



WORK INSTRUCTION

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Model code/Part number:

TM3

/ 7L0143-7020A

Customer:

TRQSS

Car Model:

SUBARU-ASCENT

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

August 30, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-711

Revision No.:

1

Page No.:

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PARTS:

1. Connector 7283-1138 (W); Jointed wire B-B 7L0143-2000A; Black corrugated tube Ø7, L=258±3mm (no slit)

JIG:

1. Insertion jig
2. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

n/a

Table lay-out

TABLE LAY-OUT

Connector 7283-1138 (W)/
Connector TrayBlack Corrugated tube
Ø7, L=257±3mm (no
slit)Jointed wire
(7L0143-2000A)

Wire holder

Insertion jig

Terminal cover jig

Safety Instruction

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

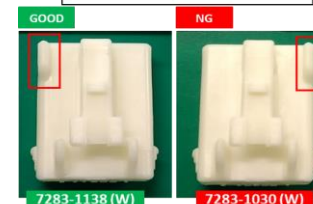
Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

CONNECTOR ILLUSTRATION



Revision History

Prepared by

Reviewed by

Approved by

Noted by

08/30/23 1 Change purpose from Pre-launch to Masspro. Inclusion of process Connector setting to Insertion jig and Wire insertion to Connector.

M. Ariola

J. Loterte

C. Villanueva

A. Arañas

07/24/23 0 Initial issue.

M. Ariola

J. Loterte

C. Villanueva

A. Arañas

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

June 24, 2023

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PARTS:		1. Connector 7283-1138 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Connector Setting to insertion jig 7283-1138 (W)	<div><div><div>Insertion Jig</div><div></div></div><div><div>Insertion Jig Orientation</div><div></div></div><div><div>Connector lock</div><div></div></div><div><div>Connector Orientation</div><div></div></div></div> <div><div><div><div>L</div><div></div><div>Press</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div></div></div><div><div><div>L</div><div><div>R</div><div></div><div>Press</div></div><div><div>2. Insert the connector 7283-1138 (W) using right hand and release the lock.</div></div></div><div><div><div>L</div><div><div>R</div><div></div><div>Release</div></div><div><div>3. Check the holes/terminal slot for Jointed wire (B).</div></div></div></div><div><div></div></div></div></div>		n/a	<div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. No wrong orientation of connector</div> <div>4. No damaged connector</div> <div><div>Connector Orientation Illustration</div><div><div><div><div>I-mark was align</div><div></div><div>GOOD</div></div><div><div>1 hole were only open</div><div></div><div>GOOD</div></div></div><div><div><div>I-mark was not align</div><div></div><div>NG</div></div><div><div>1 hole were open</div><div></div><div>NG</div></div></div><div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div></div><div>7283-1138 (W)</div></div><div><div>NG</div><div></div><div>7283-1030 (W)</div></div></div></div></div></div>

