



# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

April 4, 2023

Process Name/Title:

Model Code/ Part Number: **TM3 / 7L0113-7020**Customer: **TRQSS**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-320**

Revision No.:

3

Page No.:

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**PARTS:**

1. Assy part; Wire AVSSf 0.3 Y L=324±2mm; Wire AVSSf 0.3 B L=317±2mm; Black corrugated tube Ø5, L=50±3mm (no slit); Gray Urethane foam t=4; 75mm X 30mm); White tape; Black tape

**JIG:**

1. Insertion jig
2. Pushing jig
3. Assembly jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 (Table 1)	<p><b>BATCHING QUANTITY: 10pcs</b></p> <p><b>TABLE LAY-OUT</b></p> <p>Connector 7283-1030 (W)/ Connector Tray</p> <p>Wire AVSSf 0.3 Y L=324±2mm</p> <p>Black Corrugated tube Ø5, L=50±3mm (no slit)</p> <p>Assy parts</p> <p>Gray Urethane foam t=4; 75mm X 30mm/ Foam holder</p> <p>Insertion jig A</p> <p>Insertion jig B</p> <p>Wire AVSSf 0.3 B L=317±2mm</p> <p>Tape holder/ White tape</p> <p>Tape holder/ Black tape</p> <p>Pushing jig</p> <p>Clamp Assembly jig</p>	<p><b>Safety Instruction</b></p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b></p> <ol style="list-style-type: none"><li>1. Maintain and always practice 5's.</li><li>2. Personal things on the work place is prohibited. Keep it in your locker.</li></ol> <p><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>1. No missing parts/tools</p> <p>2. No excess parts/tools</p> <p><b>CONNECTOR ILLUSTRATION</b></p> <p>7283-1030 (W)</p> <p>7283-1138 (W)</p> <p><b>Document references:</b></p> <ol style="list-style-type: none"><li>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</li><li>2. Refer to WI-ENG-PDE-327 For offline Assembly Process.</li></ol>

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/04/23	3	Work instruction improvement: Change MP from 2MP to 1MP (Page12-17). Inclusion of batching. Update table lay-out. Inclusion of Quality Checkpoints (Page 18).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes				
09/30/22	2	Improve: Work procedure/Illustration on process no. 3, 4, 5, 6, 7, 8 and 9; Quality pointers and notes on pg. no. 1, 2, 3, 4, 5, 7, 8, 9, 10 and 11.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
08/26/21	1	Transfer Jointed wire B/B 7L0113-2000 and Black corrugated tube Ø7, L=218±3mm no slit) insertion to Kitting. Provide insertion jig. Change from pre-launch to masspro.	D.Castillo	C.Villanueva	A.Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	August 09, 2021		

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☐ PRE-LAUNCH

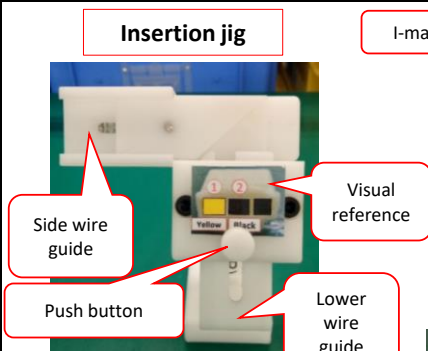

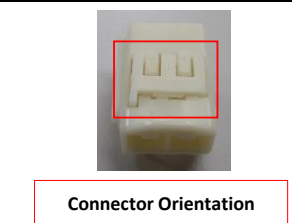
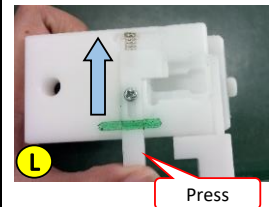
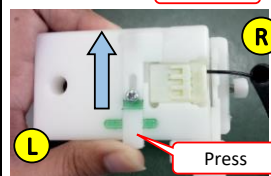
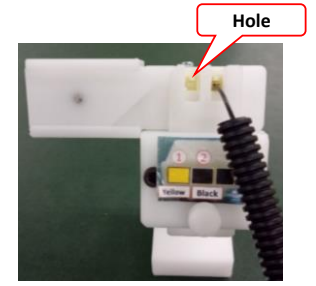

