



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Model code/Part number:

TM3 / 7L0113-7021C

Customer:

TRQSS

Car Model:

SUBARU-ASCENT

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-708A

Revision No.:

2

Page No.:

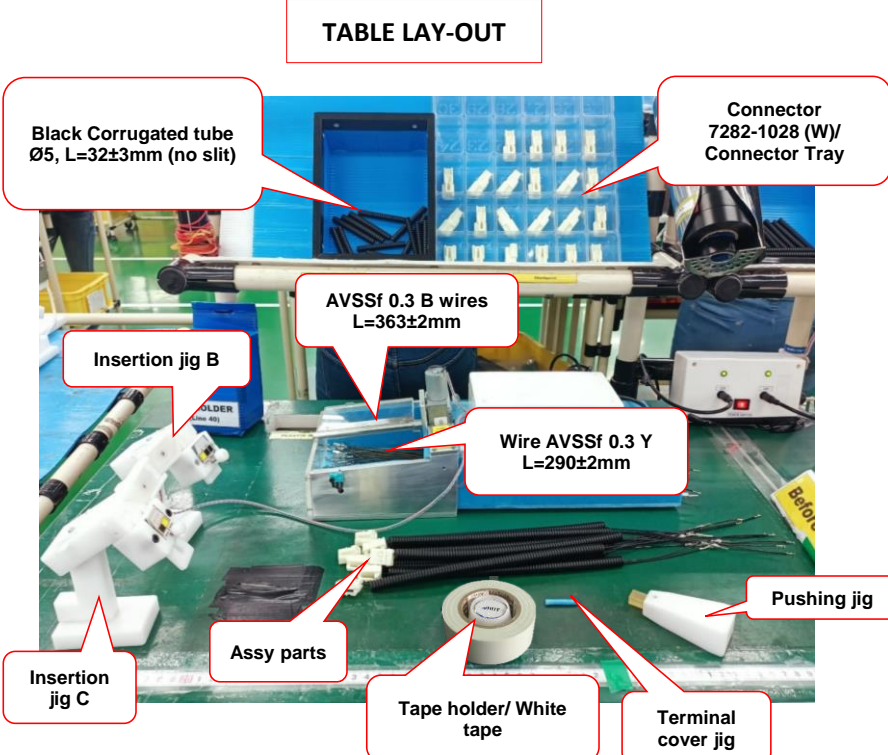
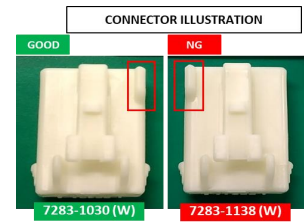

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PARTS:



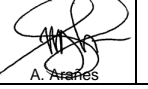
1. Assy parts; AVSSf 0.3 Y wires L=290±2mm; AVSSf 0.3 B wires L=32±3mm; White tape

JIG:

1. Insertion with switch cover
2. Pushing jig
3. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table lay-out 	Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker. Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	<ol style="list-style-type: none">1. No deformed terminal2. No wrong usage of parts Document references <i>1. Refer to WI-ENG-PDE-707 for Offline assembly process</i> <i>2. Refer to WI-PRO-CNC-017 for Wire and strip length tolerance</i>  

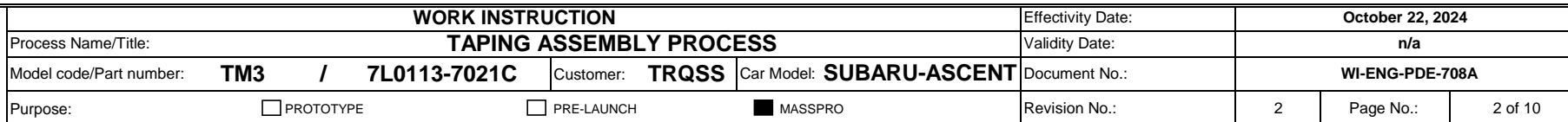
Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/08/24	2	Transfer spot taping to P2 due to process improvement. Improved Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
09/23/23	1	Change from Pre-launch to Masspro. Inclusion of table lay-out. Update Work procedure/Illustration on page no.4 and 9. Remove process no. 11,12,13,14,15 and 16 due to new process distribution. (Refer to WI-ENG-PDE-708B)	M. Ariola	J.Loterte	C. Villanueva	A. Arañes				
08/18/23	0	Initial issue.	M. Ariola	J.Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	August 18, 2023		

