



WORK INSTRUCTION
OFFLINE ASSEMBLY PROCESS

Effectivity Date:

September 30, 2022

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

TP1 / 7L0091-7022

Customer:

TRQSS

Document No.:

WI-ENG-PDE-136

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

3

Page No.:

1 of 3

PARTS:

1. Connector 7282-1020 (W)

JIG:

1. Insertion jig with switch cover

| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|-----|---|--|---|---|
| 1 | n/a Connector setting to insertion jig 7282-1020 (W) | <p>Insertion jig w/ switch cover</p> <p>Y L=319±2mm wire</p> <p>B L=387±2mm m wire</p> <p>Insertion jig</p> <p>I-mark</p> <p>Holes</p> <p>Visual reference</p> <p>Lock</p> <p>Button</p> <p>Connector orientation</p> <p>Press</p> <p>Release</p> <p>Guide</p> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector (7282-1020) into jig using right hand and release the lock.</p> <p>3. Push the guide using left hand. The slot for Black wire will be opened.</p> | <p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping</p> <p>1. Maintain and always practice 5's.</p> <p>2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> | <p>1. Use the provided jig per model</p> <p>2. No wrong orientation of connector</p> <p>3. No wrong use of connector.</p> <p>4. No damage Connector.</p> <p>Connector Orientation Illustration</p> <p>I-mark is align</p> <p>1 hole is only open</p> <p>I-mark is not align</p> <p>All holes are open</p> <p>CONNECTOR ILLUSTRATION</p> <p>GOOD</p> <p>NG</p> <p>7282-1020 (W)</p> <p>7282-1028 (W)</p> |

Revision History

| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | Prepared by | Reviewed by | Approved by | Noted by |
|-----------|---------|---|-------------|-------------|---------------|-----------|-------------|--------------|-------------|----------|
| 09/30/22 | 3 | Change Document Name/Title from Kitting Assembly Process to Offline Assembly. Improve: procedure/Illustration on process no.1, 2 and process 3 for proper checking of connector lock. Quality pointers and notes on pg. 1, 2, and 3 | M. Ariola | J. Loterte | C. Villanueva | A. Arañes | | | | |
| 02/19/22 | 2 | Change part number due to design change. | D. Castillo | R. Peñaloza | A. Shimamura | A. Arañes | | | | |
| 10/24/20 | 1 | Remove cycle time and changed locking tool from gluestick to pushing jig. | D. Castillo | R. Peñaloza | A. Shimamura | A. Arañes | | | | |
| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | Est. Date: | Jul 07, 2020 | | |

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WORK INSTRUCTION

Process Name/Title: OFFLINE ASSEMBLY PROCESS

Model Code/Part Number: TP1 / 7L0091-7022

Customer: TRQSS

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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Revision No.:

3

Page No.:

2 of 3

PARTS:

1. AVSSf 0.3 Y L=319±2mm
2. AVSSf 0.3 B L=387±2mm

JIG

1. insertion jig

NO.

PROCESS NAME

3 WORK PROCEDURE/ ILLUSTRATION

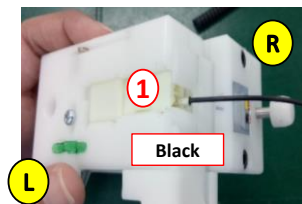
TOOLS/PPE

QUALITY POINTERS

2

n/a

Wire insertion to
Connector
7282-1020 (W)



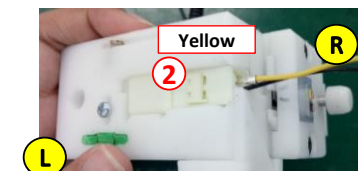
1. Get **Black wire** then insert to terminal slot ① using right hand and insert to connector



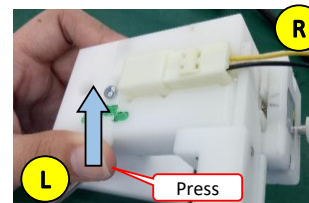
Wire facing



2. Press the button using left hand. The slot for **Yellow wire** will be opened.



3. Get **Yellow wire** then insert to terminal slot ② using right hand.



4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.

n/a

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

3 **Important reminders/Note/s:**
1. Make sure wires are properly inserted.
Conduct Pull-Push-Pull-Push after insertion.
Do not exert extra force.
2. Please hold the wire near terminal.