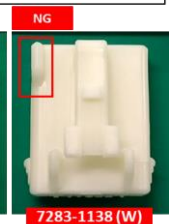
☒ MASSPRO

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PARTS:		1. Assy parts			JIG	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
2	P1 (Table 1)	<p>Connector Setting to insertion jig 7283-1030 (W) (Assy parts)</p>    <p>1. Push the lower wire guide using right hand.</p>  <p>2. Press the lock of insertion jig using left thumb.</p>  <p>3. Insert the connector 7283-1030 (W) into jig using right hand and release the lock.</p>  <p>4. Check the hole/terminal slot for Yellow wire.</p>			n/a	<p>CONNECTOR ILLUSTRATION</p>   <p>7283-1030 (W) 7283-1138 (W)</p> <p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>	

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**WI-ENG-PDE-320**

Purpose:



PROTOTYPE



PRE-LAUNCH



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**3 of 18****PARTS:**

1. Assy parts

2. Wires AVSSf 0.3 Y L=324±2mm

3. Wires AVSSf 0.3 B L=317±2mm

**JIG**

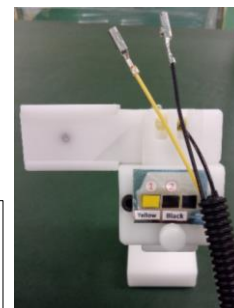
1. Insertion jig

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

3

Wire insertion to Assy parts  
(Ø7, L=218±3mm  
(no slit)

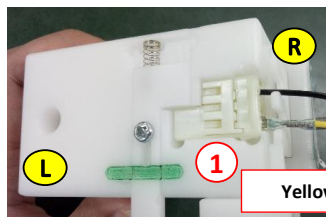
1. Get the 2 wires (Yellow L=324±2mm and Black L=317mm) and insert to assy part using right hand



n/a

1. No deformed terminal  
2. No wrong usage of partsP1  
(Table  
1)

4

Wire insertion to  
Connector  
7282-1030 (W)  
(Assy parts)

Wire Facing

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

n/a

1. No loose insertion  
2. No wrong insertion  
3. One by one insertion  
4. No deformed terminal  
5. No wrong wire facing**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.**NBC (Philippines)  
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## PARTS:

1. Assy parts
2. Wires AVSSf 0.3 Y L=324±2mm

3. Wires AVSSf 0.3 B L=317±2mm

JIG

1. Insertion jig

NO.

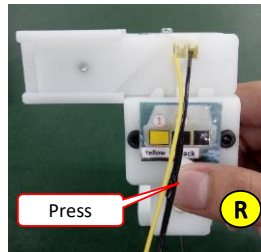
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

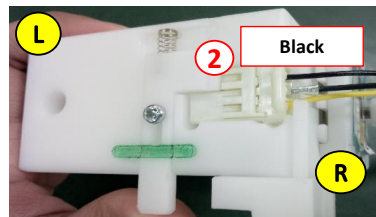
4

P1  
(Table  
1)Wire insertion to  
Connector  
7283-1030 (W)  
(Assy parts)  
(Continuation)

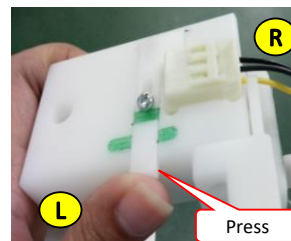
2. Press the button using right hand, the slot for Black wire will be opened.



Wire Facing



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



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

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

**Important reminders/Note/s:**

**1. Please hold the 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.**

**Document references:**

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

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PARTS:

1. Assy parts

JIG

1. Pushing jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

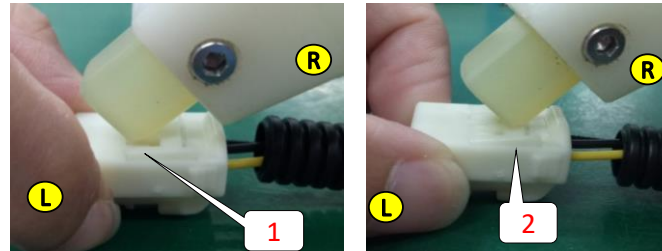
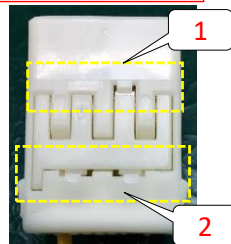
QUALITY POINTERS

