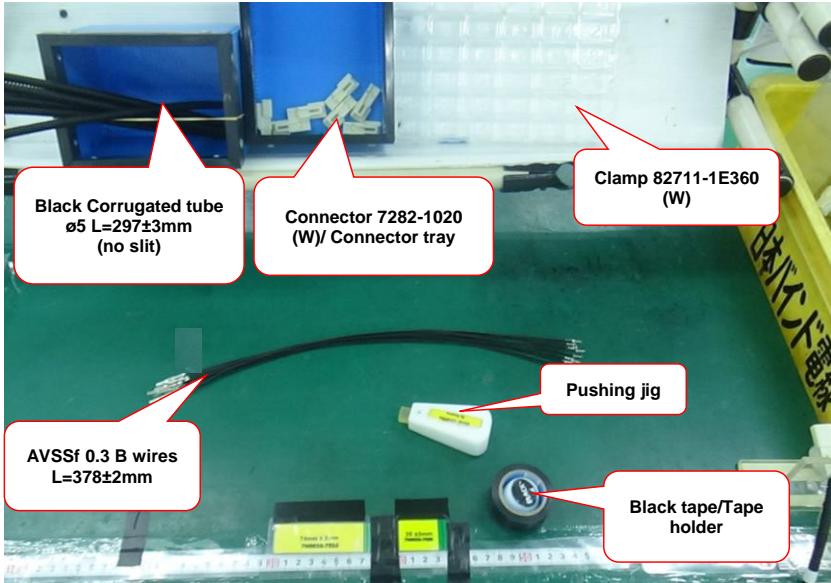




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	Model code/Part number: YKC / 7N0033-7020	Customer: TRJ	Car Model: SUZUKI SOLIO	Document No.:	WI-ENG-PDE-296		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	5	Page No.:	1 of 9


PARTS:	1. Connector 7282-1020 (W) ; AVSSf 0.3 B wires L=378±2mm ; Black Corrugated tube ø5 L=297±3mm ; Black tape; Clamp 82711-1E360 (W)			JIG:	1. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 5px; display: inline-block;">TABLE LAY-OUT</div>  </div>		<div style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1. No missing parts/tools 2. no excess parts/tools 3. No wrong position of parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
07/31/24	5	Separate assembly process to Clamp assembly process due to process improvement and change process due to removal of cover jig. Inclusion of car model "SUZUKI-SOLIO". Improved Table lay-out, Measurement and Visual inspection/Quality checkpoints.	D. Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
06/01/23	4	Installed spot taping guide with switch for detection of missing spot tape, improvement due to QC claim (Missing spot tape).	D. Castillo	J. Loterte	C. Villanueva	A. Arañes				
12/16/22	3	Improvement Project: Remove offline process. Update table lay-out (Page 1). Transfer Wire insertion to connector 7282-1020 (W), Connector lock and Wire insertion to Black corrugated tube (no slit) ø5 L=297±3mm (Page 2-4). Include quality pointers (Page 10).	D. Castillo	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	June 28, 2021		

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PARTS:	1. Corrugated tube Ø5 L=297+3mm 2. AVSSf 0.3 B wires L=378±2mm [2pcs]			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	P1 <div>5</div> Wire insertion to Corrugated tube Ø5 L=297±3mm	<div><div>1. Get black corrugated tube Ø5 L=297±3mm using left hand and insert Black wires L=378±2mm using right hand.</div></div>	N/A	1. No wrong use of parts 2. No deformed terminal	

