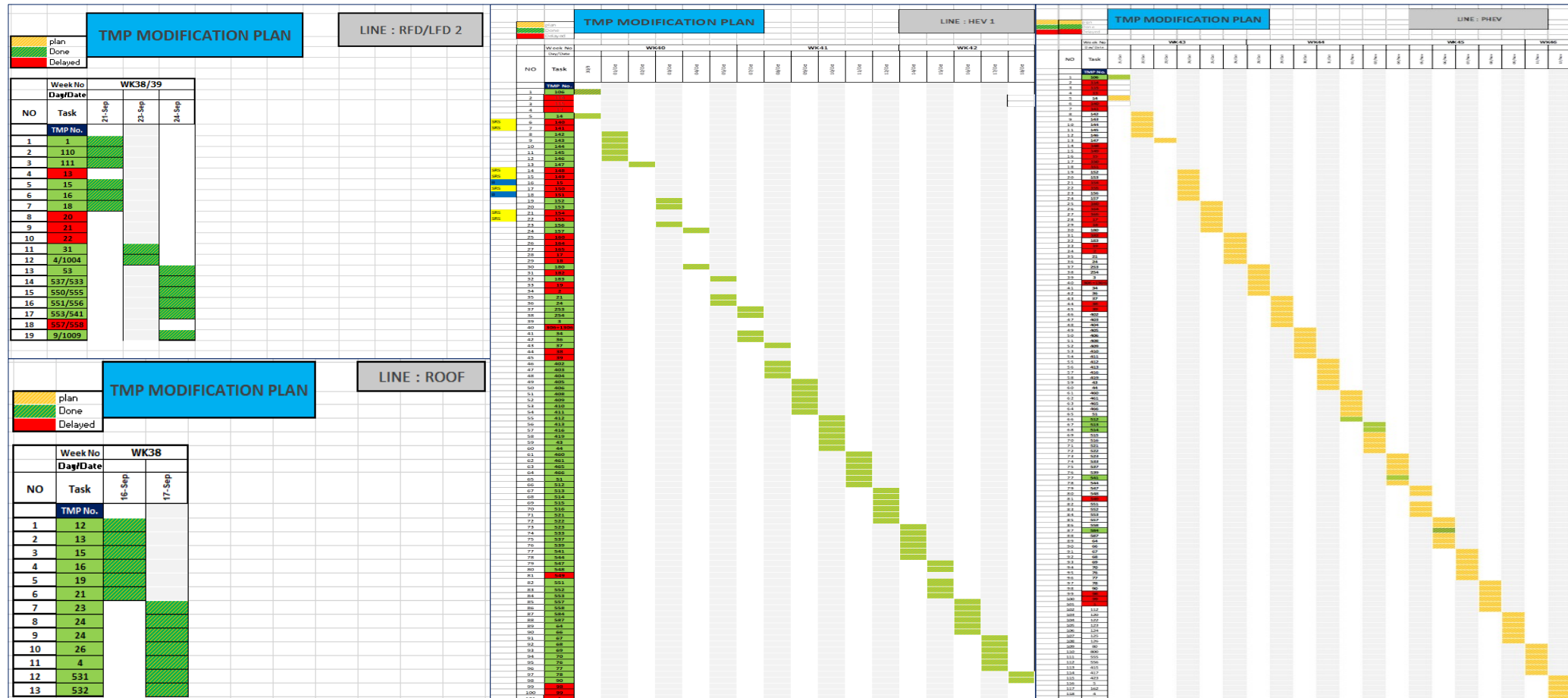


Plan for implementation



The future implementation Plan:

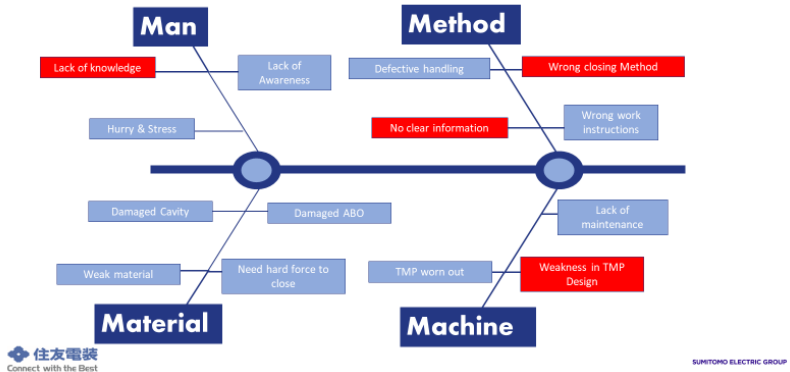
We have **12** electric boards for CHR, Yaris & Yaris cross lines with **650** Jig in total to be implemented with our idea



