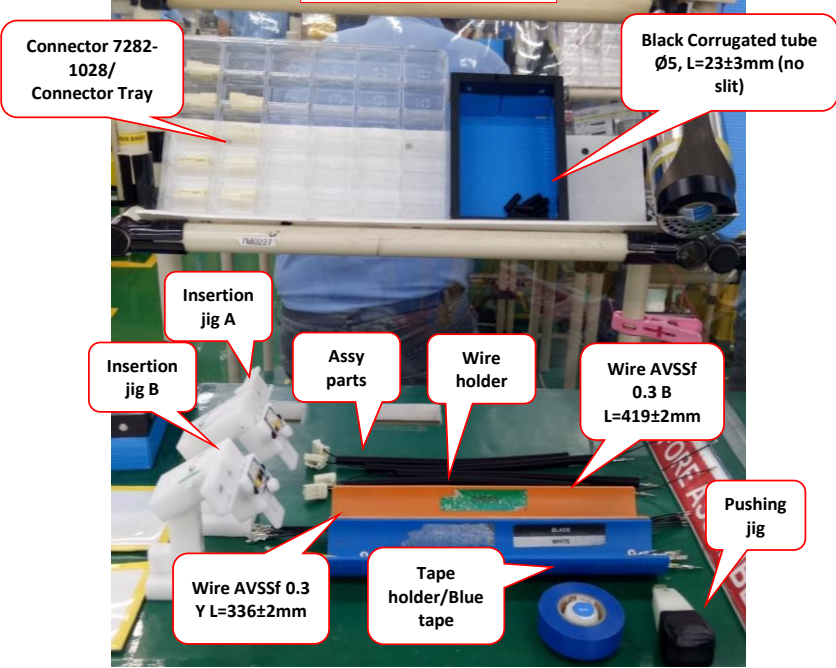
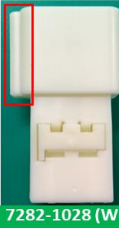
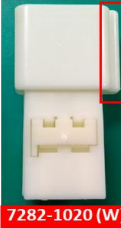
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	Process Name/Title: Taping Assembly Process		Validity Date:	n/a	
	Model Code/Part Number: TM3 / 7L0112-7020	Customer: TRQSS	Document No.:	WI-ENG-PDE-322A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	3	Page No.:

PARTS:	1. Assy parts; Wire AVSSf 0.3 Y L=336±2mm; Wire AVSSf 0.3 B L=419±2mm; Black corrugated tube Ø5, L=23±3mm (no slit); Blue tape; Connector 7282-1028 (W)				JIG:	1. Insertion jig 2. Pushing jig				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS			
1	P1	<p style="text-align: center;">TABLE LAY-OUT</p> 				<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<p>1. No missing parts/tools 2. No excess parts/tools</p> <p>Document references: 1. Refer to WI-PRO-CNC for Wire and Strip length tolerance</p> <p style="text-align: center;">CONNECTOR ILLUSTRATION</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <p>GOOD</p>  <p>7282-1028 (W)</p> </div> <div style="text-align: center;"> <p>NG</p>  <p>7282-1020 (W)</p> </div> </div>		
Revision History										
04/24/23	3	Inclusion of quality checkpoints				J. Loterte	C. Villanueva	A. Arañes	n/a	Prepared by Reviewed by Approved by Noted by
10/07/22	2	Improve quality pointers: Reminders/notes and references on page no.1, 2, 3, 4, 6, 7, and 8 due to document improvement. Work procedure/illustration in process no.5 and 10 -Connector lock.				M. Ariola	J. Loterte	C. Villanueva	A. Arañes	
08/26/21	1	Transfer Jointed wire B-B 7L0112-2000 and Black corrugated tube (Ø7, L=257±3mm no slit) insertion to Kitting. Provide insertion jig. Change from pre-launch to masspro.				D.Castillo	C.Villanueva	A.Shimamura	A. Arañes	
08/10/21	0	Initial issue.				D.Castillo	C.Villanueva	A.Shimamura	A. Arañes	
Eff. Date	Rev. No	Details of Change				Revise	Review	Approve	Noted	Est. Date: August 10, 2021

