

**WORK INSTRUCTION**

Effectivity Date:

October 7, 2022

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

TM3 / 7L0114-7020A

Customer:

TRQSS

Document No.:

WI-ENG-PDE-340

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

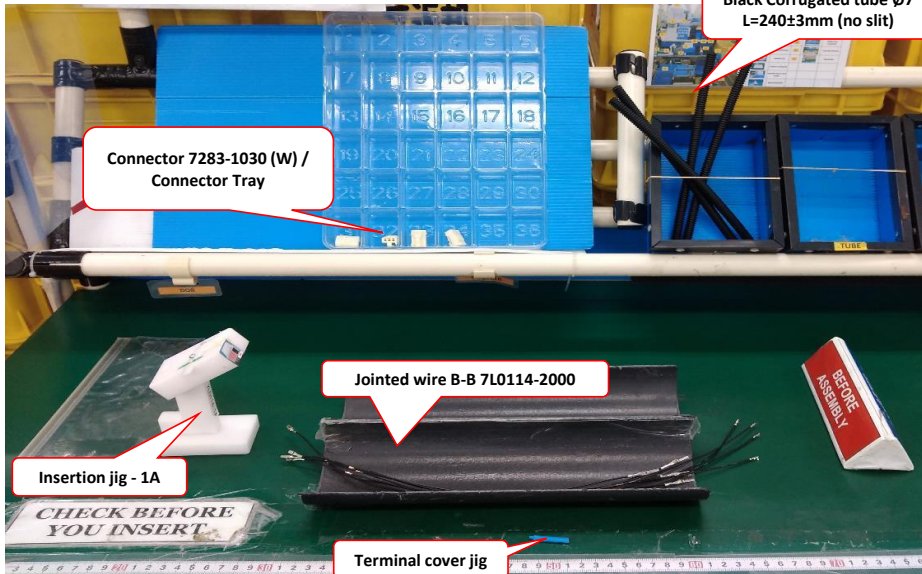
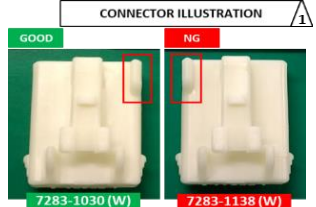
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PARTS:



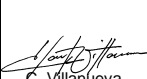

1. Connector 7283-1030 (W); Jointed wire B-B 7L0114-2000; Black corrugated tube Ø7 L=240±3mm (no slit)

JIG:

1. Insertion jig
2. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	Table Lay-out 	Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	<ol style="list-style-type: none">1. No missing parts/tools2. No excess parts/tools <p>Document references:</p> <ol style="list-style-type: none">1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. <p>CONNECTOR ILLUSTRATION</p> 

Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
10/07/22	1	Change Document name/title from 'Kitting Assembly Process' to 'Offline Assembly Process'. Improve quality pointers: Reminders/notes and references on page no.1, 2, and 3 due to document improvement.	M Ariola	J. Loterte	C. Villanueva	A. Arañes				
09/24/21	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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WORK INSTRUCTION OFFLINE ASSEMBLY PROCESS

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Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO		

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Connector setting to insertion jig 7283-1030 (W)	<p>Insertion Jig</p> <p>Insertion Jig Orientation</p> <p>Connector lock</p> <p>Connector Orientation</p> <p>Press</p> <p>Release</p> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 7283-1030 (W) using right hand and release the lock using left hand. <i>Note: Follow the connector orientation.</i></p> <p>3. Check the holes/terminal slot for Jointed wire (B).</p>	n/a	<p>Connector Orientation Illustration</p> <p>I-mark is align</p> <p>1 hole were only open</p> <p>GOOD</p> <p>I-mark is NOT align</p> <p>1 hole were open</p> <p>NG</p> <p>CONNECTOR ILLUSTRATION</p> <p>GOOD</p> <p>NG</p> <p>7283-1030 (W)</p> <p>7283-1138 (W)</p> <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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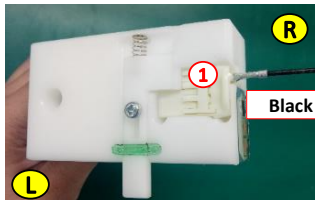




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PARTS:

1. Jointed wire B-B 7L0114-2000
2. Black corrugated tube Ø7 L=240±3mm (no slit)

JIG

1. Insertion jig
2. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Connector 7283-1030 (W)	 <p>1. Get Jointed wire then insert to terminal slot ① using right hand.</p> <p>2. After insertion, push the lock using left thumb 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 insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing <p>Important reminders/Note/s:</p> <ol style="list-style-type: none"> 1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted . Conduct Pull-Push-Pull-Push after insertion. <p>Document references:</p> <ol style="list-style-type: none"> 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4	Wire insertion to Corrugated tube Ø7, L=240±3mm (no slit)	 <p>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert to terminal.</p>  <p>2. Get the corrugated tube Ø7 L=240±3 (no slit) using right hand then insert the wires using left hand</p>  <p>3. After insertion, remove the terminal cover jig using right hand.</p>	<p>TERMINAL COVER JIG</p> 	<ol style="list-style-type: none"> 1. No wrong usage of parts 2. No deformed terminal

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