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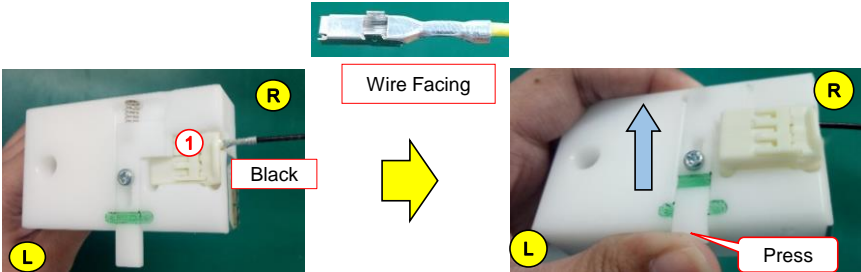
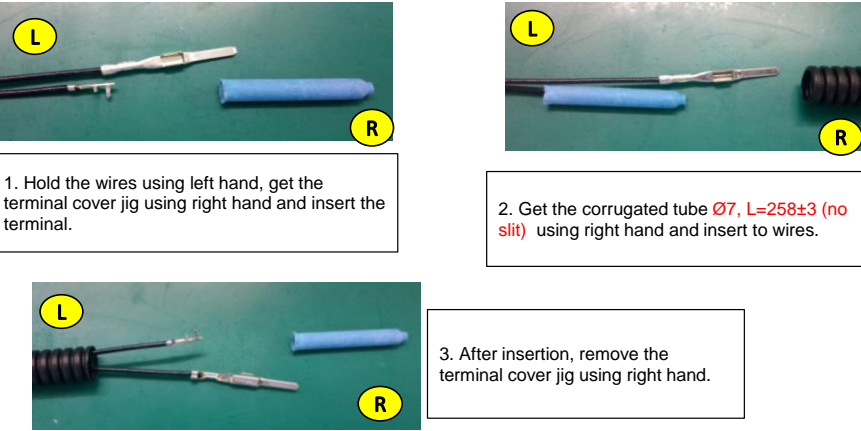
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PARTS:		1. Jointed wire B-B 7L0143-2000A 2. Black corrugated tube Ø7, L=258±3mm (no slit)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Connector 7283-1138 (W)	 <p>1. Get Jointed wire then insert to terminal slot ① using right hand.</p> <p>2. 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>		n/a	<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 during inspection.</p> <p>Important reminders/Note/s:</p> <p>1. Refer to GL-PRO-ASSY-029 for Pull-Push procedure</p>
4	Wire insertion to Corrugated tube Ø7, L=258±3mm (no slit)	 <p>1. Hold the wires using left hand, get the terminal cover jig using right hand and insert the terminal.</p> <p>2. Get the corrugated tube Ø7, L=258±3 (no slit) using right hand and insert to wires.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>		n/a	<p>1. No wrong usage of parts 2. No deformed terminal</p>

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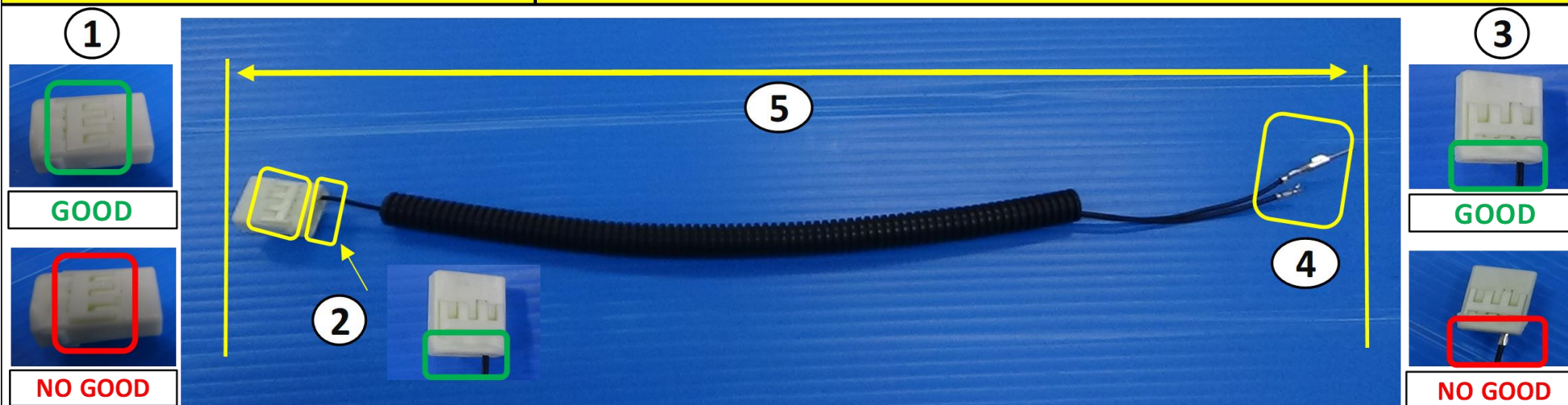
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PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**OFFLINE INSERTION****7L0143-7020A****1 No Lock connector****2 No Wrong insert****3 No Terminal Backing Out****4 No Deform terminal****5 Check the Alignment**

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