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P1

Connector Setting to
insertion jig
7283-1138 (W)
(Assy parts)

Insertion jig

I-mark

Visual reference

Side wire guide

Push button

Lower wire guide

Insertion jig orientation

Connector Orientation

1. Push the lower wire guide using right hand.

2. Press the lock of insertion jig using left thumb.

3. Insert the connector **7283-1138 (W)** into jig using right hand and release the lock.

3. Check the hole/terminal slot for **Yellow wire**.

Press

Release

Hole

CONNECTOR ILLUSTRATION

GOOD

NG

7283-1138 (W)

7283-1030 (W)

n/a

1. Use provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

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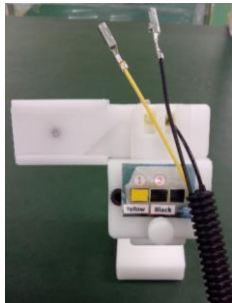
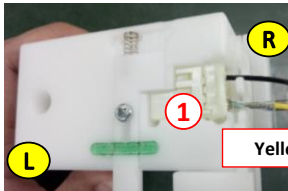

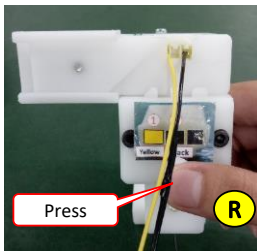
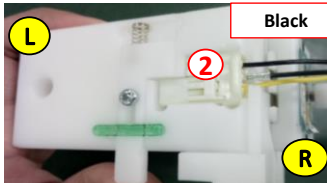
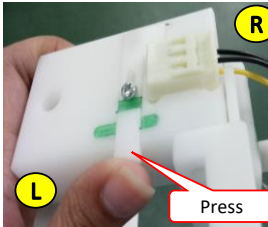
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Wire AVSSf 0.3 Y L=336±2mm 3. Wire AVSSf 0.3 B L=419±2mm			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3		   2. Get the 2 wires (Yellow L=336±2mm and Black L=419mm) and insert to assy part using right hand			n/a	1. No deformed terminal 2. No wrong usage of parts
4	P1	     1. Get the Yellow wire using right hand and insert to connector. 2. Press the button using right hand, the slot for Black wire will be opened. 3. Get Black wire and insert to connector using right hand. 4. After insertion, press 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 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 during insertion. 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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PARTS:

1. Assy parts

JIG

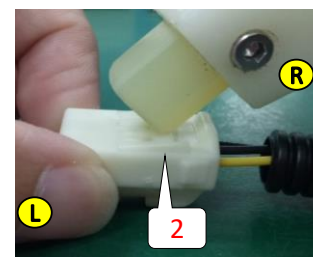
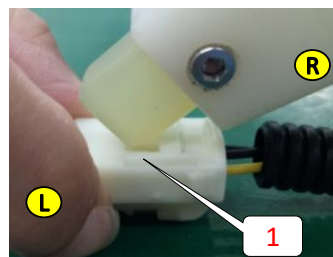
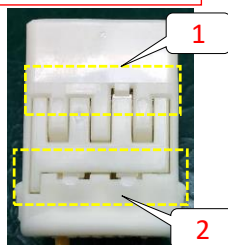
1. Pushing jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

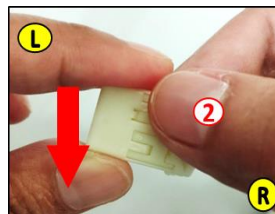
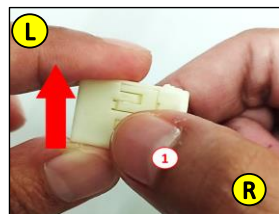
5

P1

Connector lock

LOCKING SEQUENCE

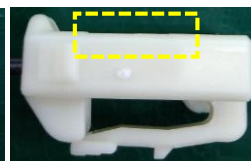
1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on above illustration. Push the lower part of the connector lock first and then push the upper part.



