

	WORK INSTRUCTION						Effectivity Date:		June 28, 2021	
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:			Product Name/Code: RE7 / 15F855-0050			Customer: TRP		Document No.: WI-ENG-PDE-022A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		5	Page No.: 1 of 4

PARTS:	1. Connector 505570-0600 (W) 2. AVSS 0.3 Black, Yellow, Green and Red L= 258mm	JIG:	1. Insertion jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Wire insertion to Connector 505570-0600 (W)	<div style="display: flex; flex-direction: column; align-items: center;"> <div style="display: flex; justify-content: space-around; width: 100%;"> <div style="text-align: center;"> <p>Insertion Jig</p> </div> <div style="text-align: center;"> <p>Connector orientation</p> </div> </div> <div style="display: flex; justify-content: space-around; width: 100%;"> <div style="text-align: center;"> <p>Wire sequence</p> </div> <div style="text-align: center;"> <p>Wire facing</p> </div> </div> <div style="display: flex; justify-content: space-around; width: 100%;"> <div style="text-align: center;"> <p>Before pressing</p> </div> <div style="text-align: center;"> <p>After pressing</p> </div> </div> </div> <p>1. Get the connector 505570-0600 and set it to jig using right hand. <i>Note: Follow the connector orientation.</i></p> <p>2. Press the lock button using left index finger. You will notice the holes that needs to be inserted are only open.</p> <p>3. Get R wire and insert to terminal slot using right hand, conduct pull test 2x. Repeat the process for G-Y- and B wires. <i>Note: Follow wire sequence based on visual reference attached on jig.</i></p>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<p>1. No removed wires or wrong insertion</p> <p>2. Must have slight movement after insertion</p> <p>3. No stuck-up terminal tip</p> <p>4. No deformed terminal</p> <p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force</p>


Revision History						Prepared by		Reviewed by	Approved by	Noted by
06/28/21	5	Removal of validity date.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
01/28/21	4	Change all wires length form 255mm to 258mm due to adjustment in over-all length from 243mm to 246mm as per costumer request; Change effectivity and validity date.	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
02/08/19	n/a	Previously established as Engineering Instruction (EI-ENG-PDE-068). Initial issue.	R. Alcantara	A. Shimamura	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	February 08, 2019		

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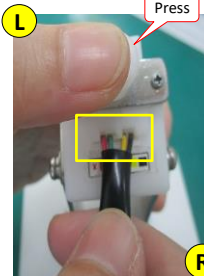
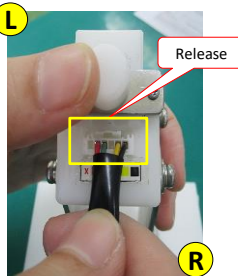

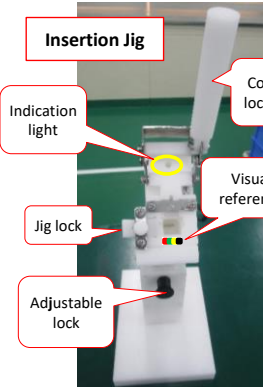
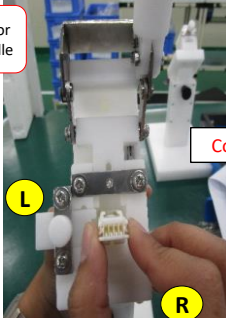
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	Process Name/Title: TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Product Name/Code: RE7 / 15F855-0050	Customer: TRP	Document No.:	WI-ENG-PDE-022A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	5	Page No.:

PARTS:	1. Black vinyl tube $\phi 6$ L=208 \pm 3mm 2. Connector 7282-5976 (W)	3. Assy parts	JIG	1. Insertion jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Vinyl tube $\phi 6$ L=208 \pm 3mm	 <p>1. Get the vinyl tube $\phi 6$ L=208\pm3mm using right hand and insert the wires on tube using left hand.</p>  <p>3. Compare the wire insertion to visual aid then check the condition of terminal claw.</p>  <p>2. Press the unlock button using left thumb to release the lock. Then slowly remove the harness from jig.</p> 	N/A	<p>1. No wrong use of parts 2. Terminal claw must be seen in connector holes</p> 
3	Connector setting Connector 7282-5976 (W)	 <p>Indication light</p> <p>Connector lock handle</p> <p>Visual reference</p> <p>Jig lock</p> <p>Adjustable lock</p>  <p>Connector lock</p> <p>Press</p> <p>Connector Orientation</p> <p>1. Get the connector and insert to jig using right hand.</p> <p>2. Press the lock using right thumb after insertion</p>	N/A	<p>1. No wrong setting of connector</p>

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Product Name/Code: **RE7 / 15F855-0050**

Customer: **TRP**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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n/a

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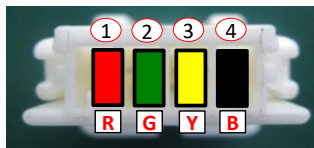

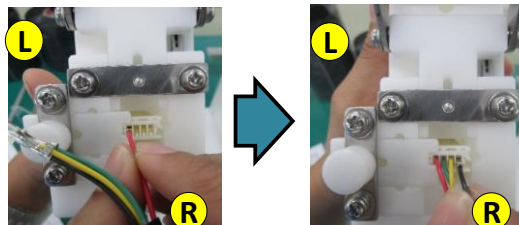
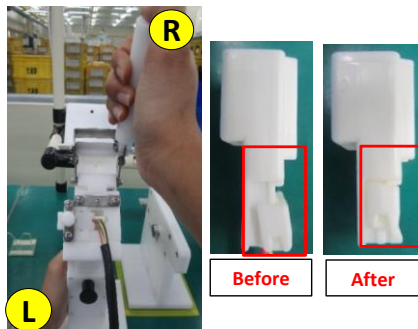
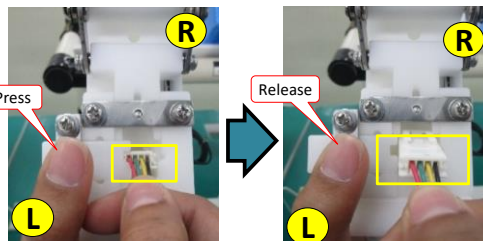
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PARTS:		1. Connector 7282-5976 (W) 2. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Wire Insertion to Connector 7282-5976 (W)	<div><div>Wire sequence</div><div>Wire facing</div></div> <div><div>1. Get the R wire and insert to terminal slot using right hand. Conduct pull test 2x. Repeat the process for G-Y and B wires. <i>Note: Follow wire sequence based on visual reference attached to jig.</i></div></div> <div>N/A</div> <td><div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing.</div><div>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion Do not exert extra force</div></td>	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing.</div> <div>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion Do not exert extra force</div>	
5	P1	Connector Lock	<div><div>Before</div><div>After</div></div> <div><div>2. Press the unlock button to release the lock using left thumb. Then slowly remove the harness from jig. Check the lock if properly pressed.</div></div> <div>N/A</div> <td><div>1. No unlock/half-locked connector</div></td>	<div>1. No unlock/half-locked connector</div>	

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts			JIG	N/A
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	Pass WIP to P2	 <div>Put WIP to WIP holder. Note: One Piece Flow</div>		n/a	1. No WIP overflow

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