



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/ Part Number: **TP1 / 7L0088-7022**

Customer:

TRQSS

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

October 7, 2022

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WI-ENG-PDE-057A

Revision No.:

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PARTS:		1. Connector 4F5260-0000 (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 4F5260-0000 (W)				<div><div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>		<div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>All holes are open</div><div>NG</div></div></div>			
Revision History													
10/7/22	5	Improve quality pointers: Reminders/notes and references on page no. 2, 3, 4, 5, 6, 7, 8 and 9 due to document improvement. Work procedure/illustration in process no.3 and 8 -Connector lock.				M. Ariola	J. Loterte	C. Villanueva	A. Arañes	Prepared by	Reviewed by	Approved by	Noted by
02/15/21	4	Change spot tape color on process 10 from Black tape to Green tape to prevent the wrong use of tape.				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
02/03/21	3	Revise due to standardize the color of connectors in accordance with color standardization of plastic parts. Remove cycle time in every process. Conduct semi-annual review of documents.				M. Catapang	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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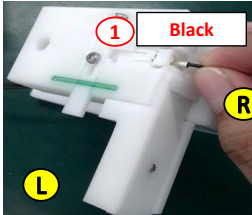
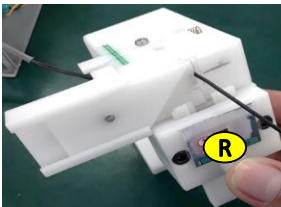
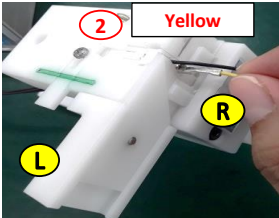
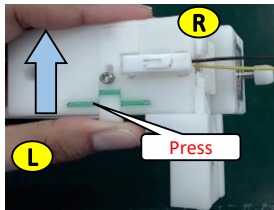
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PARTS:		1. AVSSf 0.3 B L=316±2mm; Y L=335±2mm		JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div><p>Wire facing</p></div> <div><p>1. Get the B wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. After insertion of B wire press the button using right hand. The slot for Y wire will be opened.</p></div> <div><p>3. Get the Y wire then insert to terminal slot 2 using right hand.</p></div> <div><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></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. 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.</div> <div>5 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>

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PARTS:

1. Assy parts

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P1

Connector Lock



1. Put the connector into locking jig using right hand then press 2x using both hands.



BEFORE PRESSING



AFTER PRESSING



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

LOCKING JIG



1. Use the provided locking jig per model
2. No unlock/half-locked connector

5

Important reminders/Note/s:

1. Manual locking may cause damaged connector lock.

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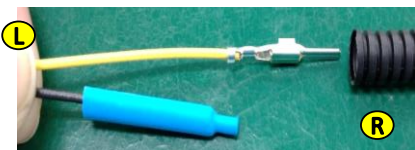
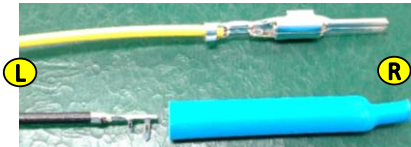



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PARTS:		1. Assy parts 2. Black Corrugated tube (no slit) Ø5 L=218±3mm; Ø5 L=47±3mm 3. AVSSf 0.3 B L=120±1mm		JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Wire insertion to Black Corrugated tube (no slit) Ø5 L=218±3mm	<div><p>1. Get the terminal cover jig and insert to B wire using right hand.</p></div> <div><p>2. Get the Corrugated tube (no slit) Ø5 L=218±3mm using right hand and insert the wires using left hand.</p></div> <div><p>3. Remove the terminal cover jig using right hand after insertion.</p></div>	<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts 2. No deformed terminal
5		Wire insertion to Black Corrugated tube (no slit) Ø5 L=47±3mm	<div><p>1. Get the B wire L=120±1mm using right hand then combine to Y wire.</p></div> <div><p>2. Get the corrugated tube (no slit) Ø5 L=47±3mm using right hand then insert the B-Y wires using left hand.</p></div>	n/a	1. No wrong use of parts 2. No deformed terminal <div>5</div> <p>Document references:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</p>

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PARTS:

1. Connector 7282-1028 (W)

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

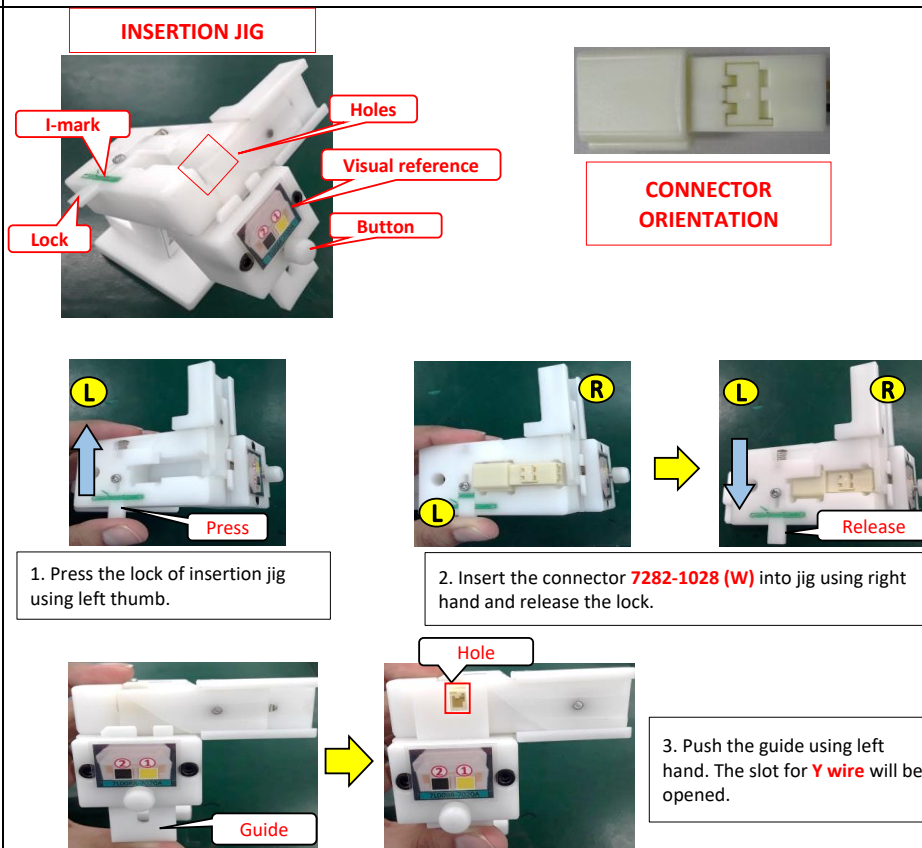
TOOLS/PPE

QUALITY POINTERS

6

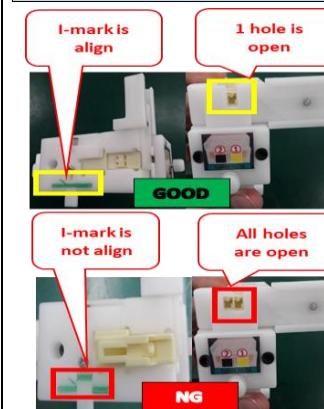
P1

Connector setting to
insertion jig
7282-1028 (W)

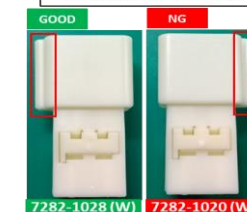


n/a

Connector Orientation Illustration



CONNECTOR ILLUSTRATION



1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

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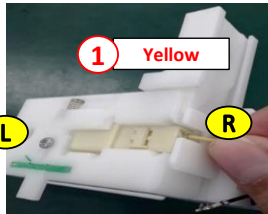
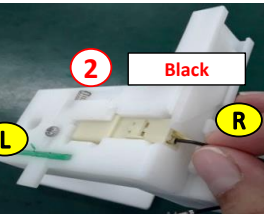
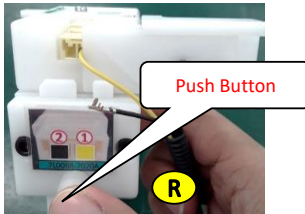
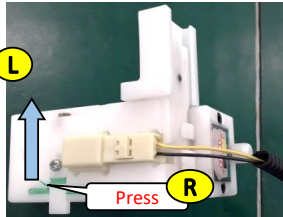
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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	<div><p>WIRE FACING</p></div> <div><p>1. Hold the Y wire then insert to terminal slot 1 using right hand.</p></div> <div><p>3. Hold the B wire then insert to terminal slot 2 using right hand.</p></div> <div><p>2. After insertion of Y wire press the button using left hand. The slot for B wire will be opened.</p></div> <div><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>		n/a	<div><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p><p>Important reminders/Note/s:</p><p>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p><p>2. Please hold the wire near terminal.</p><p>Document references:</p><p>1. Refer to GL-PRO-ASSY-029 for Pull-Push procedure.</p></div>