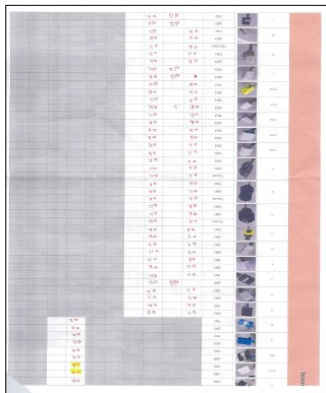
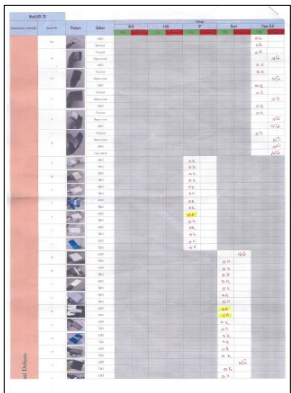
QC tools used

Root cause Analysis

4M analysis:



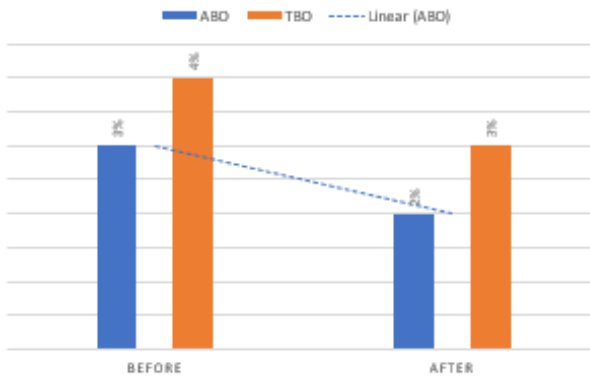
4M analysis ↔



Check Sheet



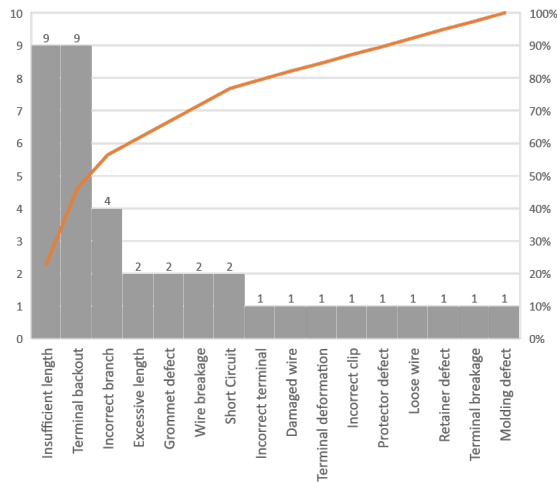
DEFECT REDUCTION



Trend Chart



TOYOTA official concerns per type



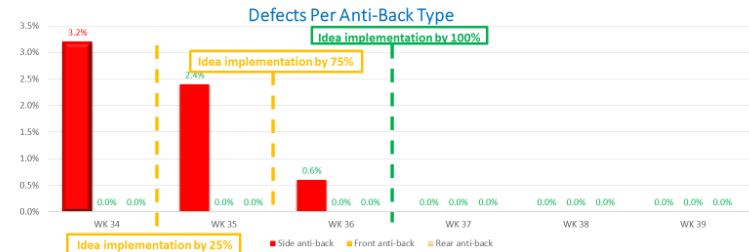
Pareto Chart



Quality Impact

Internal defects by percentage from the total defects during idea implementation:

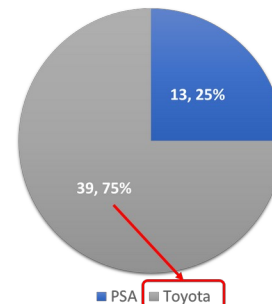
We started to implement our idea on **CHR** small lines