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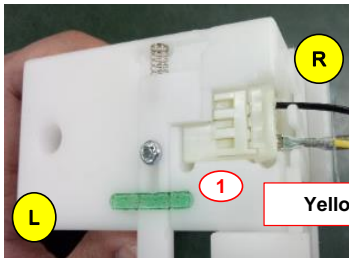
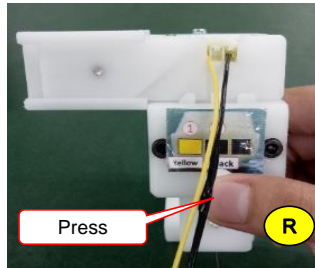
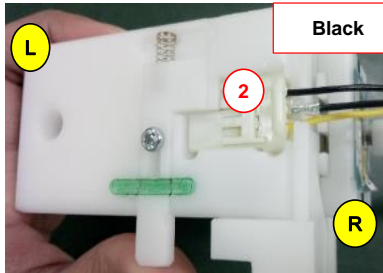
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PARTS:	1. AVSSf 0.3 wires Y L=290±2mm 2. AVSSf 0.3 wires B L=363±2mm		3. Assy parts	JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 7283-1030(W) (Assy parts)	<div><p>Wire Facing</p></div> <div><p>1. Get the Yellow wire using right hand then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Press the button using right hand, the slot for Black wire will be opened.</p></div> <div><p>3. Get the Black wire using right hand then insert to terminal slot 2 using right hand.</p></div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted . Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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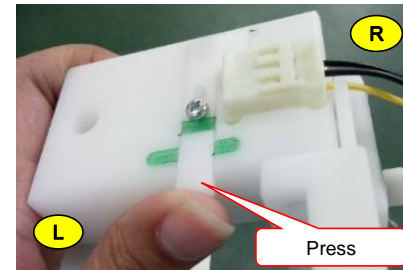

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PARTS:		1. Assy parts		JIG:	1. Terminal cover jig 2. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<div><div></div><div></div><div></div></div> <div>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B wire using left hand.</div> <div>2. Hold the corrugated tube (no slit) Ø5 L=202±3mm using right hand then insert the B and Y wires using left hand.</div> <div>3. After insertion, press the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div>		<div>TERMINAL COVER JIG</div> 	1. No deformed terminal 2. No wrong usage of parts

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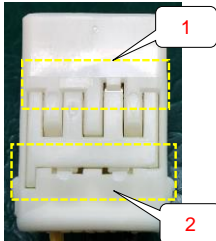
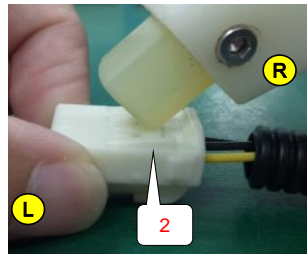
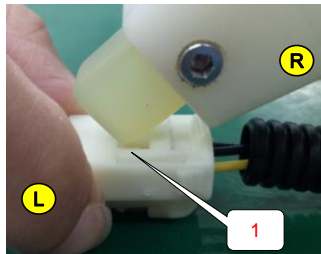
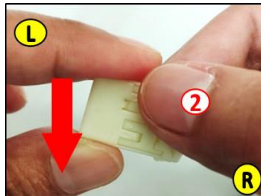
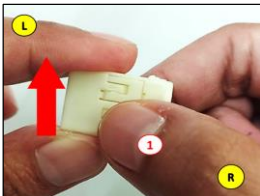
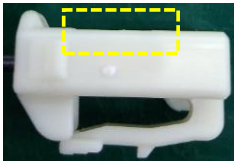


