INTE-AUTO

SHENZHEN INTE-AUTO Co., LTD

Standard Product Work Instruction

Product Name	2P Series Fixed Receptacle Final Assembly		
Document No.	INTE-SOP-2P-02	Preparation Date	2024/3/21
Process Name	Final Assembly	Standard Time/s	60S
Process No.	2P-002	Standard Output/h	60PCS

Work Procedure:

I. Preparation Before Assembly

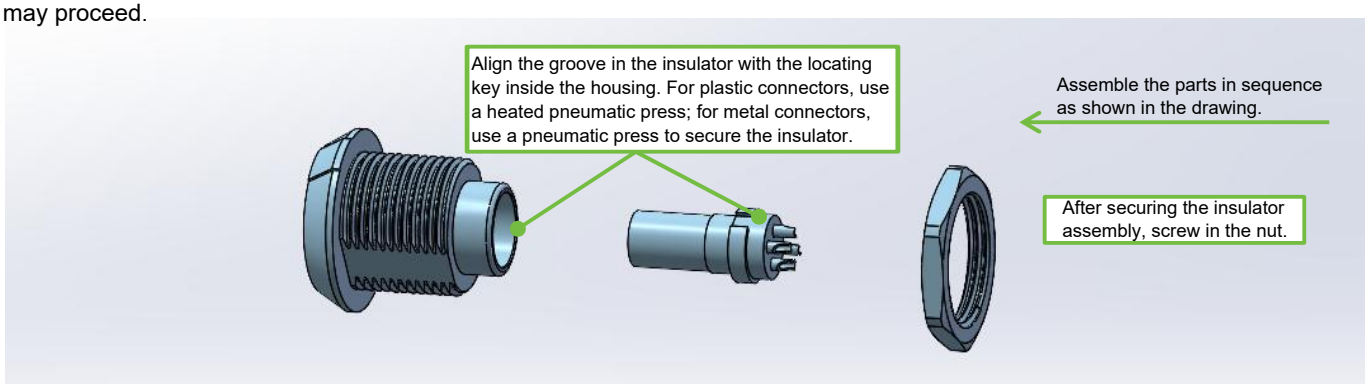
① Prepare the required product parts and materials. Keep the workbench clean and organized, and remove any unrelated parts or foreign objects.

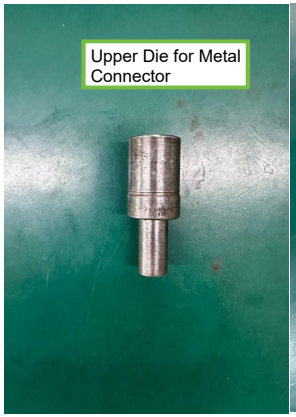
② Before assembly, operators must wear finger cots to prevent scratches or contamination on the connector housing.

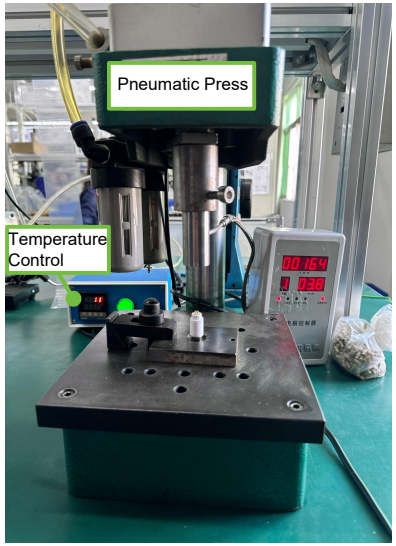
II. Assembly Procedure

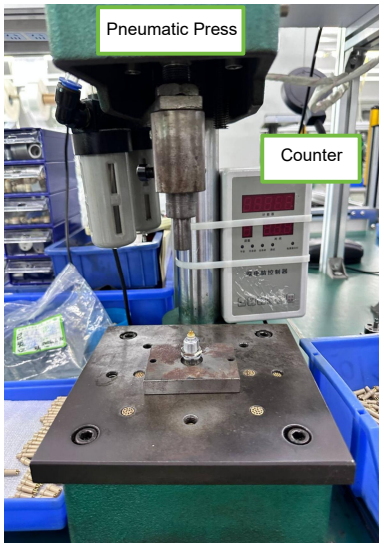
① Install the required parts into the housing in sequence as shown in the drawing.

② After the first assembled sample has been inspected and confirmed by the production team leader, continuous production may proceed.









III. Precautions

① Mate the assembled receptacle with the corresponding plug and verify that mating and unmating are smooth.

② Check the finished product number to ensure that it is correct

Quality Requirements

1. Check whether all product materials comply with the drawing requirements and meet the specified work standards.
2. Check whether the assembled finished product complies with the drawing requirements, whether there is any appearance damage, whether the cable collet is correctly installed, and confirm that the finished product meets the customer order requirements.

(Refer to the Assembly Drawing)

Assembly Materials

NO.	Part Name	Specification	QTY
1	Outshell		1
2	Insulator & contact		1
3	Hex Nut		1
4			
5			
6			
7			
8			
9			
10			
11			
12			
13			
14			
15			
16			
17			
18			
19			
20			

Fixtures / Jigs		Inspection Tools / Instruments	
1	Plastic Connector Mold	1	Caliper
2	Metal Connector Mold	2	Mating Plug
3	Pneumatic Press	3	Visual Inspection

Approved by		Reviewed by		Prepared by	Liu Jingcheng		Total 1 Page	Revision	Rev. A0