



# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	September 30, 2022		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-056A		
Revision No.:	5	Page No.:	1 of 9

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

Model code/Part number: **TP1 / 7L0090-7022** Customer: **TRQSS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Connector 6520-0550 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	5 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1  Connectoer setting to insertion jig Connector 6520-0550 (W)	<div><div><div>Insertion jig with Switch Cover</div><div><div>Wire</div><div>Insertion</div><div>I-mark</div><div>Insertion jig orientation</div><div>Connector</div></div></div><div><div><div>Press</div><div>L</div><div>R</div></div><div><div>Press</div><div>L</div><div>R</div></div><div><div>Release</div><div>L</div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6520-0550 (W) into jig using right hand and release the lock.</div><div><div>3. Check the holes/terminal slot for Y wire.</div></div></div></div> <div><div><div>Safety Instruction</div><div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div></div><div><div>Housekeeping</div><div>1. Maintain and always practice 5's.</div><div>2. Personal things on the workplace is prohibited. Keep it in your locker.</div></div><div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div></div>		<div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector.</div><div>4. No damage Connector.</div></div> <div><div>5 Connector Orientation Illustration</div><div><div>I-mark was align</div><div>1 hole is open</div><div>I-mark was not align</div><div>All holes are open</div><div>GOOD</div><div>NG</div></div><div><div>5 CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div>NG</div><div>6520-0550 (W)</div><div>7283-1020 (W)</div></div></div></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: Work procedure/Illustration on process no. 1 to 12; Quality pointers and notes on pg. no. 1, 2, 3, 5, 6, 7, 8 and 9	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
02/22/21	4	Change part number.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
01/30/21	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:	Dec 16, 2019		

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☐ PROTOTYPE

☐ PRE-LAUNCH

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### PARTS:

1. AVSSf 0.3 wires Y L=580±3mm; B L=761±3mm

### JIG

1. Insertion jig with switch cover

### NO.

### PROCESS NAME

5

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### QUALITY POINTERS

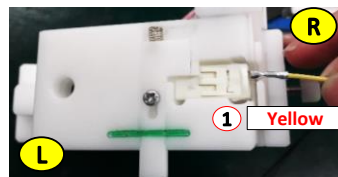
2

P1

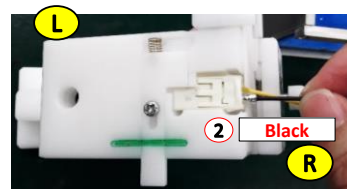
Wire Insertion to  
Connector  
6520-0550 (W)



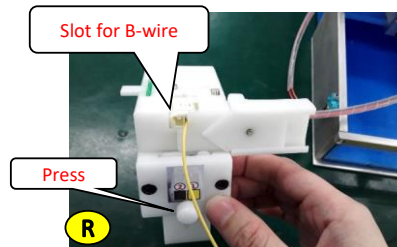
Wire facing



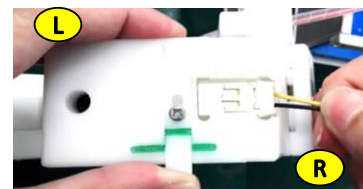
1. Get the **Yellow wire** from wire holder using right hand and insert to connector.



3. Get the **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

5

### Important reminders/Note/s:

1. No loose insertion
  2. No wrong insertion
  3. One by one insertion
  4. No deformed terminal
  5. No wrong wire facing
- 1. Make sure wires are properly inserted.**  
**Conduct Pull-Push-Pull-Push after insertion.**  
**Do not exert extra force.**
- 2. Please hold the wire near terminal.**