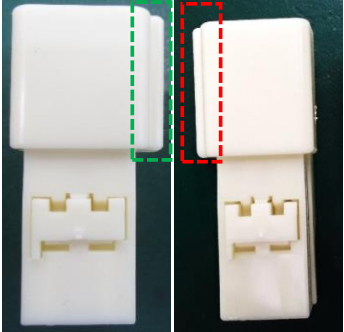

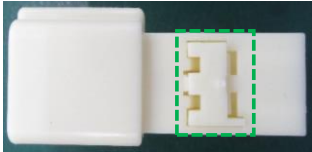
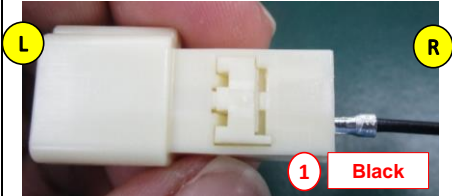
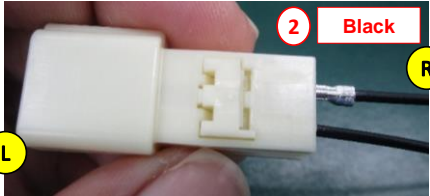
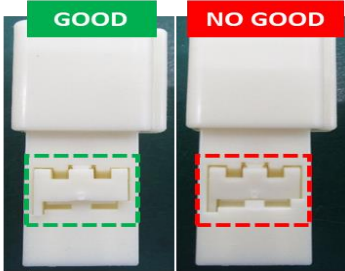
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PARTS:	1. Connector 7282-1020 (W) 2. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 7282-1020 (W)	<div><div><div>GOOD</div><div>NO GOOD</div></div><div><div>WIRE FACING</div></div><div><div>CONNECTOR ORIENTATION</div></div><div><div>1. Get the 1st Black wire then insert to terminal slot 1 of connector using right hand. <i>Note: Insertion of wires must be from left to right.</i></div></div><div><div>2. Get the 2nd Black wire then insert to terminal slot 2 of connector using right hand.</div></div></div> <div>N/A</div> <div><div><div>GOOD</div><div>NO GOOD</div></div><div>UNLOCK HALF-LOCKED</div><p>Important reminders/Note/s:</p><p>1. Please hold the wire near terminal.</p><p>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p><p>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</p><p>Document references:</p><p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p><p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p></div>			


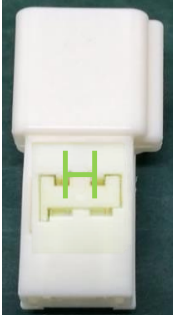
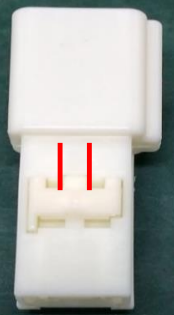
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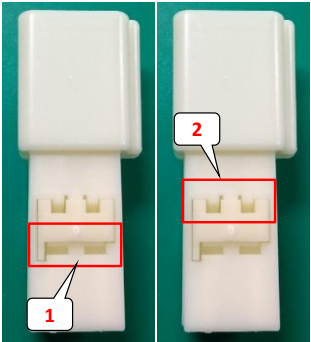
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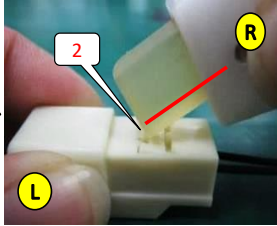
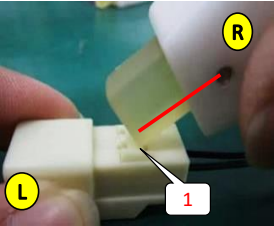
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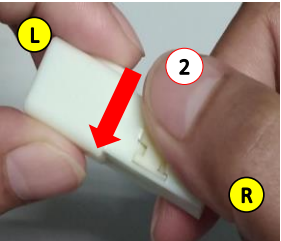
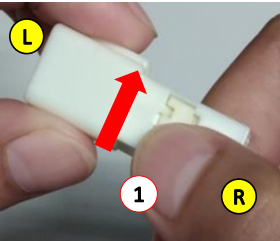
PARTS:	1. Assy parts			JIG:	1. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Connector lock		<div>Pushing jig</div> 	<div>Important reminders/Note/s:</div> <div>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</div> <div>2. Use the provided jig tool to lock the connector.</div> <div>3. Position of pushing jig during locking must be slanted.</div> <div>1. No unlocked/half-locked connector</div> <div>2. No damage connector</div> <div>LOCKED CONDITION</div> <div> GOOD</div> <div> NG</div>

Pressing sequence



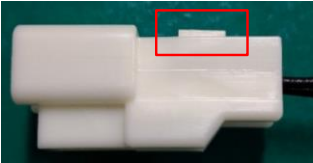


1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on the above illustration. Push the lower part of the connector lock first and then push the upper part.

