

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

September 30, 2022

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

TP1 / 7L0087-7021

Customer:

TRQSS

Document No.:

WI-ENG-PDE-049A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

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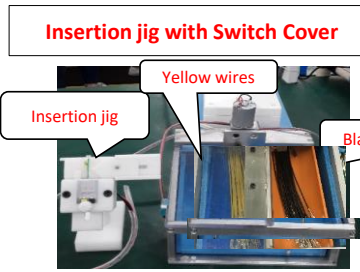

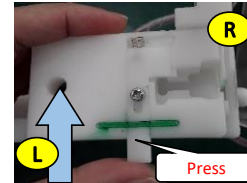
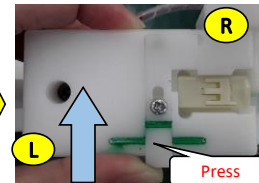

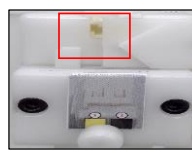

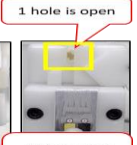


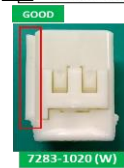
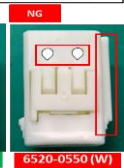
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PARTS:

1. Connector 7283-1020 (W)

JIG:

1. Insertion jig with switch cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Connector setting to insertion jig Connector 7283-1020 (W)	<div><p>Insertion jig with Switch Cover</p><p>Yellow wires</p><p>Black wires</p><p>Insertion jig</p><p>I-mark</p><p>Insertion jig orientation</p><p>Connector Orientation</p><p>Press</p><p>Press</p><p>Release</p><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 7283-1020 into jig using right hand and release the lock.</p><p>3. Check the holes/terminal slot for Y wire.</p></div>	<div><p>Safety Instruction</p><p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p><p>Housekeeping</p><p>1. Maintain and always practice 5's.</p><p>2. Personal things on the workplace is prohibited. Keep it in your locker.</p><p>Alert level</p><p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p></div>	<div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector.</p><p>4. No damage Connector.</p><p>Connector Orientation Illustration</p><p>I-mark was align</p><p>1 hole is open</p><p>GOOD</p><p>I-mark was not align</p><p>All holes are open</p><p>NG</p><p>CONNECTOR ILLUSTRATION</p><p>7283-1020 (W)</p><p>6520-0550 (W)</p></div>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
09/30/22	5	Improve quality pointers: Reminders/notes and references in process no.1, 2, 3, 5, 6, 7, and 8 due to document improvement. Work procedure/illustration in process no.3- Connector lock	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
02/22/21	4	Change part number	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
02/04/21	3	Change connector color in accordance with standardization for plastic parts; Update pictures using terminal cover jig, Put assy parts on parts section Pg. 3, 4, 5-8; Removal of cycle time; Conduct semi-annual review of doc's.	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	December 16, 2019		

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PROTOTYPE



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PARTS:

1. AVSSf 0.3 wires Y L=335mm; B L=418mm

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

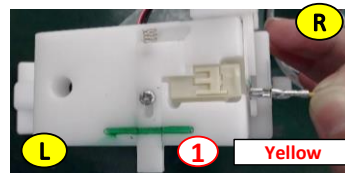
2

P1

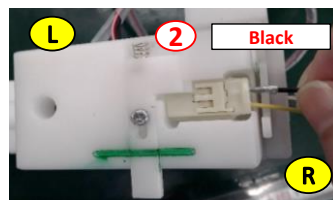
Wire Insertion to
Connector
7283-1020 (W)



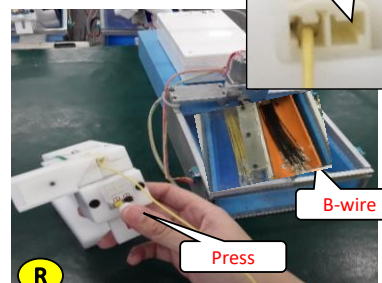
Wire facing



1. Get the **Yellow wire** from wire holder using right hand and insert to connector.



3. Get **Black wire** and insert to connector using right hand.



2. Press the button using right hand, the slot for Black wire will be opened.



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



Important reminders/Note/s:

1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Pull after insertion. Do not exert extra force.
2. Please hold the wire near terminal.



Document references:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
2. Refer to WI-ENG-PDE-017 for Wire and Strip length tolerance.