2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.



BEFORE PRESSING



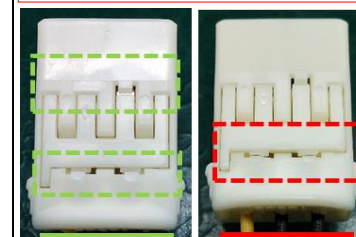
AFTER PRESSING

PUSHING JIG

1. No unlocked/half-locked connector
2. No damage connector

Important reminders/Note/s:

1. Use provided jig tool per model to avoid damaged lock.
2. Manual locking may cause damaged connector lock.
3. Position of pushing jig during locking must be slanted.

LOCK CONDITION

GOOD

NG

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PARTS:


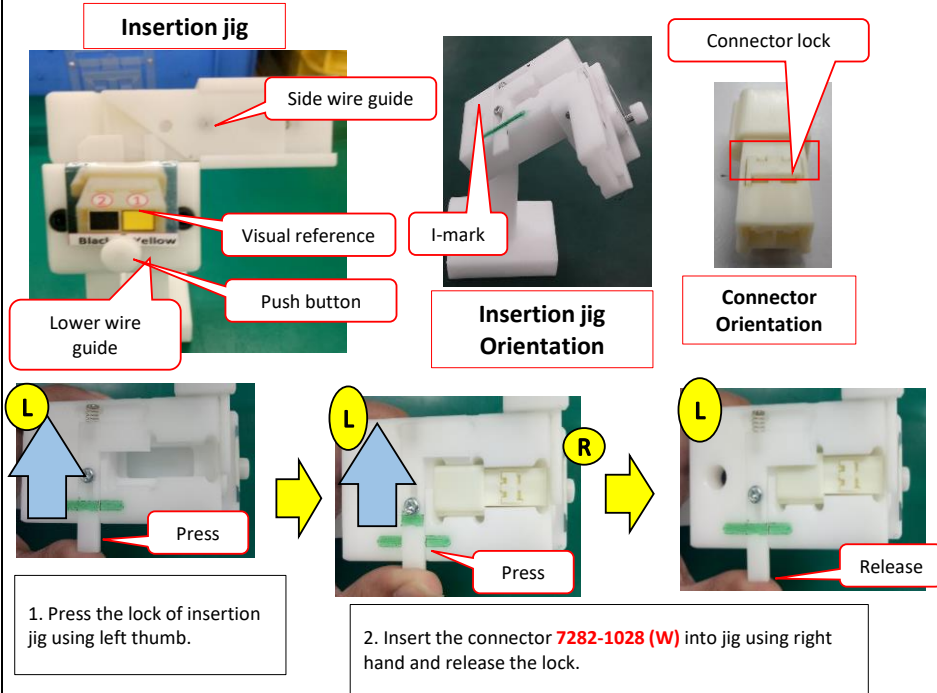

1. Assy parts

2. Black corrugated tube Ø5, L=23±3mm (no slit)

3. Connector 7282-1028 (W)

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Wire insertion to Assy parts (Ø5, L=23±3mm (no slit))	 <p>1. Get the corrugated tube Ø5 L=23±3mm using right hand then insert the Y and black jointed wire using left hand.</p>	n/a	1. No deformed terminal 2. No wrong usage of parts
7	P1 Connector setting to Insertion jig 7282-1028 (W)	 <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 7282-1028 (W) into jig using right hand and release the lock.</p>	n/a	 <p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>