5

### Document reference:

1. Refer to WI-PRO-CNC-017 for Wire and strip length tolerance.
2. Refer to GL-PRO-ASY-029 For Pull-Push procedure.

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

5

WORK PROCEDURE/ ILLUSTRATION

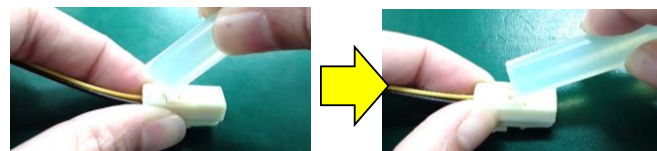
TOOLS/PPE

QUALITY POINTERS

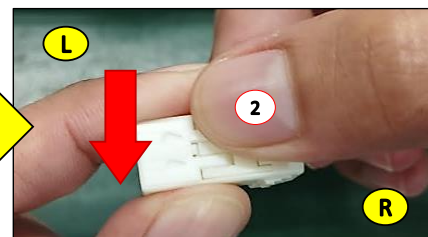
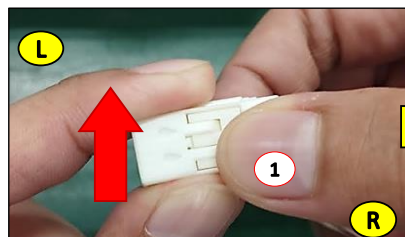
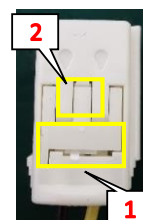
3

P1

Connector Lock



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



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

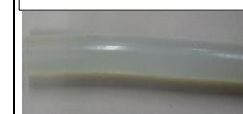


BEFORE PRESSING



AFTER PRESSING

GLUE STICK



5

Important reminders/Note/s:

1. Manual locking may cause damaged connector lock.

5

LOCKED CONDITION



GOOD



NG

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PARTS:		1. AVSSf 0.3 wire B L=255±2mm 2. Assy parts		3. Black Corrugated tube Ø5 L=25±3mm(no slit) 4. Black Corrugated tube Ø5 L=506±3mm (no slit)		JIG	1. Terminal cover jig	
NO.	PROCESS NAME		5 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
4	P1	Wire Insertion to Corrugated tube Ø5 L=506±3mm (no slit)	<div><div></div><div></div><div></div></div> <div><p>1. Hold the wires using left hands, get the terminal cover jig using right hand then insert the <b>B-Y wires</b> using left hands.</p><p>2. Get the <b>Corrugated tube Ø5 L=506±3mm (no slit)</b> using right hand and insert the wires using left hand.</p><p>3. After insertion, remove the terminal cover jig using right hands.</p></div>		<div><div>TERMINAL COVER JIG</div></div>		1. No wrong use of parts 2. No deformed terminal tip	
5		Wire insertion to Corrugated tube Ø5 L=25±3mm (no slit)	<div><div></div><div></div></div> <div><p>1. Get the <b>Black wire L=255mm</b> and combine to <b>Yellow wire</b>. Get the <b>Corrugated tube Ø5 L=25±3mm</b> using right hand. Insert both wires to COT using left hand.</p></div>		n/a		5 <div>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and strip length tolerance.</div>	

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Model code/Part number:

TP1 / 7L0090-7022

Customer:

TRQSS

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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### PARTS:

1. Connector 7282-1020 (W)

### JIG

1. Insertion jig

### NO.

### PROCESS NAME

### 5 WORK PROCEDURE/ ILLUSTRATION

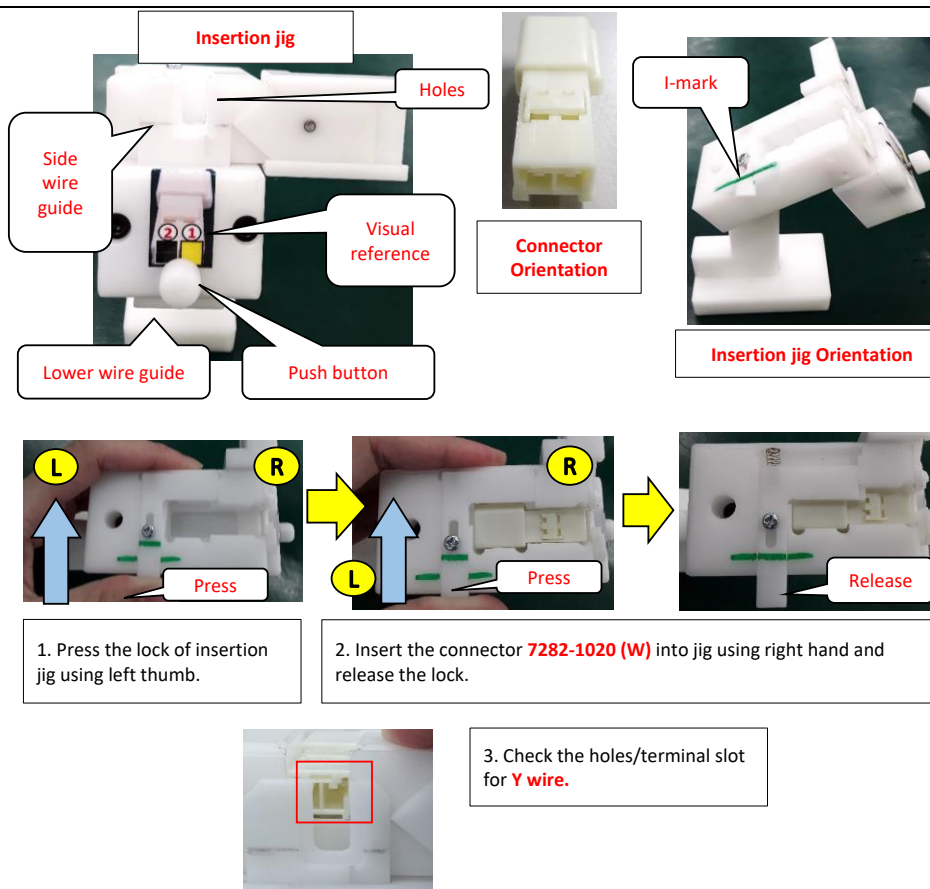
### TOOLS/PPE

### QUALITY POINTERS

6

P1

Connector setting to  
Insertion jig  
7282-1020 (W)

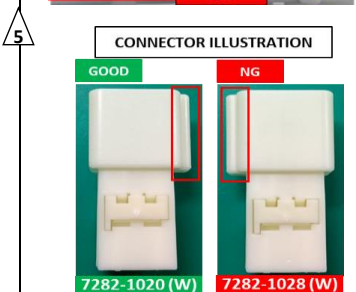
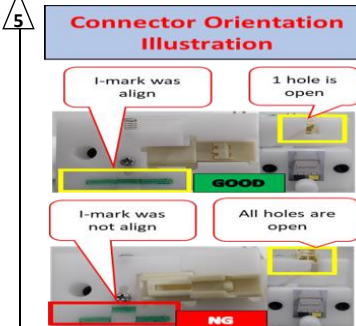


n/a

1. Use provided jig tools per model.
2. No wrong usage of parts.
3. No wrong orientation of connector
4. No damaged connector.

#### 5 Important reminders/ Note/s:

1. Follow the connector orientation
2. Cannot insert the inverted connector.



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Customer:

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

5

WORK PROCEDURE/ ILLUSTRATION


TOOLS/PPE

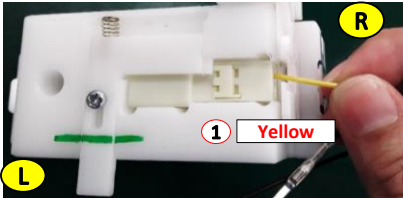
QUALITY POINTERS

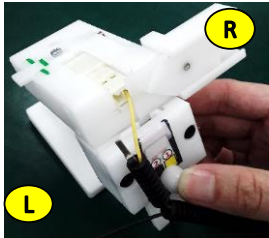
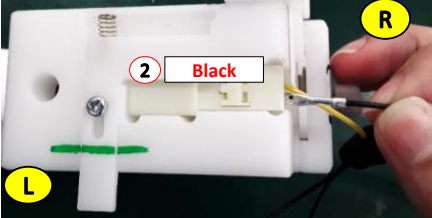
7


P1

Wire Insertion to  
Connector  
7282-1020 (W)

 Wire facing

 1. Insert the **Yellow wire** using right hand and insert to connector.

  2. Press the lower wire guide using right thumb. Insert **Black wire** and insert to connector using right hand.

 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.

n/a

5 Important reminders/Note/s:

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

5 Document references:

1. Refer to GL-PRO-ASY-029 For Pull-Push procedure.

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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



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.



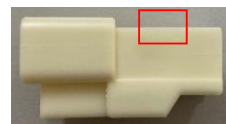
2. Push down the upper center part of the connector lock using gluestick.