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

5

WORK PROCEDURE/ ILLUSTRATION

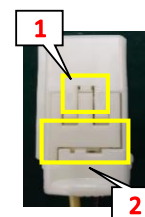
TOOLS/PPE

QUALITY POINTERS

3

P1

Connector Lock



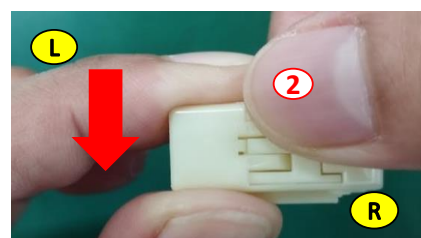
1. Get the **Glue stick** using right hand. Press the connector lock.
Note: Follow the sequence stated on the illustration.



BEFORE PRESSING

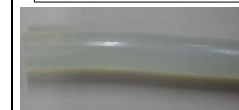


AFTER PRESSING



1. Get the **Glue stick** using right hand. Press the connector lock.
Note: Follow the sequence stated on the illustration.

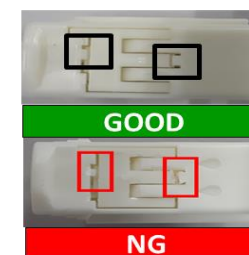
GLUE STICK



5 **Important reminders/Note/s:**

1. **Manual locking may cause damaged connector lock.**

5 **LOCKED CONDITION**



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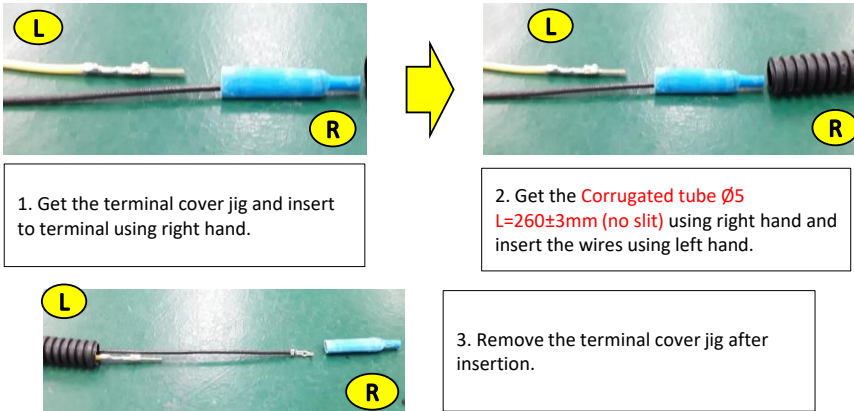

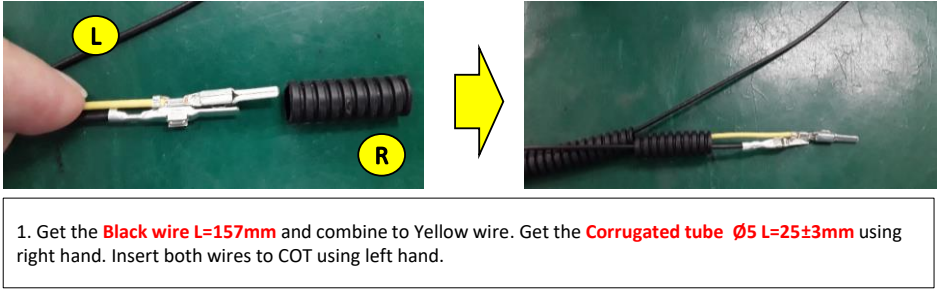
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PARTS:		1. Black Corrugated tube Ø5 L=260±3mm (no slit) 2. Assy parts 3. Black Corrugated tube Ø5 L=25±3mm (no slit)			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P1	Wire Insertion to Corrugated tube Ø5 L=260 ± 3mm				 1. No wrong use of parts 2. No deformed terminal
5		Wire insertion to Corrugated tube Ø5 L=25±3mm (no slit)				n/a 1. No wrong use of parts 2. No deformed terminal

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PARTS:

