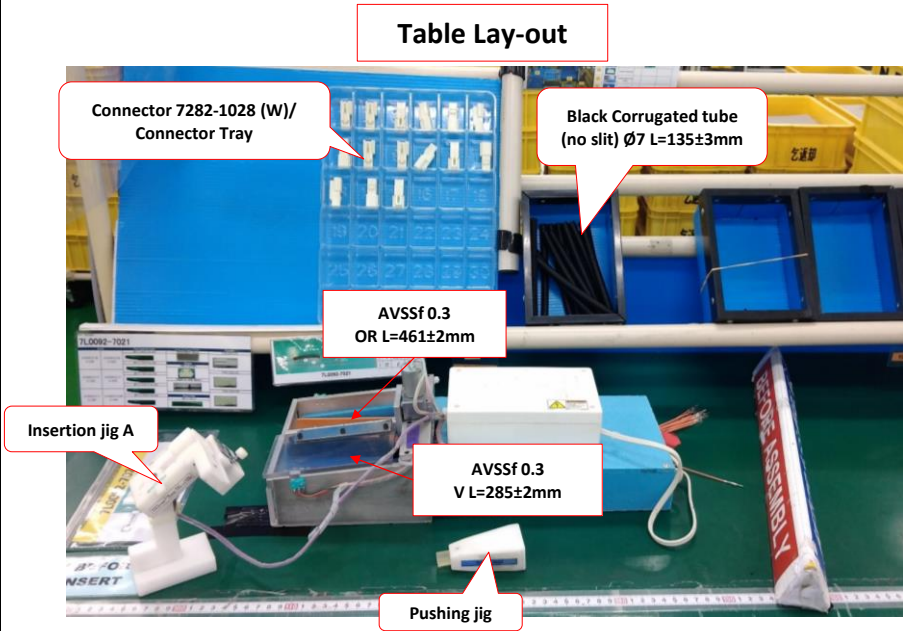





	WORK INSTRUCTION OFFLINE ASSEMBLY PROCESS				Effectivity Date:		October 07, 2022	
	Process Name/Title:				Validity Date:		n/a	
	Model Code/Part Number: TP1 / 7L0092-7021		Customer: TRQSS		Document No.:		WI-ENG-PDE-062	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		8	Page No.:	1 of 5	

PARTS:	1. All parts: Connector 7282-1028 (W); AVSSf 0.3 OR L=461±2mm; AVSSf 0.3 V L=285±2mm; Black Corrugated tube (no slit) Ø7 L=135±3mm			JIG:	1. Insertion jig with switch cover 2. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	n/a	<p>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 workplace 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>Document reference/s:  8 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History								Prepared by	Reviewed by	Approved by	Noted by		
10/07/22	8	Improve quality pointers and notes in: Process no.1,2,3 and 4 as document improvement. Work procedure and illustration in locking process in process no.4.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes	 M. Catapang	 J. Loterte	 C. Villanueva	 A. Arañes
04/02/22	7	Additional table lay-out. Change document title from Kitting assembly process to Offline assembly process.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
10/27/21	6	Change locking tool from gluestick to pushing jig. Additional checkpoint in checking of wire tolerance. Improve work procedure and illustration on Page3.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	January 03, 2020		

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WORK INSTRUCTION

Process Name/Title: **OFFLINE ASSEMBLY PROCESS**

Model Code/Part Number: **TP1 / 7L0092-7021**

Customer: **TRQSS**

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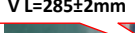










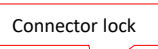

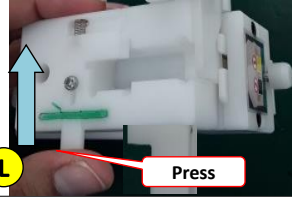
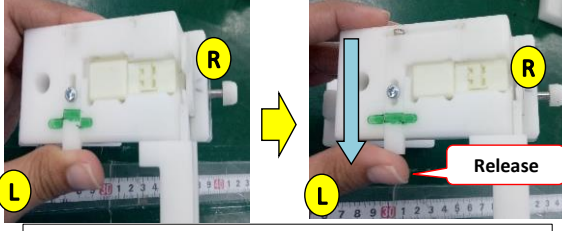
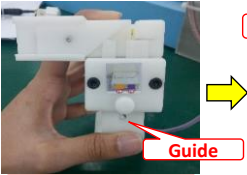
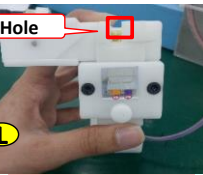
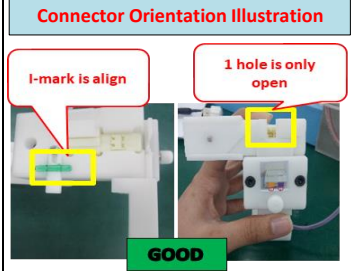