5

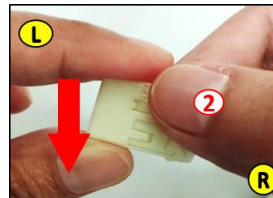
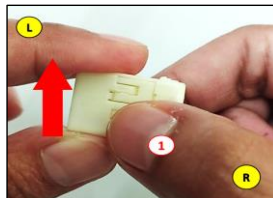
P1  
(Table  
1)

Connector lock

LOCKING SEQUENCE



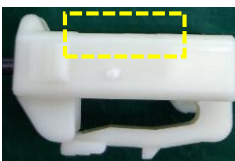
1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on above illustration. Push the lower part of the connector lock first and then push the upper part.



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



BEFORE PRESSING



AFTER PRESSING

PUSHING JIG

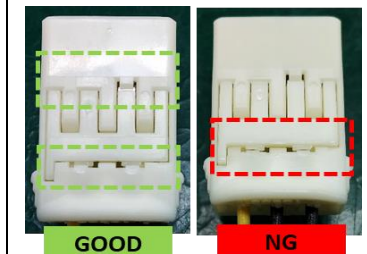


1. No unlocked/half-locked connector
2. No damage connector
3. Use provided jig tool per model to avoid damaged lock.

Important reminders/Note/s:

1. Manual locking may cause damaged connector lock.
2. Position of pushing jig during locking must be slant.

LOCKED CONDITION



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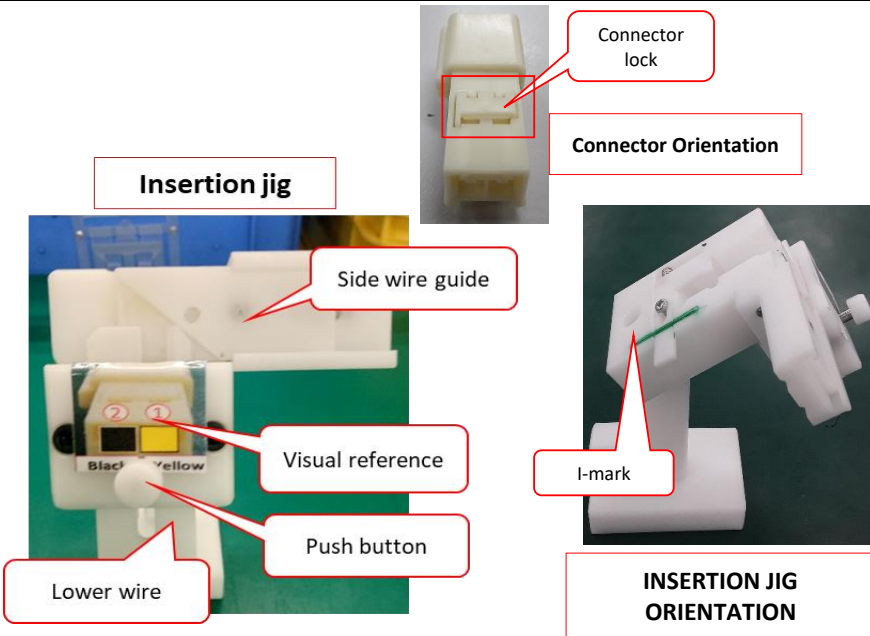
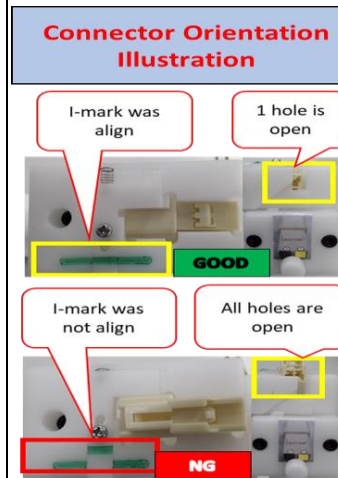
**6 of 18****PARTS:**