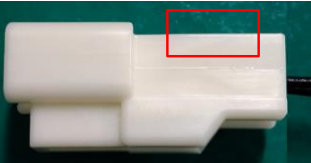


2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

Before pressing



After pressing




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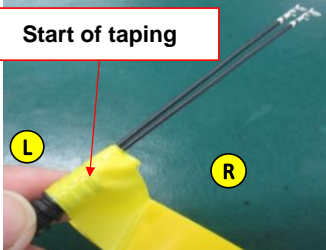
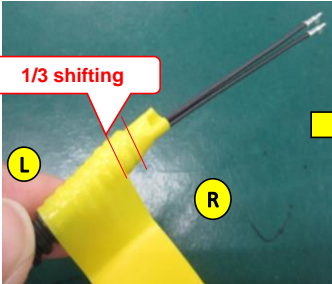
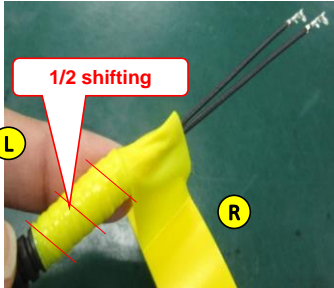

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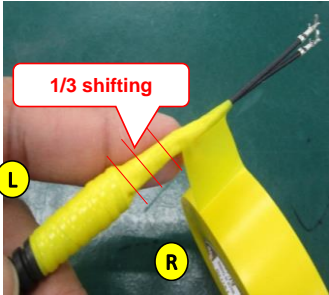
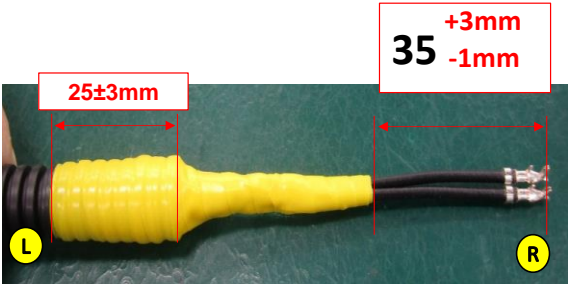

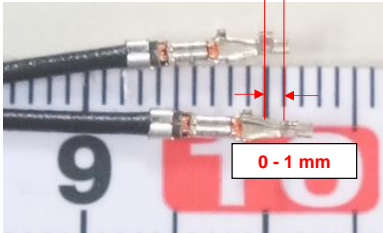
PARTS:	1. Assy parts 2. Black tape			JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
5	P1 Taping 1 Black corrugated tube Ø5 L=297+3mm to wire near terminal	<div><div>Start of taping</div><div>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</div></div> <div><div>1/3 shifting</div><div>25±3mm</div><div>2. Wind the tape 1/3 shifting going to COT until it reach 25mm then make 2 windings of tape before shifting.</div></div> <div><div>1/2 shifting</div><div>74±3mm</div><div>4. Measure from end of COT up to terminal pointed tip 74±3mm then continue the taping process using both hands.</div></div> <div>3. Wind the tape 1/2 shifting going to wires.</div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p> <p>Document references:</p> <p>1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance.</p> <p>2. Refer to WI-PRO-ASY-001 for taping procedure.</p>	