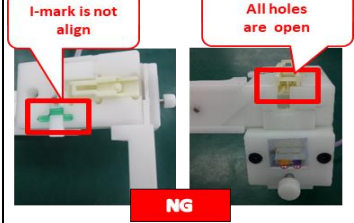


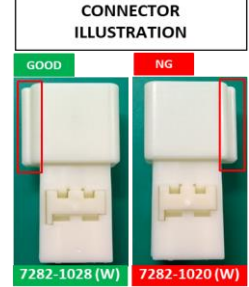
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PARTS:	1. Connector 7282-1028 (W)			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a Connector setting to insertion jig 7282-1028 (W)	<div>             </div> <div> Press 1. Press the lock of insertion jig using left thumb.</div> <div> Release 2. Insert the connector 7282-1028 (W) into jig using right hand and release the lock. <i>Note: Follow the connector orientation</i></div> <div> BEFORE PRESSING  AFTER PRESSING 3. Push the guide using left hand. The slot for OR wire will be opened.</div>		n/a	<div> GOOD  </div> <div> NG  </div> <div> GOOD NG 7282-1028 (W) 7282-1020 (W)</div> <div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>

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WORK INSTRUCTION

Effectivity Date:

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Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

TP1 / 7L0092-7021

Customer:

TRQSS

Document No.:

WI-ENG-PDE-062

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


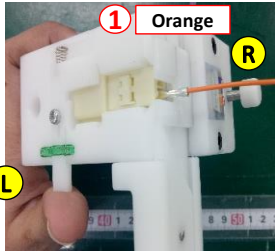
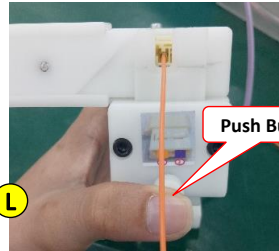
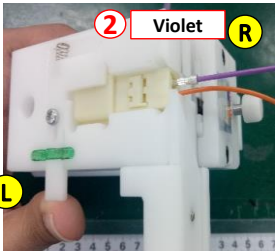
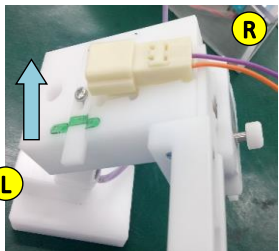
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PARTS:		1. AVSSf 0.3 OR L=461±2mm 2. AVSSf 0.3 V L=285±2mm	JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a Wire insertio to connector 7282-1028 (W)	<div><p>WIRE FACING</p></div> <div><p>1. Get the OR wire, then insert to terminal slot 1 using right hand.</p></div> <div><p>2. After insertion of OR wire press the button using left thumb. The slot for V wire will be opened.</p></div> <div><p>3. Get the V wire, then insert to terminal slot 2 using right hand.</p></div> <div><p>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.</p></div>	n/a	<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>8</div> <div>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>

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WORK INSTRUCTION

Process Name/Title: **OFFLINE ASSEMBLY PROCESS**

Model Code/Part Number: **TP1 / 7L0092-7021**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

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PARTS:

1. Assy parts

JIG

1. Pushing jig

NO.

PROCESS NAME

8 WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

n/a

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.

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

Before pressing **After pressing**

8

Important reminders/Note/s:

1. **MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR**
2. Use the provided jig tool to lock the connector.
3. Position of pushing jig during locking must be slanted

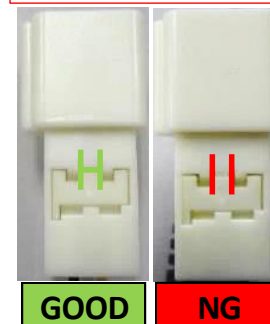
Pushing jig



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

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LOCKED CONDITION



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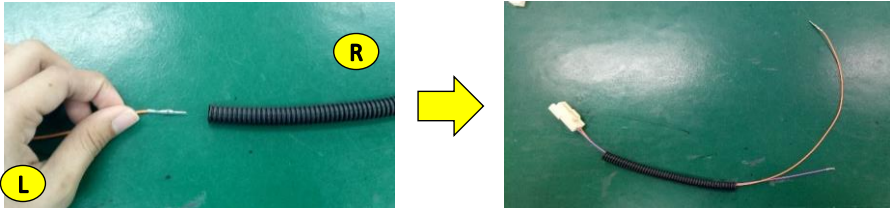
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PARTS:		1. Assy parts 2. Black Corrugated tube (no slit) Ø7 L=135±3mm			JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	n/a	Wire insertion to Black Corrugated tube (no slit) Ø7 L=135±3mm	<div><div>1. Get the black corrugated tube Ø7 L=135±3mm using right hand then insert the OR and V wire using left hand.</div></div>			1. No wrong usage of parts 2. No deformed terminal tip

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