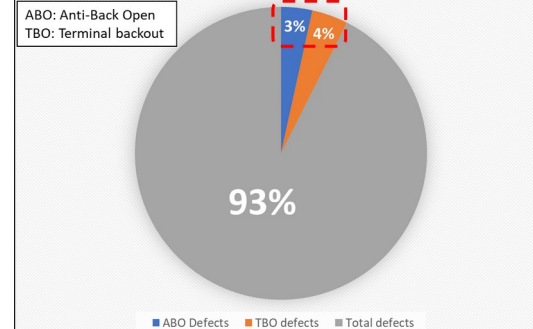
Histogram



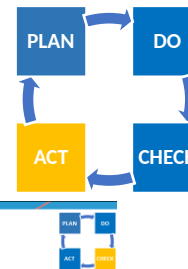
Official concerns per customer



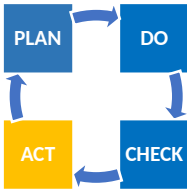
Internal defects per type



Pie Chart



Skill Matrix After



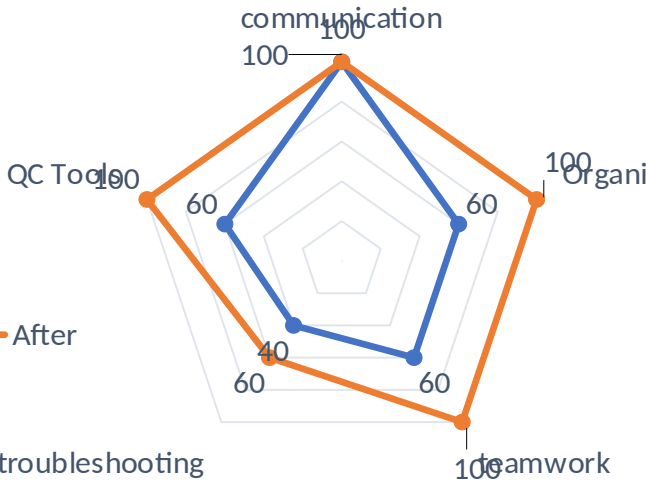
Categories	Communication	Organization	Teamwork	Trouble shooting	QC tools	Total
 Helmy						87%
 Alaa						93%
 Bassem						93%
 Abdullah						93%

Skill Matrix Conclusion: By Manager



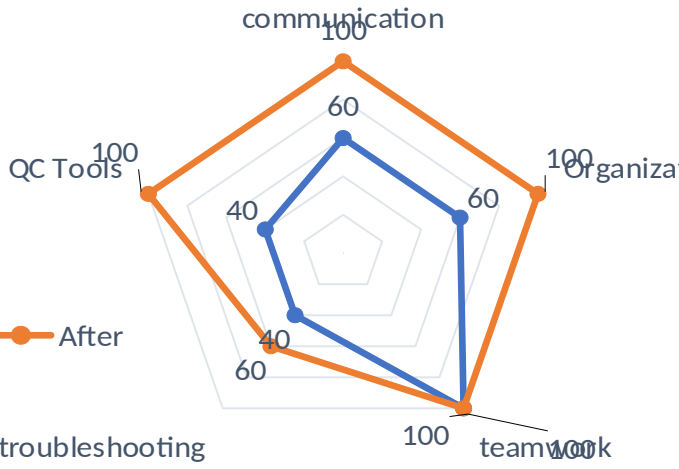
MAHER

Before After

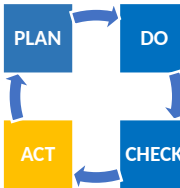
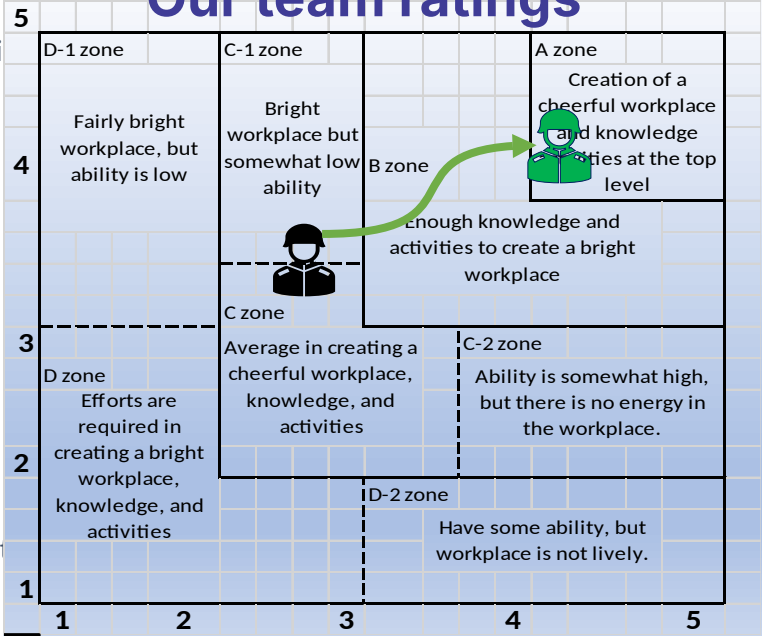