3 **Document references:**
1. Refer to WI-PRO-CNC-017 for Wire and strip length tolerance.
2. Refer to GL-PRO-ASY-029 For Pull-Push procedure.

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WORK INSTRUCTION

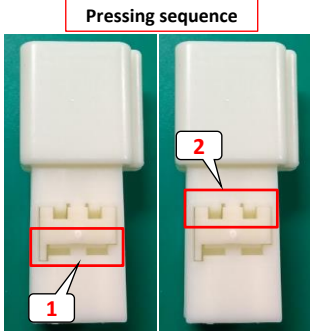
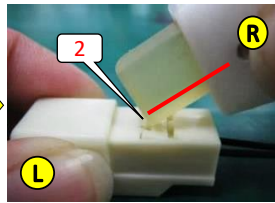
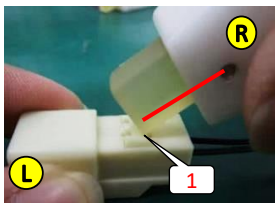
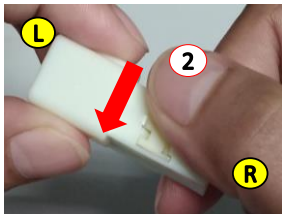
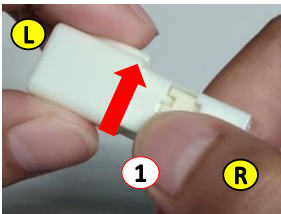
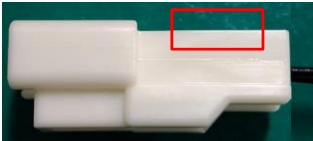
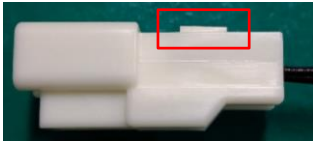

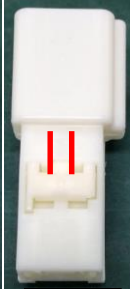
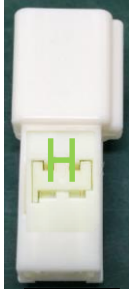
TAPING ASSEMBLY PROCESS

| | | | |
|-------------------|--------------------|-----------|--------|
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| Validity Date: | n/a | | |
| Document No.: | WI-ENG-PDE-136 | | |
| Revision No.: | 3 | Page No.: | 3 of 3 |

Process Name/Title: **TP1 / 7L0091-7022** Customer: **TRQSS**

Model Code/Part Number: **TP1 / 7L0091-7022**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

| | | | | | |
|--------|--------------|--|--|---|--|
| PARTS: | | 1. Assy parts | | JIG | 1. Pushing jig |
| NO. | PROCESS NAME | 3 WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 3 | n/a | <div><div>Pressing sequence</div><div></div><div></div><div>1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on the above illustration. Push the lower part of the connector lock first and then push the upper part.</div><div></div><div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div><div><div>Before pressing</div><div>After pressing</div><div></div></div></div> | | <div>Pushing jig</div> <div></div> | <div>3 Important reminders/Note/s:</div> <div>1. Manual locking may cause damaged connector lock.</div> <div>2. Use the provided jig tool to lock the connector.</div> <div>3. Position of pushing jig during locking must be slanted</div> <div>1. No unlocked/half-locked connector</div> <div>2. No damage connector</div> <div>3 LOCKED CONDITION</div> <div></div> <div>GOOD NG</div> |

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