1. Assy parts
2. Black corrugated tube Ø5, L=50±3mm (no slit)

3. Connector 7282-1028 (W)

**JIG**

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Wire insertion to Assy parts (Ø5, L=50±3mm (no slit)	 <p>1. Get the corrugated tube Ø5 L=50±3mm using right hand then insert the Y and black jointed wire using left hand.</p>	n/a	<ol style="list-style-type: none"><li>1. No deformed terminal</li><li>2. No wrong usage of parts</li></ol>
7	P1 (Table 1)  Connector setting to Insertion jig 7282-1028 (W)	 <p>INSERTION JIG ORIENTATION</p>	n/a	<ol style="list-style-type: none"><li>1. Use provided jig per model</li><li>2. No wrong usage of parts</li><li>3. No wrong orientation of connector</li><li>4. No damaged connector</li></ol> <div><b>Connector Orientation Illustration</b> </div>

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☐ PRE-LAUNCH

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### PARTS:

1. Connector 7282-1028 (W)

### JIG

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

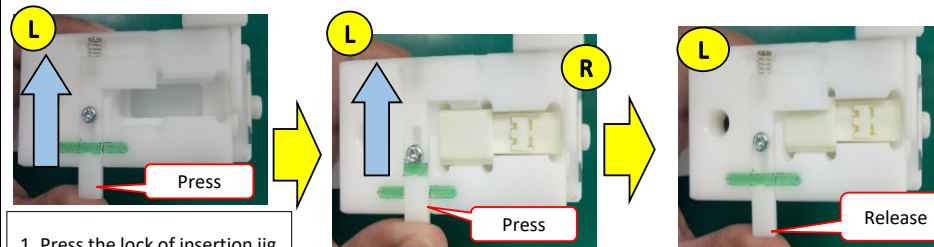
### TOOLS/PPE

### QUALITY POINTERS

7

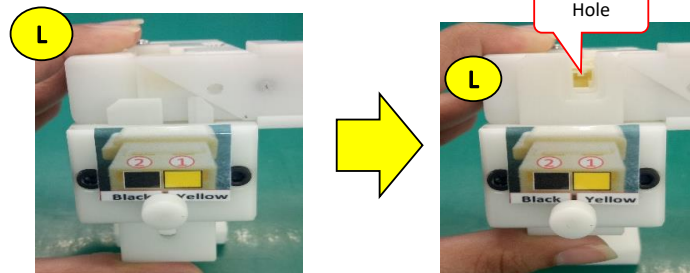
P1  
(Table  
1)

Connector setting to  
Insertion jig  
7282-1028 (W)  
(Continuation)



1. Press the lock of insertion jig using left thumb.

2. Insert the connector **7282-1028 (W)** into jig using right hand and release the lock.

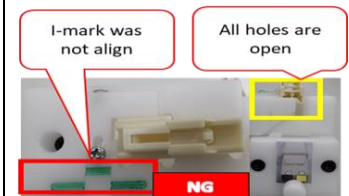


3. Push the lower wire guide using left hand, the slot for **Yellow wire** will be opened.

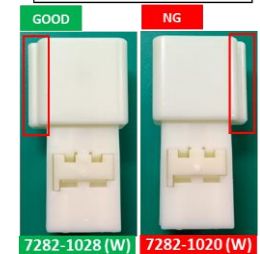
n/a

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

### Connector Orientation Illustration



### CONNECTOR ILLUSTRATION



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## PARTS:

1. Assy parts

## JIG

1. Insertion jig

## NO.

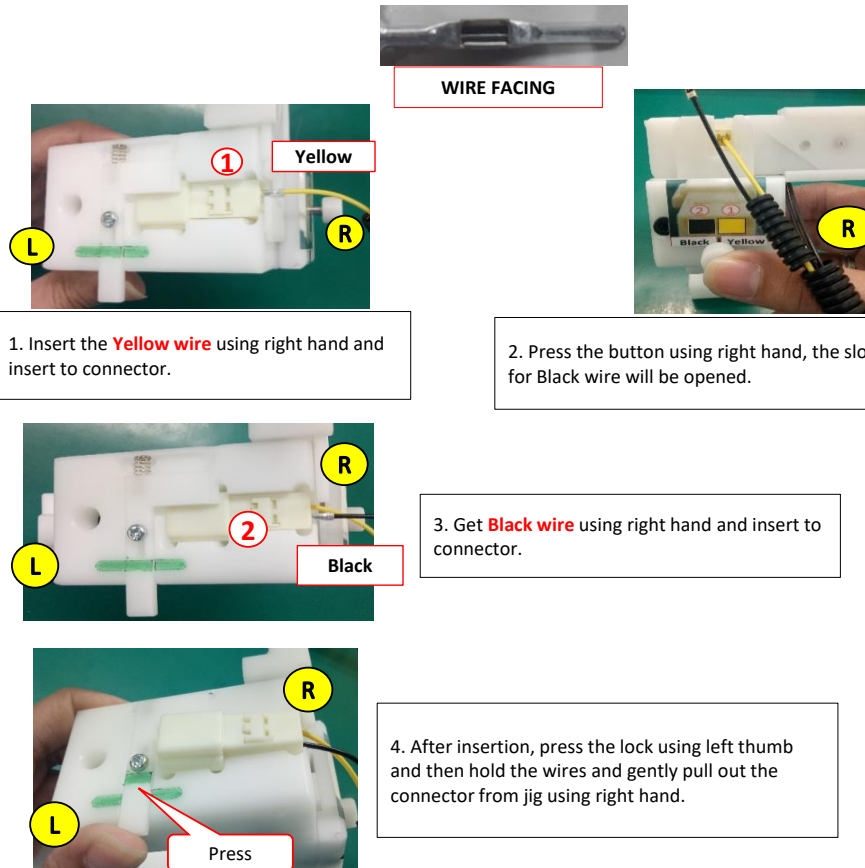
## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

## QUALITY POINTERS

8

P1  
(Table  
1)Wire insertion to  
connector  
7282-1028 (W)

n/a

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing.

**Important reminders/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.**

**Document references:**

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

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PROTOTYPE



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### PARTS:

1. Assy parts

### JIG

1. Pushing jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

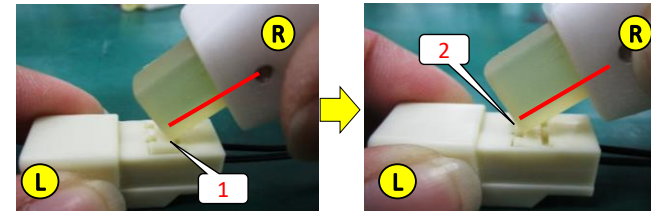
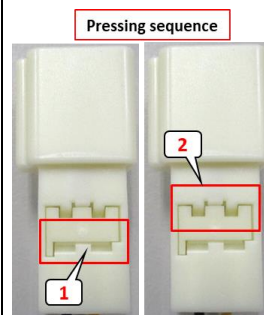
### TOOLS/PPE

### QUALITY POINTERS

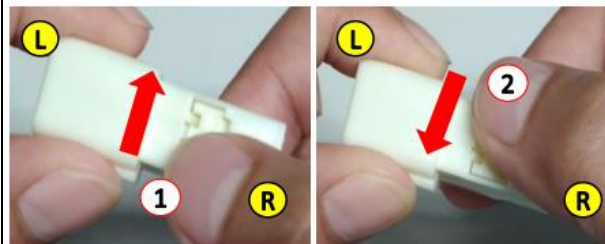
9

P1  
(Table  
1)

Connector lock



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 touching the connector lock based on the sequence illustrated.

Before pressing

After pressing



### PUSHING JIG

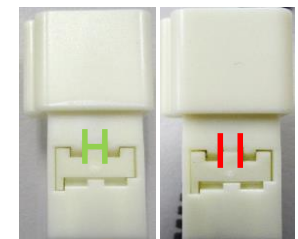


1. No unlocked/half-locked connector
2. No damage connector
3. Use provided jig tool per model to avoid damaged lock.

### Important reminders/Note/s:

1. Manual locking may cause damaged connector lock.
2. Position of pushing jig during locking must be slant

### LOCKED CONDITION



GOOD

NG

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## PARTS:

1. Assy parts
2. White tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

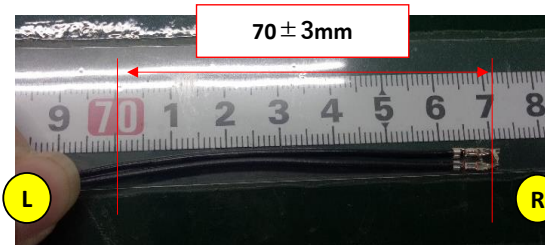
TOOLS/PPE

QUALITY POINTERS

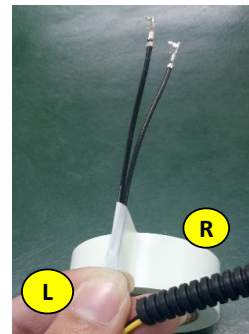
10

P1  
(Table  
1)