ALAA

Before After

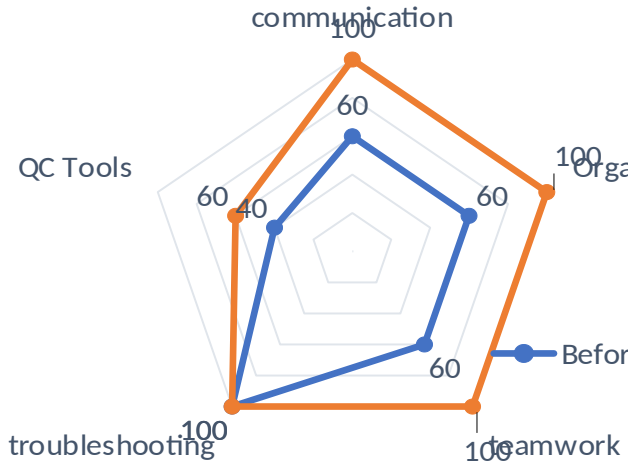


Our team ratings



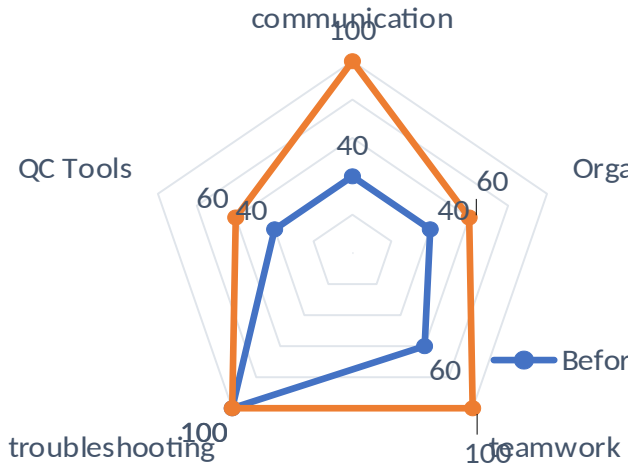
BASSEM

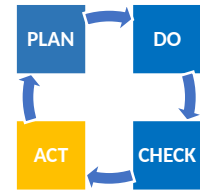
Before After



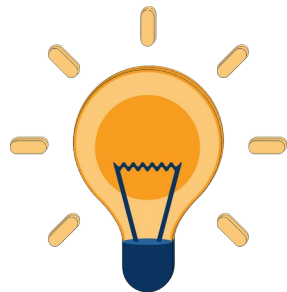
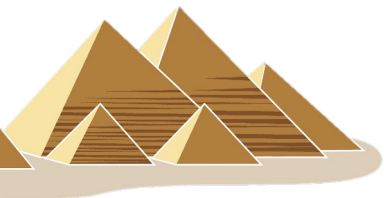
HELMY

Before After

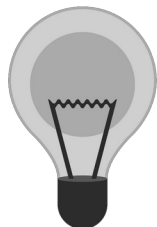




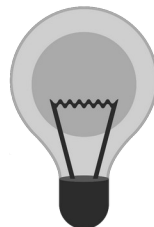
Egypt - Cairo



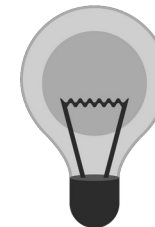
Egypt - Port Said



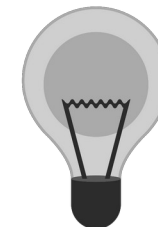
Romania



Morocco - Kenitra



Morocco - Ain Aouda



We have shared our idea with other

YOKOTEN ACTIONS :

QC Sharing Idea



AbdElmoneam, Bassem (6th October)

To  AbouZeid, Mohamed (Port Said);  Cheradi, Mohamed (kenitra);  Nassiri, Hind (Kenitra 2);
 El bouzidi, Fatima-ezzahra (Ain Aouda);  Cheradi, Mehdi (Skhirat);  Rayhani, Fatiha (MFZ);  Tahir, Mohamed (Ain Aouda);
 Telegredean, Cristina (Deva);  Gatalan, Ovidiu (Monastir);  Monier, Yosry (10th Ramadan)
Cc  Youssef, Ahmed (6th October);  Adam, Mohamed (6th October);  Elafany, Ahmed (6th October);
 Adam, Mohamed (6th October);  Maher, Adham (6th October);  Maher, Abdallah (6th October);
 Alaaelden, Ahmed (6th October)

← Reply

↩ Reply All

→ Forward



Wed 9/27/2023 8:51 AM



Dear Quality Teams,

We want to share our idea with you , we wanted to prevent the Semi Open Anti Back defect due to its high severity , We Have an improvement Idea on Electric Jig .We 're Facing a Semi-open Anti back defect which it Pass on Many Electric Jigs on Floor Lines of a New Design of TSK Jigs [Push-Up Design].
when the Jig active, the Cylinder of Presence response too Fast checking which can't catch up the Semi Open Anti back and press on Spacer Probe to Pass ,so we installed a Timer on the Spacer Detection on Electric Jig which it allow 3 sec. to check the anti-back of the Connector.

Regards,

Basem Abdel Monem

Test Engineer – SE Wiring System Egypt S.A.E

+201125719801

Mission Accomplished

Finally, We can back home now