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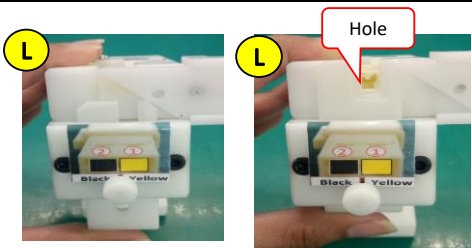
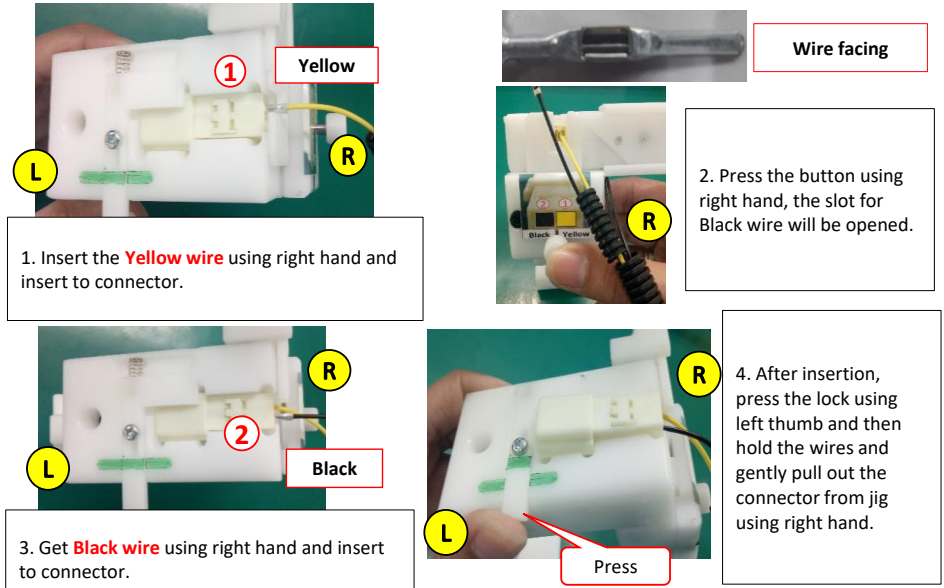
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PARTS:

1. Connector 7282-1028 (W)
2. Assy parts

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	Connector setting to Insertion jig 7282-1028 (W)	 <p>3. Push the lower wire guide using left hand, the slot for Yellow wire will be opened.</p>	n/a	<ol style="list-style-type: none">1. Use provided jig per model2. No wrong usage of parts3. No wrong orientation of connector4. No damaged connector
9	Wire insertion to connector 7282-1028 (W)	 <p>1. Insert the Yellow wire using right hand and insert to connector.</p> <p>2. Press the button using right hand, the slot for Black wire will be opened.</p> <p>3. Get Black wire using right hand and insert to connector.</p> <p>4. After insertion, press the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p>	n/a	<ol style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deformed terminal5. No wrong wire facing <p>Important reminders/Note/s:</p> <p>1. Make sure wires are properly inserted.</p> <p>Conduct Pull-Push-Pull-Push after insertion.</p> <p>Do not exert extra force.</p> <p>2. Please hold the wire near terminal during insertion.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

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PARTS:

1. Assy parts

JIG

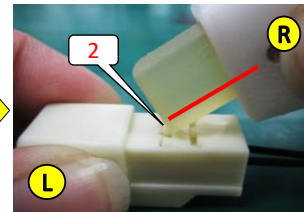
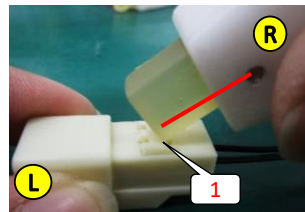
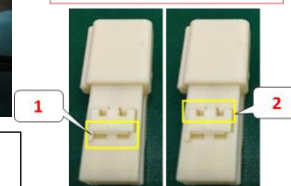
1. Pushing jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

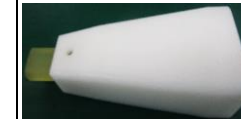
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P1

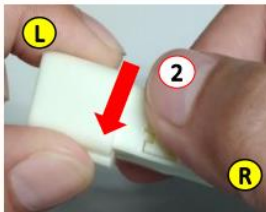
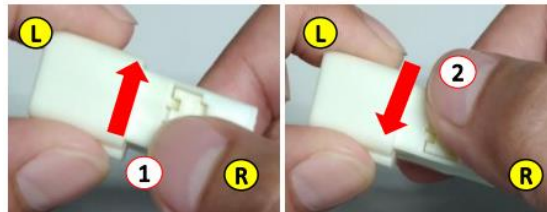
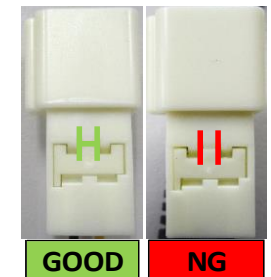
Connector lock

**Pressing Sequence**

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.

