

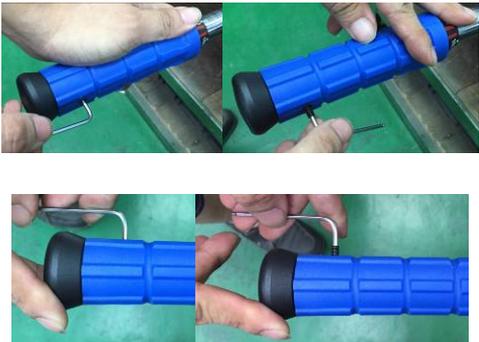
KABO TOOL COMPANY

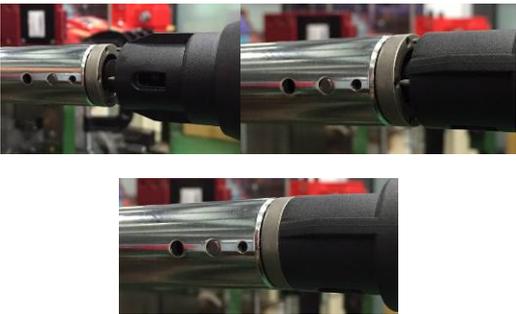
Repair SOP

Work Station	Calibration Process	Issue Date:	Version:
		10/24/2016	A1
		Date Build:	PAGE/OF :
		10/24/2016	1/5
Process	Photo	Checking Points	
<p>1</p> <p>Ready to repair</p>		<p>Preparing:</p> <ul style="list-style-type: none"> - Allen wrench set - Flat-head screwdriver (width 4mm) 	
<p>2</p> <p>Prepare to do torque checking</p>		<p>Put torque wrench horizontally on torque tester for preparing to check each torque value within accuracy +/- 4%.</p>	
<p>3</p> <p>Turn to 80FT/LB</p>		<p>Turn to 80 FT/LB and make sure push lock is locked for first point (80 FT/LB) torque checking.</p>	
<p>4</p> <p>First point Torque checking</p>		<p>Press the torque wrench, first 3 times are not counting, but start to record after that. Make sure the 5 recorded torque values are within accuracy ±4%.</p>	
Approval	Plant Manager : Edward Chang	QC Manager : Jack Tsai	Issue by : Jhih-Yao

KABO TOOL COMPANY

Repair SOP

Work Station	Calibration Process	Issue Date:	Version:
		10/24/2016	A1
		Date Build:	PAGE/OF :
		10/24/2016	2/5
Process	Photo	Checking Points	
<p>5</p> <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 10px auto;">Turn to 160FT/LB</div>		<p>Unlock the push lock and turn the handle with clockwise direction to 160 FT/LB and then lock the push lock back.</p>	
<p>6</p> <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 10px auto;">Highest Torque value checking</div>		<p>Press the torque wrench, first 3 times are not counting, but start to record after that. Make sure the 5 recorded torque values are within accuracy $\pm 4\%$.</p>	
<p>7</p> <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 10px auto;">Turn to 80FT/LB</div>		<p>Unlock the push lock and the handle with counter-clockwise direction to lowest torque value (80FT/LB) and lock the push lock back.</p>	
<p>8</p> <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 10px auto;">Loosen handle screw</div>		<p>Use one Allen wrench (2.5mm) to loosen both right handle screw and left handle screw.</p>	
Approval	Plant Manager : Edward Chang	QC Manager : Jack Tsai	Issue by : Jhih-Yao

Work Station			
Work Station	Calibration Process	10/24/2016	Version:
		Date Build:	A1
		10/24/2016	PAGE/OF :
		Issue Date:	3/5
Process	Photo	Checking Points	
9 <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 10px auto;">Draw back handle module</div>		After loosening the handle screws, pull the handle and push lock together out.	
10 <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 10px auto;">Calibrate first point torque value</div>		Put push lock on propulsive post to calibrate 80FT/LB in between 80 to 83FT/LB. <ul style="list-style-type: none"> ● Clockwise direction is adjusting to higher torque value and counter-clockwise direction is adjusting to lower torque value. 	
11 <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 10px auto;">Make sure Torque value</div>		Put push lock into positioning ring to make sure the value 80 FT/LB.	
12 <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 10px auto;">Turn to 160FT/LB</div>		Pull out the push lock and turn 288 degree with clockwise direction, then put the push lock back to positioning ring.	
Approval	Plant Manager : Edward Chang	QC Manager : Jack Tsai	Issue by : Jhih-Yao

Work Station			
Work Station	Calibration Process	10/24/2016	Version:
		Date Build:	A1
		10/24/2016	PAGE/OF :
		Issue Date:	4/5
Process	Photo	Checking Points	
13	<div style="border: 1px solid black; padding: 5px; width: fit-content; margin-bottom: 10px;">Check Highest Torque value</div> 	<p>Make sure Highest Torque value (160FT/LB) accuracy is within +/-4%. If not between +/-4% ranges, you will need to adjust the torque value again.</p>	
14	<div style="border: 1px solid black; padding: 5px; width: fit-content; margin-bottom: 10px;">Loosen side screw</div>  	<p>Use flat-head screwdriver to loosen side screw on tube for preparing to adjust the torque value.</p>	
15	<div style="border: 1px solid black; padding: 5px; width: fit-content; margin-bottom: 10px;">Calibrate highest Torque value</div> 	<p>Use Allen wrench (3mm) insert the adjusting screw to calibrate 160FT/LB in between 161 to 165FT/LB.</p> <ul style="list-style-type: none"> ● Clockwise direction is adjusting to lower torque value and counter-clockwise direction is adjusting to higher torque value. 	
16	<div style="border: 1px solid black; padding: 5px; width: fit-content; margin-bottom: 10px;">Turn to 80FT/LB</div>  	<p>Pull the push lock and turn 288 degree with counter-clockwise, then turn to 80FT/LB and put the push lock to connect with positing ring. Make sure the torque value is correct and then pull out the push lock for preparing to install the handle module.</p>	
Approval	Plant Manager : Edward Chang	QC Manager : Jack Tsai	Issue by : Jhih-Yao

Work Station			
Work Station	Calibration Process	10/24/2016	Version:
		Date Build:	A1
		10/24/2016	PAGE/OF :
		Issue Date:	5/5
Process	Photo	Checking Points	
17 <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 0 auto;">Handle module assembly</div>		<p>Put push lock into the handle tube. Please pay attention to the direction of both handle tube and push lock. Kindly see the demo photo carefully, handle module will insert the tube, but the push lock need to connect positioning ring.</p>	
18 <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 0 auto;">Fasten handle screw</div>		<p>Fasten both right and left side handle screw. During the process, please make sure whether push lock is pushed in the end and whether push lock is hold together with the handle tube.</p>	
19 <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 0 auto;">Check lowest, middle and highest Torque value</div>		<p>Check lowest, middle and highest torque value (80, 120 and 160 FT/LB). The first 3 times are not counting, but after the first 3 times, the following 5 times need to be recorded and make sure the accuracy is within +/-4%.</p>	
20 <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 0 auto;">Lock side screw</div>		<p>Turn the handle back to first point value (80FT/LB), and lock side screw of the tube. To set the scale ring into the handle tube and then the process is done.</p>	
Approval	Plant Manager : Edward Chang	QC Manager : Jack Tsai	Issue by : Jhih-Yao