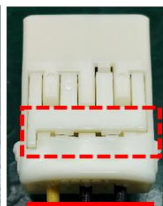

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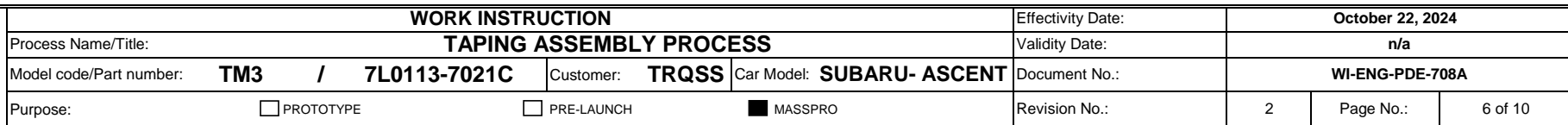
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PARTS:	1. Assy parts		JIG:	1. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 Connector lock 1	<div><div>LOCKING SEQUENCE</div><div></div><div></div><div>1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on above illustration. Push the lower part of the connector lock first and then push the upper part.</div><div></div><div>2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</div><div></div><div>BEFORE PRESSINGAFTER PRESSING</div></div> <div><div>PUSHING JIG</div></div> <div><div>LOCKED CONDITION</div><div></div><div>GOODNG</div></div> <div>1. Use provided jig tool per model to avoid damaged lock. 2. No unlocked/half-locked connector 3. No damage connector</div> <div>Important reminder/Note/s: 1. Manual locking may cause damaged terminal.</div>		

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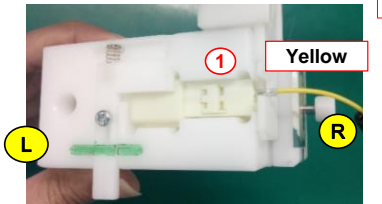

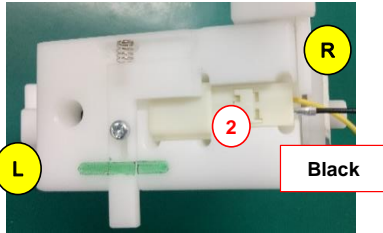
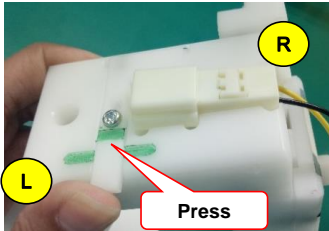
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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Wire insertion to connector 7282-1028 (W)	<div> WIRE FACING</div> <div> 1. Insert the Yellow wire using right hand and insert to connector.</div> <div> 2. Press the button using right hand, the slot for Black wire will be opened.</div> <div> 3. Get Black wire using right hand and insert to connector.</div> <div> 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.</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>Important reminder/Note/s: 1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct PULL-PUSH-PULL-PUSH after insertion. Do not exert extra force.</div> <div>Document reference/s: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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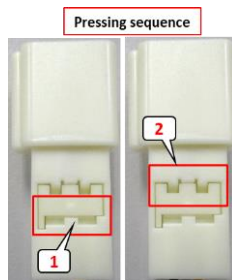
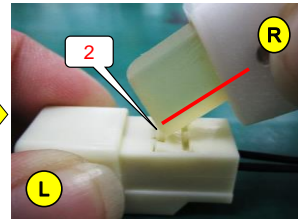
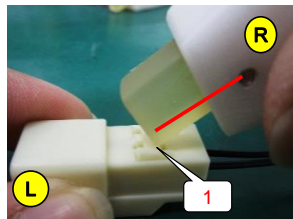
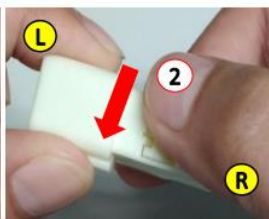
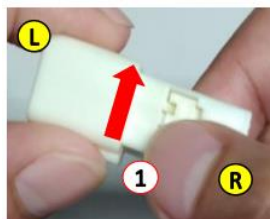




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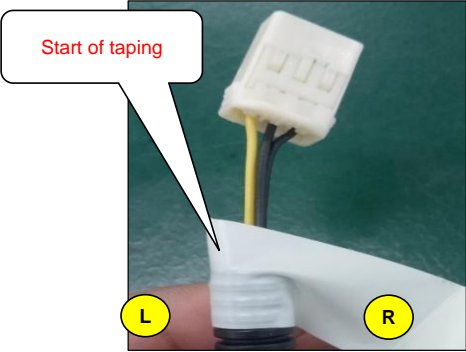
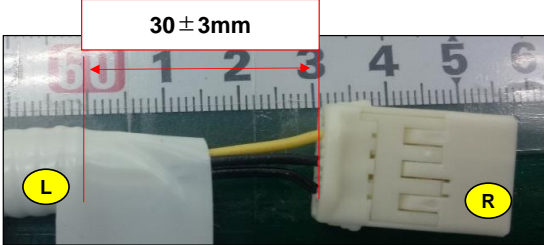
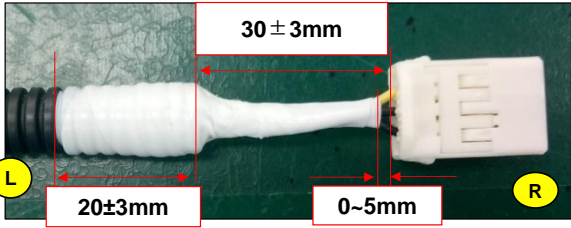