PUSHING JIG**Important reminders/Note/s:**

1. Manual locking may cause damaged connector lock.
2. Position of pushing jig during locking must be slanted

LOCK CONDITION

2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.

Before pressing**After pressing**

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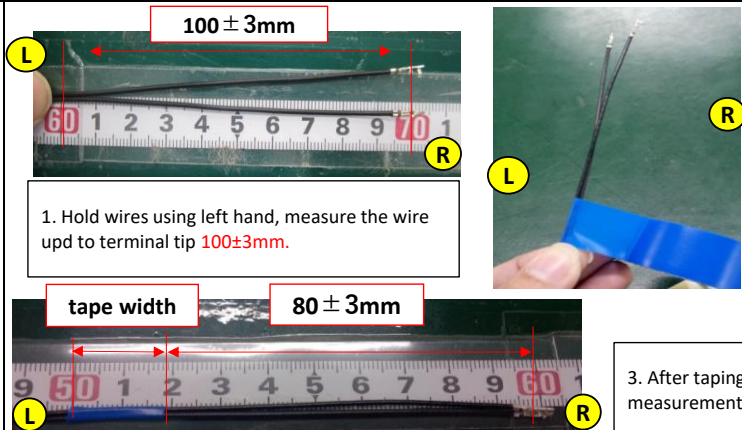

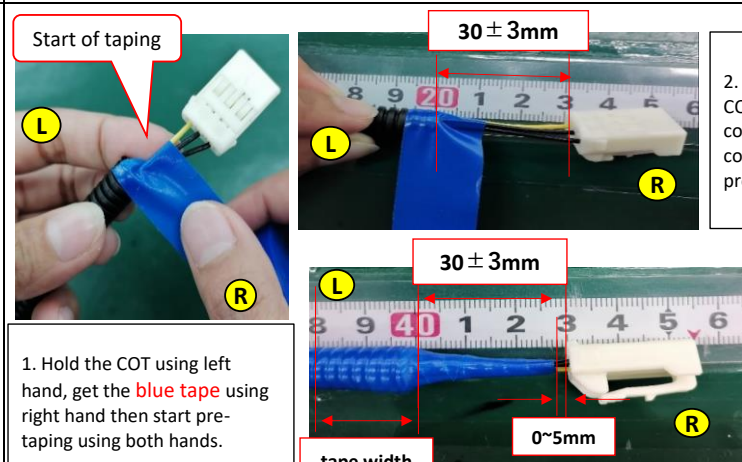

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PARTS:

1. Assy parts
2. Blue tape

JIG

1. Pushing jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	Spot taping	 <p>1. Hold wires using left hand, measure the wire up to terminal tip $100 \pm 3\text{mm}$.</p> <p>2. Get the Blue tape, conduct 2x windings of tape then cut using both hand.</p> <p>3. After taping, check the measurement and taping condition.</p>		<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>
12	P1 Taping 1 Black COT to wire near connector	 <p>1. Hold the COT using left hand, get the blue tape using right hand then start pre-taping using both hands.</p> <p>2. Measure from end of COT up to edge of connector $30 \pm 3\text{mm}$ then continue the taping process using both hands.</p> <p>3. After taping, check the measurement and taping condition.</p>		<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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PARTS:

n/a

JIG

n/a

3 QUALITY CHECKPOINTS

P1

7L0112-7020



GOOD



NO GOOD



GOOD



NO GOOD



7



GOOD



NO GOOD

① ② No Unlocked/ Half Locked Connector ⑤ No Missing Tape

③ ④ No Wrong Insert ⑥ No Missing Spot Tape ⑦ No Terminal Backing Out

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