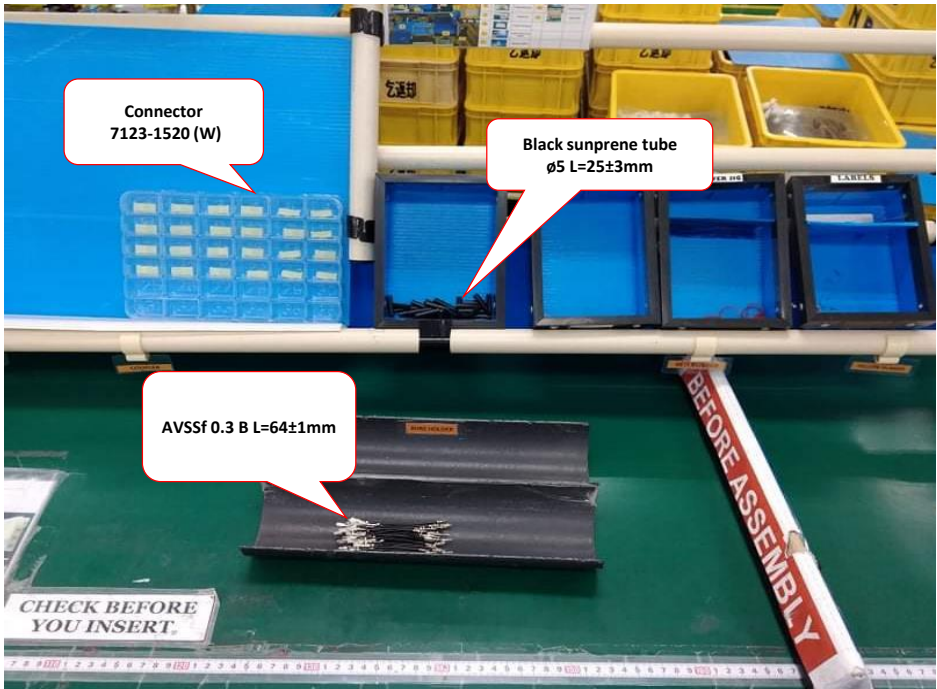



	WORK INSTRUCTION 2 OFFLINE ASSEMBLY PROCESS				Effectivity Date: June 9, 2023	
	Process Name/Title:				Validity Date: n/a	
	Model Code/Part Number: ES1 / 7M0511-7020B		Customer: TRJ		Document No.: WI-ENG-PDE-367	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.: 2 Page No.: 1 of 5	

PARTS:		1. All parts; Connector 7123-1520 (W); Black Vinyl tube Ø5 L=25±3mm; AVSSf 0.3 B L=64±1mm		JIG:	n/a
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 references; 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		
06/09/23	2	Inclusion of quality checkpoints, improvement of by two's inspection, important reminders and document references; change title from kitting assembly process to offline assembly process.				J.Loterte	C. Villanueva	A. Arañes	na	 J. Loterte	 C. Villanueva	 A. Arañes	n/a
11/25/21	1	Change from Pre-launch to Masspro. Additional checkpoint "Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance" Improve work procedure/ Illustration. Additional Table lay-out.				M.Ariola	J.Loterte	C.Villanueva	A. Arañes				
10/21/21	0	Initial Issue				M.Ariola	J.Loterte	C.Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Prepared	Reviewed	Approved	Noted	Est. Date:	October 21, 2021		

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WORK INSTRUCTION

Process Name/Title:

2 OFFLINE ASSEMBLY PROCESS

Model code/Part Number

ES1

/

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Customer:

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Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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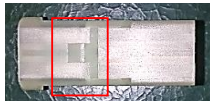



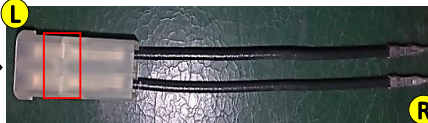


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PARTS		1.Connector 7123-1520 (W) 2.AVSSf 0.3 B L=64±1mm (2pcs.)			3. Black Vinyl Tube Ø5 L=25±3mm		Jig	n/a
No.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS
2	n/a	Wire Insertion to Connector 7123-1520 (W)	<div><div>CONNECTOR SETTING</div><div>WIRE FACING</div><div><div><p>1. Get the connector 7123-1520 (W) using left hand then get the Black wire and insert to terminal slot ① using right hand.</p></div><div><p>2. Get the Black wire then insert to terminal slot ② using right hand.</p></div><div><p>Note: Insertion of wire must be from left to right.</p></div></div></div>			n/a	<div>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</div> <div>Important reminders and Note/s; 1. Make sure wires are properly inserted. 2. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 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>	
3		Wire Insertion to Black Vinyl Tube Ø5 L=25±3mm	<div><div><p>1. Get the Black Vinyl Tube Ø5 L=25±3mm using right hand then insert the B-B wires using left hand</p></div><div></div></div>			n/a	<div>1.No wrong use of part. 2.No deformed terminal.</div>	