1. Connector 7282-7028 (W)

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

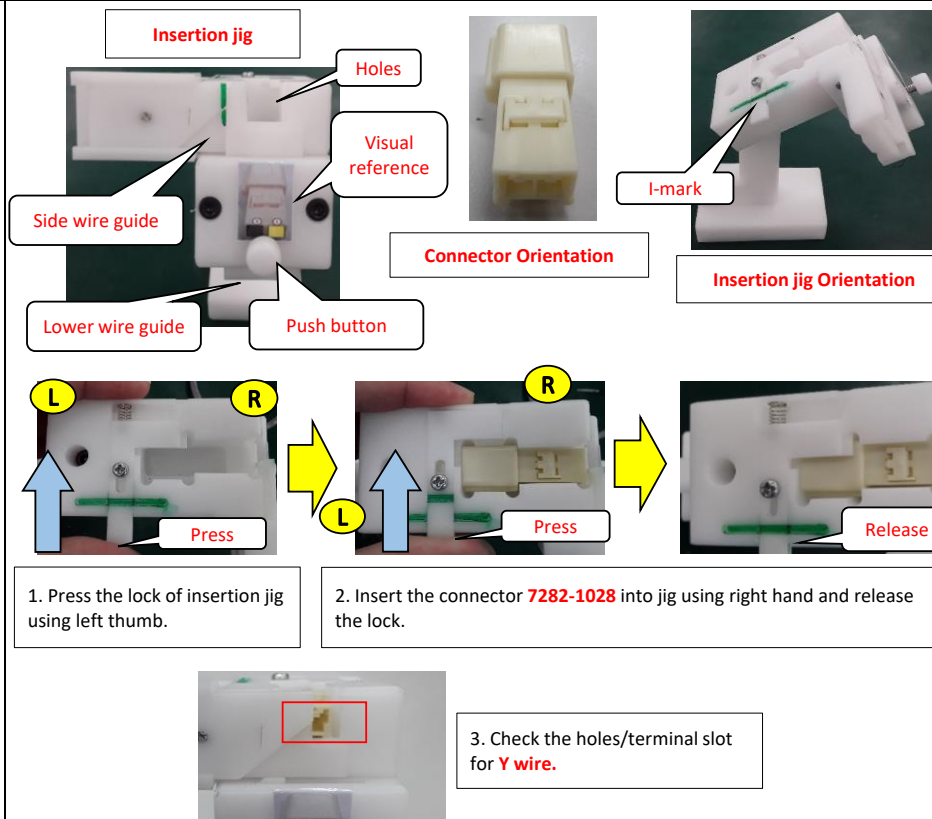
TOOLS/PPE

QUALITY POINTERS

6

P1

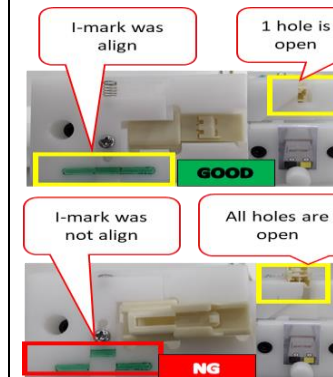
Connector setting to
Insertion jig
7282-1028 (W)



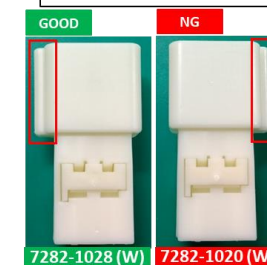
n/a

1. Use the provided jig per model
2. No wrong setting of connector

Connector Orientation Illustration



CONNECTOR ILLUSTRATION



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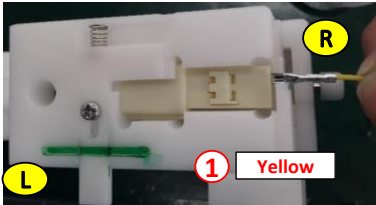

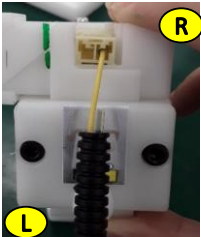
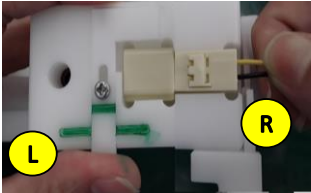
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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	<div><div>WIRE INSERTION</div></div> <div><div>1. Insert the Yellow wire using right hand and insert to connector.</div></div> <div></div> <div>2. Press the lower wire guide using right thumb. Get Black wire and insert to connector using right hand.</div> <div><div>3. After insertion, press the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div></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>5 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>5 Document references 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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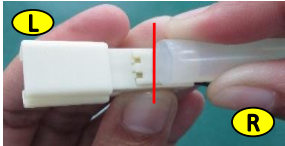
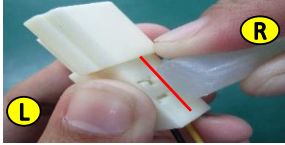
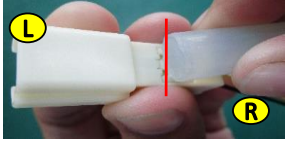
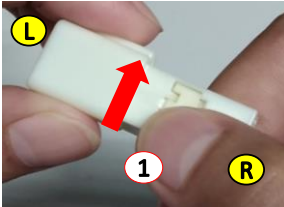
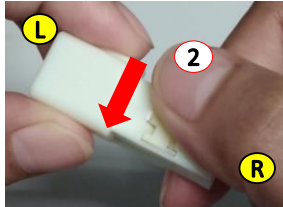
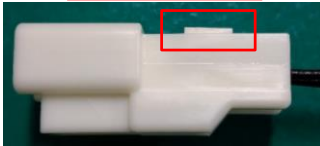
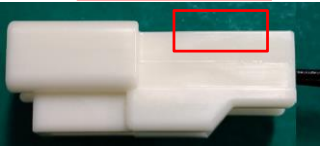