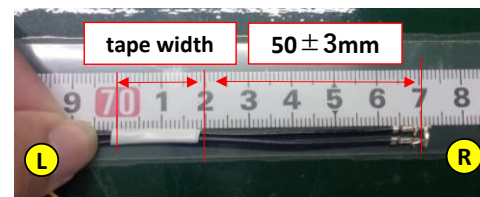
Spot taping



1. Hold wires using left hand, measure the wire up to terminal tip **70±3mm**.



2. Get the **White tape**, conduct **2x windings** of tape then cut using both hand.



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

## MEASURING TAPE



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

**Important reminders/Note/s:**

**1. Please use calibrated/verified measuring tape when getting the measurement.**

**2. Use WHITE TAPE only.**

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WI-ENG-PDE-320

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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### PARTS:

1. Assy parts
2. White tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

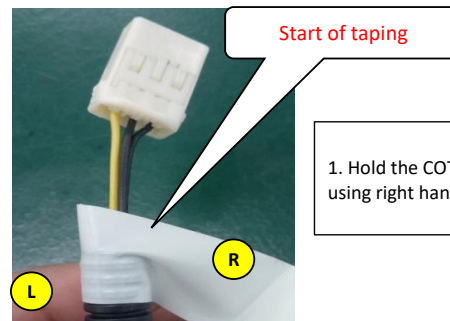
TOOLS/PPE

QUALITY POINTERS

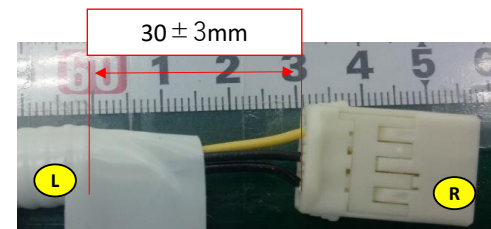
10

P1  
(Table  
1)

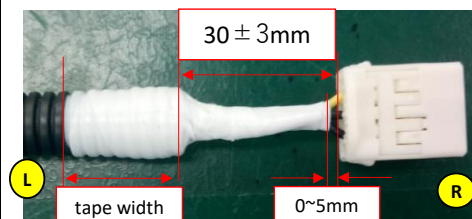
Taping 1  
Black COT to wire near  
Connector



1. Hold the COT using left hand, get the **White tape** using right hand then start pre-taping using both hands.



2. Measure from end of COT up to edge of connector **30±3mm** then continue the taping process using both hands.



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

MEASURING TAPE



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

Important reminders/Note/s:

1. Please use calibrated/ verified measuring tape when getting the measurement.

2. Use **WHITE TAPE** only.

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

April 4, 2023

Process Name/Title:

Model Code/Product Numbe

TM3 / 7L0113-7020

Customer:

TRQSS

Validity Date:

n/a

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

11

P1  
(Table  
1)

Y-Taping

1. Fix the two (2) COT.

2. Get the **Black tape** using right hand then make **2 winds pre-taping** before shifting.

Start of taping

1/2 shifting

43±3mm

1/3 shifting

1/2 shifting

3. Make **1/2 shifting** going left side then measure from connector up to tape **43±3mm** then make **2 winds** before shifting using both hands.

4. Make **1/2 shifting** going right side and another **1/3 shifting** until it reach the **35(+3/-1mm)** measurement from end of tape up to terminal pointed tip.