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

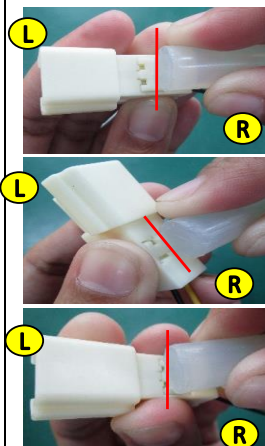
TOOLS/PPE

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.



BEFORE PRESSING



AFTER PRESSING

Glue stick



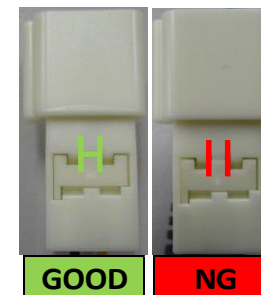
1. No unlock/half-locked connector

Important reminders/

1. Manual locking may cause damaged connector lock.

2. Position of glue stick must be slanted.

LOCK CONDITION



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PARTS:

1. Assy parts
2. Green tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

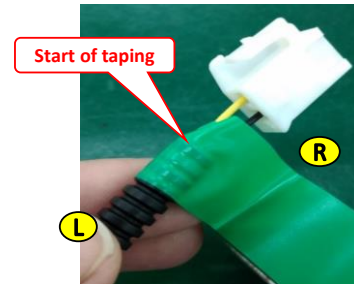
TOOLS/PPE

QUALITY POINTERS

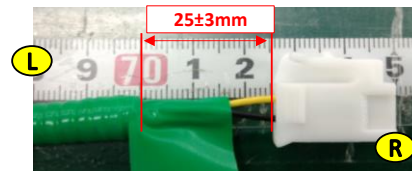
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P1

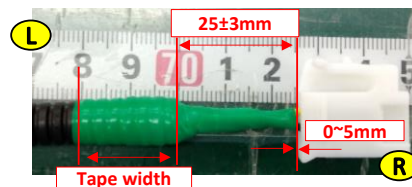
Taping 1
COT to wire near
connector



1. Hold the COT using left hand and start taping using right hand.



2. Measure from COT up to the end of connector **25±3mm** using both hands then continue the taping process.



3. After taping, check the dimension and taping condition.

MEASURING TAPE



1. No loose tape
2. No peel-off tape
3. No flip-out tape
4. No wrong dimension
5. No wrong use of tape

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

1. Use **GREEN TAPE** only.

2. Please use **calibrated/Verified measuring tape** when getting the measurement.

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PARTS:

1. Assy parts
2. Green tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

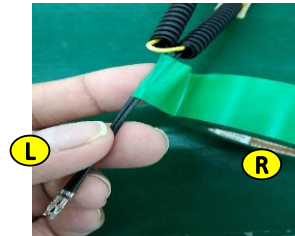
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P1

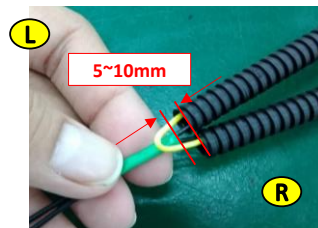
Spot taping



1. Hold the **B-B wires** using left hand.



2. Get the **green tape** using right hand then initially attached to **B-B wires**. Make **2 winds** then cut the tape.



3. After taping, check the dimension, terminal appearance, taping condition and wire alignment.

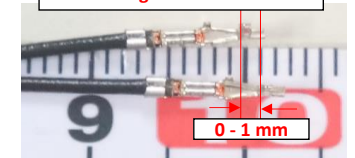
MEASURING TAPE



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Wire alignment tolerance



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