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PARTS

1. Assy parts.

Jig

n/a

No.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1. Check the connector

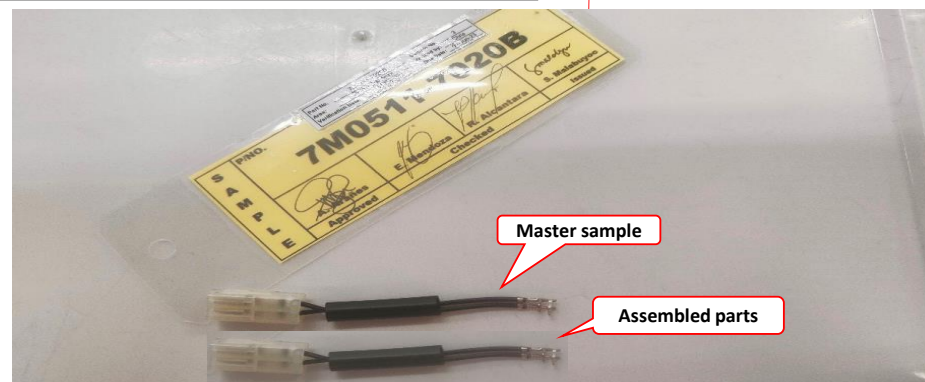
2. Check the presence of Vinyl Tube.

3. Check the terminal apperance, make sure no deformed terminal.



ACTUAL PRODUCT

4. Compare to Master Sample by tapping.



MASTER SAMPLE



n/a

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PARTS		1.Assy parts.			Jig	n/a
No.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	n/a	Measurement	<div><p>MEASURING TAPE</p></div>			<div><p>2</p><p>Important reminders and Note/s;</p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>2. FOR HATSUMONO AND OWARIMONO</p><p>1. No wrong Dimension.</p></div>

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PARTS

n/a

Jig

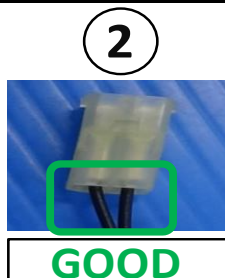
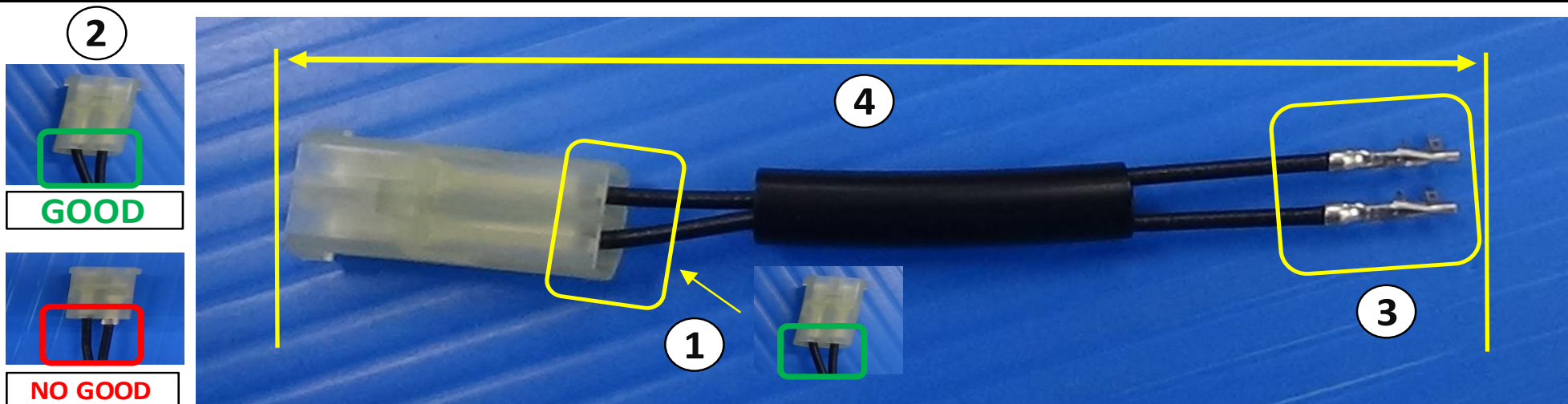
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QUALITY CHECKPOINTS

OFFLINE INSERTION

7M0511-7020B



1 No Wrong insert

2 No Terminal Backing Out

3 No Deform terminal

4 Check the Alignment

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