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PARTS:	1. Assy parts 2. Black tape			JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
5	P1 Taping 1 Black corrugated tube Ø5 L=297+3mm to wire near terminal (Continuation)	<div><p>1/3 shifting</p></div> <div><p>25±3mm</p><p>35 +3mm -1mm</p></div> <div>5. Make 1/3 shifting to wires until it measure from end of tape up to terminal pointed tip 35+3mm/-1mm. Make 3 windings of tape before cut.</div> <div>6. After taping, check the measurement, taping condition and terminal appearance.</div>		<div><p>MEASURING TAPE</p></div>	<div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div> <p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p> <p>Document references:</p> <p>1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance.</p> <p>2. Refer to WI-PRO-ASY-001 for taping procedure.</p>	

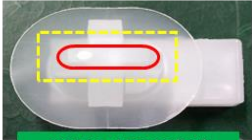
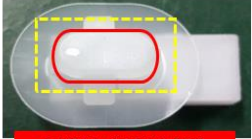
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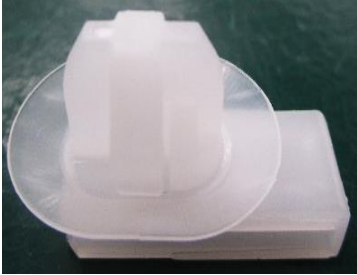
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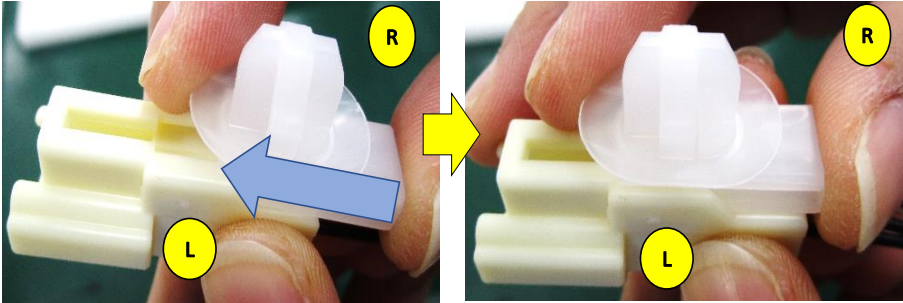
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PARTS:	1. Clamp 82711-1E360 (W) 2. Assy Parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	Clamp Attachment		N/A	<div>CLIP CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div>82711-1E360 (W)</div></div> <div><div>NG</div><div>82711-12B10 (W)</div></div> <div>1. No wrong use of parts 2. No loose attachment</div>



CLAMP ORIENTATION



1. Hold the connector using left hand, get the Clamp **82711-1E360 (W)** then insert using right hand.

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PARTS:	1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 <div>5</div>	<div>Measurement</div> <div><p>NOTE: (A) - Taping (B) (B) - Clamp (W)</p></div>	<div>MEASURING TAPE</div> <div></div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>

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Car Model:

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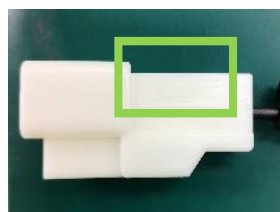
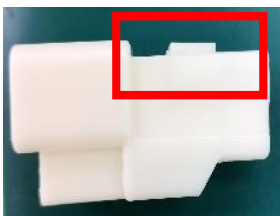
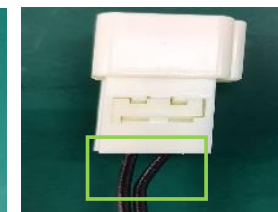
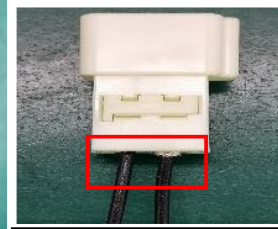
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7N0033-7020****GOOD****NO GOOD****GOOD****NO GOOD****1** No unlock connector/ halflocked connector**3** No missing of tape**5** No Terminal backing out**2** No wrong insert**4** No Deformed terminal

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