5. After taping, check the measurement, taping condition and terminal appearance.

MEASURING TAPE

1. No peel-off tape
2. No flip-out tape
3. No wide interval between the 2 COT
4. No exposed wire
5. No wrong dimension

### Important reminder/Note/s:

1. Used **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

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**TM3**

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PROTOTYPE



PRE-LAUNCH



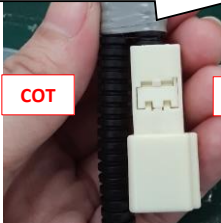





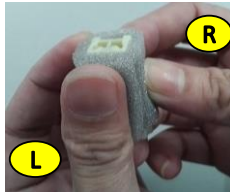

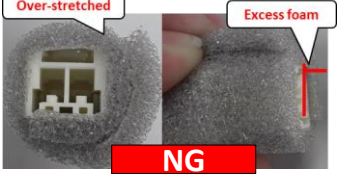
MASSPRO

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PARTS:		1. Gray Urethane foam t=4; 75mm X 30mm 2. Assy parts	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	P1 (Table 2)	Urethane foam manual attachment to connector  <div><div>Step 1: Identify the right facing to attached the foam</div><div><div>COTConnector</div></div><div>Step 2: Get the Urethane foam and begin the attachment. Note: Foam and connector must be align</div><div><div>L R</div></div><div>Step 3: Attached the foam in all sides of the connector. Note: Follow the attachment sequence based on the illustration</div><div><div>L R</div></div><div><div>L R</div></div><div><div>L R</div></div><div><div>L R</div></div><div><div>L R</div></div><div>Step 4: Press the Urethane foam side by side after attachment.</div></div>	n/a	<div><div>GOOD</div></div> <div><div>NG</div></div> <div>Over-stretchedExcess foam</div> <div><b>Important reminder/Note/s:</b></div> <div>1. Tolerance from Urethane foam to connector must be 0~3mm.</div> <div>2. Do not Stretch the Urethane foam.</div>

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## PARTS:

1. Assy parts

## JIG

1. Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

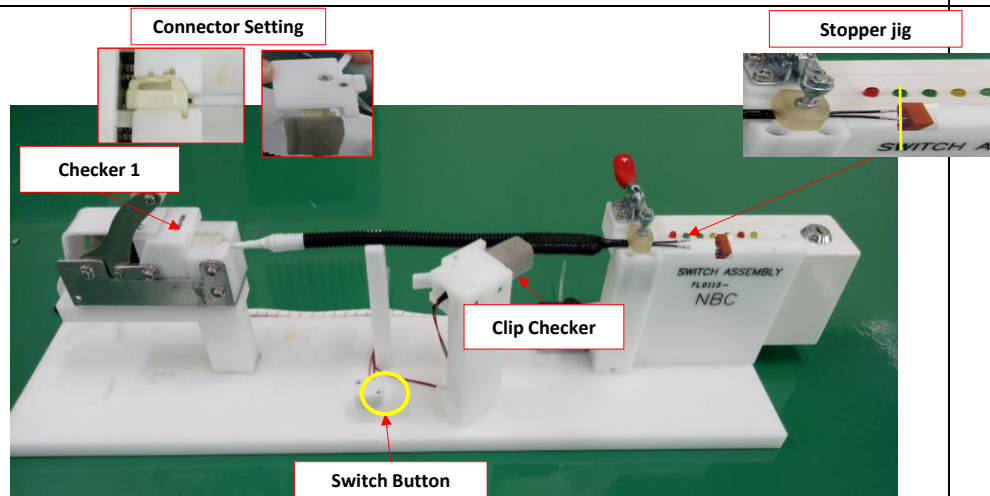
TOOLS/PPE

QUALITY POINTERS

13

P1  
(Table  
2)

Assembly jig

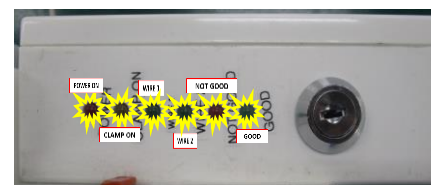


n/a

1. No wrong insert  
2. Make sure no gap between terminal  
and stopper jig

1. Get the assy parts and set to clamp assembly jig using both hands. **(See above picture for correct setting)**. First set the connector **7283-1030 (W)** to **Receiver base** then pull the checker fixture for continuity checking. Second, set the connector **7282-1028 (W)** to **Clip checker** then lock. Last, set the **B-B wires** to together within the stopper jig then press by toggle clamp.

2. Check if all **LED** light for **Power ON, Wire1 & Wire2** was **ON**. If encounter abnormality or hearing **NG** buzzer, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process.