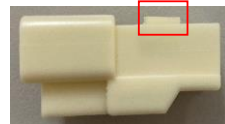
3. Push down the upper part as a whole to properly lock the connector.



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



AFTER PRESSING



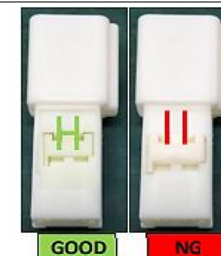
BEFORE PRESSING

GLUE STICK



5 **Important reminders/Note/s:**  
1. **Manual locking may cause connector damaged connector lock.**  
2. **Use provided jig tools to lock the connector.**  
3. **Position of gluestick must be slanted.**

5 **LOCKED CONDITION**



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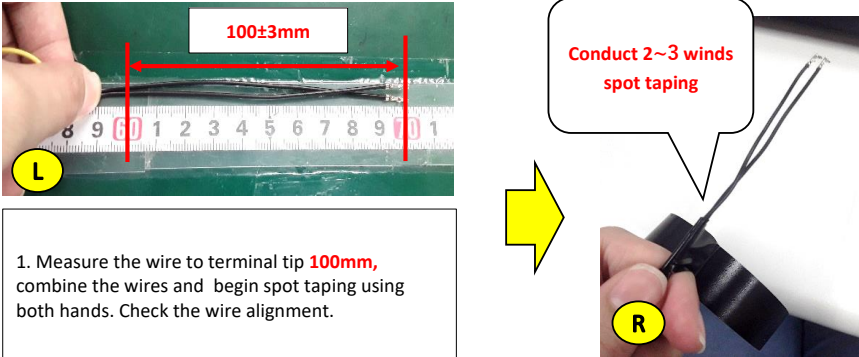

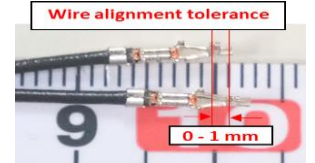
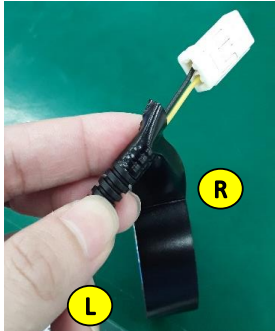

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PARTS:		1. Black tape 2. Assy parts		JIG	n/a
NO.	PROCESS NAME	5 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Spot taping	 <p>1. Measure the wire to terminal tip <b>100mm</b>, combine the wires and begin spot taping using both hands. Check the wire alignment.</p>		 	<p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong dimension</p> <p>5 <b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</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>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong dimension</p> <p>5 <b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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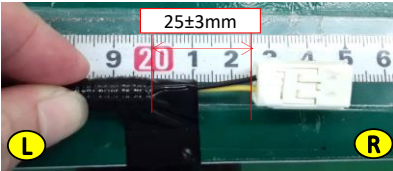
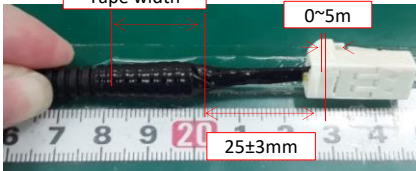






☒ MASSPRO

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PARTS:	1. Black tape 2. Assy parts	3. Black Corrugated tube Ø5 L=163±3mm (no slit)	JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	Taping 1 Corrugated tube to wire near connector (Continuation)	<div></div> <div>2. Hold the COT using left hand and measure the COT up to the end of connector <b>25mm</b>, proceed on taping process.</div> <div></div> <div>3. After taping, check the dimension and taping condition.</div>	<div>MEASURING TAPE</div> 	1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong dimension  <b>Important reminders/Note/s:</b>  <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b>
12	P1  Wire insertion to corrugated tube Ø5 L=163±3mm (no slit)	<div></div> <div>1. Get the terminal cover jig using right hand then insert the 2 Black wires.</div> <div></div> <div>2. Get the Black corrugated tube <b>Ø5 L=163±3mm (no slit)</b> using right hand and insert the 2 Black wires.</div> <div></div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>	<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts. 2. No deformed terminal

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