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PARTS:		1. Assy parts		JIG	n/a
NO.	PROCESS NAME	5 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	Connector lock	<div><p>1. Get the Gluestick using right hand and hold the connector using left hand and then push down the lower part of the connector lock using gluestick.</p><p>2. Push down the upper center part of the connector lock using gluestick.</p><p>3. Push down the upper part as a whole to properly lock the connector.</p><div><p>1</p><p>2</p><p>4. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div><div><div>Before pressing</div><div>After pressing</div></div></div>	<div>GLUE STICK</div> 	<div>5 Important reminders/Note/s:</div> <p>1. Manual locking may cause damaged connector lock.</p> <p>2. Position of gluestick must be slanted.</p>

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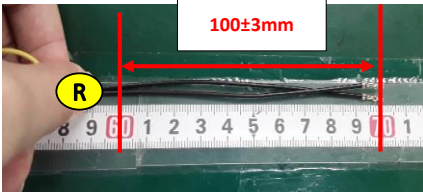

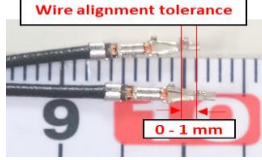
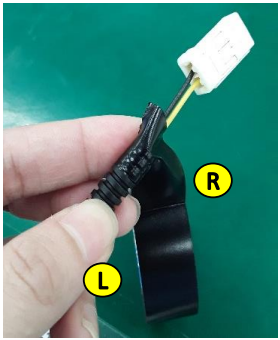

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PARTS:		JIG		
1. Black tape 2. Assy parts		n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1 Spot taping	 <p>100±3mm</p> <p>Conduct 2~3 winds spot taping</p> <p>1. Measure the wire to terminal tip 100mm, combine the wires and begin spot taping using both hands.</p>	<p>MEASURING TAPE</p> 	<p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong dimension</p> <p>⚠ Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Wire alignment tolerance</p>  <p>0 - 1 mm</p>
10	Taping 1 Corrugated tube to wire near connector	 <p>1. Hold the COT using left hand, get Black tape and start pre-taping using right hand.</p>	<p>MEASURING TAPE</p> 	<p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong dimension</p> <p>⚠ Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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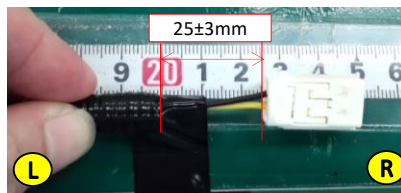
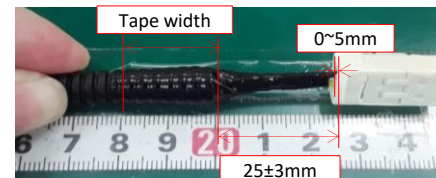





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PARTS:		1. Black tape 2. Assy parts		3. Black corrugated tube Ø5 L=65±3mm (no slit)		JIG	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS
10	P1	Taping 1 Corrugated tube to wire near connector (Continuation)	 <p>2. Hold the COT using left hand and measure the COT up to the end of connector 25mm, proceed on taping process.</p>	 <p>3. After taping, check the dimension and taping condition.</p>	<div>MEASURING TAPE</div> 	<div>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong dimension</div> <div>⚠ Important reminders/Note/s: 1. Please use calibrated/ verified measuring tape when getting thr measurement.</div>	
11		Wire insertion to corrugated tube Ø5 L=65±3mm (no slit)	 <p>1. Get the terminal cover jig using right hand then insert the 2 Black wires.</p> 	 <p>2. Get the Black corrugated tube Ø5 L=65±3mm (no slit) using right hand and insert the 2 Black wires.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>	<div>TERMINAL COVER JIG</div> 	<div>1. No wrong use of parts</div>	

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