3. Press the switch button using right hand. **GO** buzzer will be heard

4. Conduct **POINT CHECKING** before removing the harness from jig.

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## PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

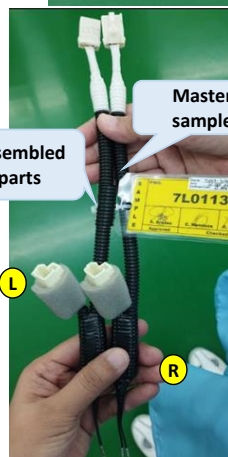
TOOLS/PPE

QUALITY POINTERS

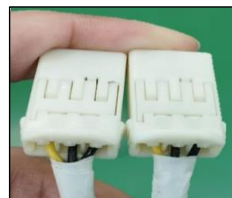
14

P1  
(Table 2)Visual/By Two's  
Inspection

ACTUAL PRODUCTS

Assembled  
partsMaster  
sample

1. Conduct **alignment of harness (Master sample vs. Assembled parts)** using both hands.



2. Check the **connector lock, terminal and Insertion.**



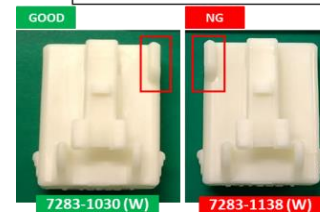
3. Check the **taping condition.**

MASTER SAMPLE



1. No skip checking during inspection

CONNECTOR ILLUSTRATION



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**16 of 18****PARTS:**

1. Assembled parts
2. Master sample

**JIG****n/a****NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

15

P1  
(Table  
2)Visual/By Two's  
Inspection (Continuation)**ACTUAL PRODUCTS**

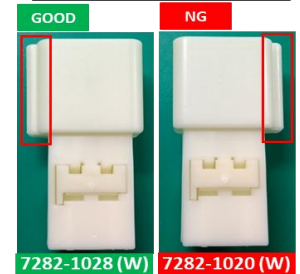
4. Check the **terminal, insertion** and **presence of Urethane foam** attachment.



5. Check the **Y-Taping condition** and **terminal appearance**. Must be **no deformed terminal**.

**MASTER SAMPLE**

1. No skip checking during inspection

**CONNECTOR ILLUSTRATION**

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**PARTS:**

n/a

**JIG**

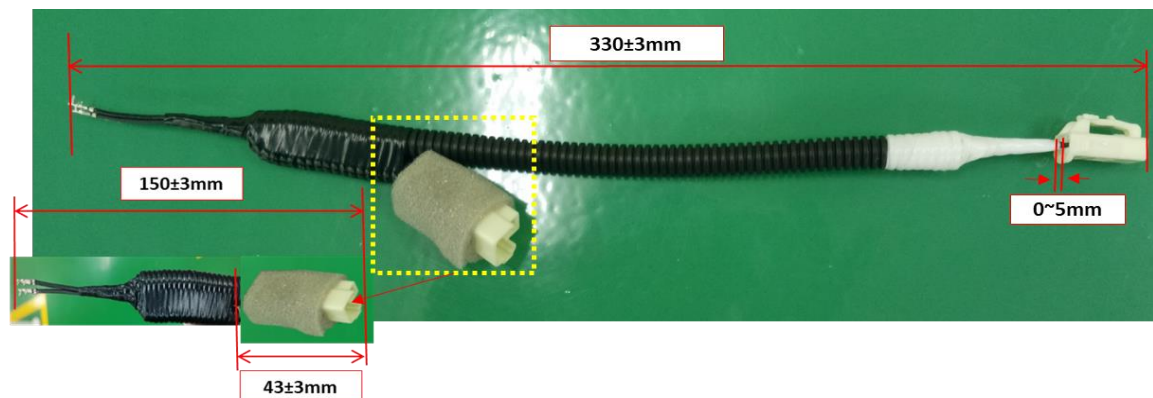
n/a

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

16

P1  
(Table 2)

Measurement

**MEASURING TAPE**

1.No wrong dimension

**Important reminders/Note/s:****1. Please use calibrated/ verified measuring tape when getting the measurement.****2. For Hatsumono and Owarimono.**

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PARTS:

n/a

JIG

n/a



### QUALITY CHECKPOINTS

P1

7L0113-7020

①

GOOD

NO GOOD

GOOD

NO GOOD

②

GOOD

NO GOOD

③

④

⑤

⑥

⑦

⑧

⑨

① No Unlocked/ Half Locked Connector

② No Terminal Backing Out

③ ④ No Wrong insert

⑤ No Missing Spot Tape

⑥ ⑦ No Missing Tape

⑧ No Missing Sponge

⑨ No Deform Terminal

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