PARTS:	1. Assy parts		JIG:	1. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QU
9	P1 Connector lock 2	<div><div><p>Pressing sequence</p></div><div></div><div><p>1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on the above illustration. Push the lower part of the connector lock first and then push the upper part.</p></div><div></div><div><div><p>Before pressing</p></div><div><p>After pressing</p></div></div></div> <div><div><p>PUSHING JIG</p></div><div><p>1. Manual damaged connector lock 2. Position of Pushing jig must be slanted.</p><p>GOOD</p><p>NG</p></div></div>		

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.:

PARTS:		1. Assy parts 2. White tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1 Taping 1 Black COT to wire near Connector	<div><p>Start of taping</p></div> <div><p>30 ± 3mm</p></div> <div><p>30 ± 3mm 20 ± 3mm 0~5mm</p></div> <div><p>1. Hold the COT using left hand, get the White tape using right hand then start pre-taping using both hands.</p><p>2. Measure from end of COT up to edge of connector 30±3mm then continue the taping process using both hands.</p><p>3. After taping, check the measurement and taping condition.</p></div> <div><p>MEASURING TAPE</p></div>		<p>Important reminders and Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Use <u>WHITE TAPE</u> only.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p>	

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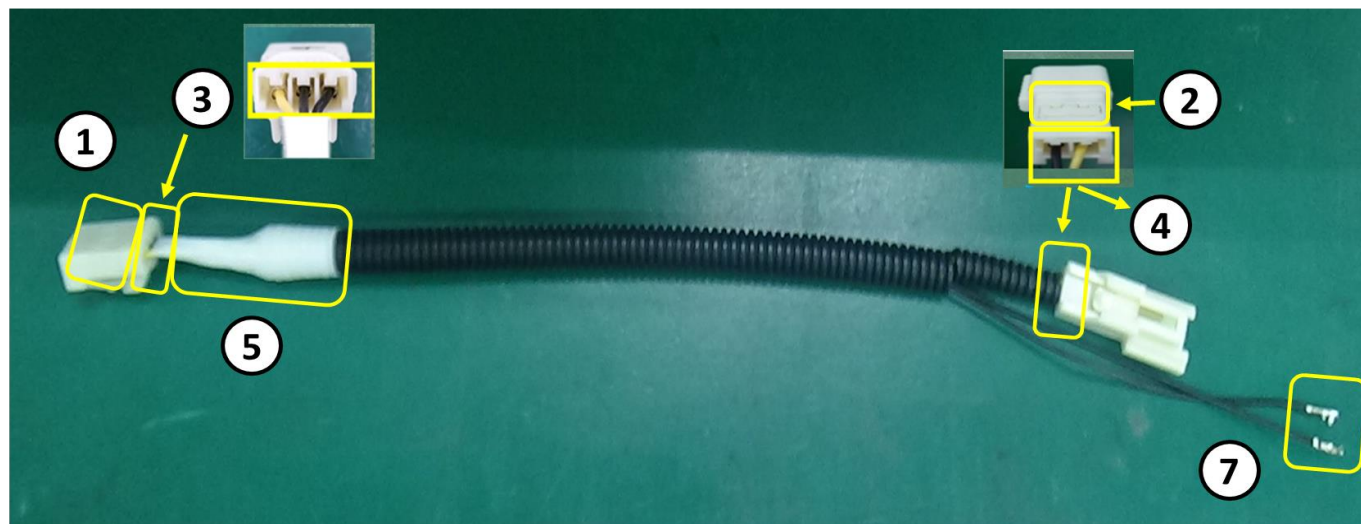
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**P1****7L0113-7021C****GOOD****NO GOOD****GOOD****NO GOOD****6****GOOD****NO GOOD****1 2** No Unlocked / Halflocked Connector**5** No Missing Tape**3 4** No Wrong Insert**6** No Terminal Backing Out**7** No Deformed Terminal

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