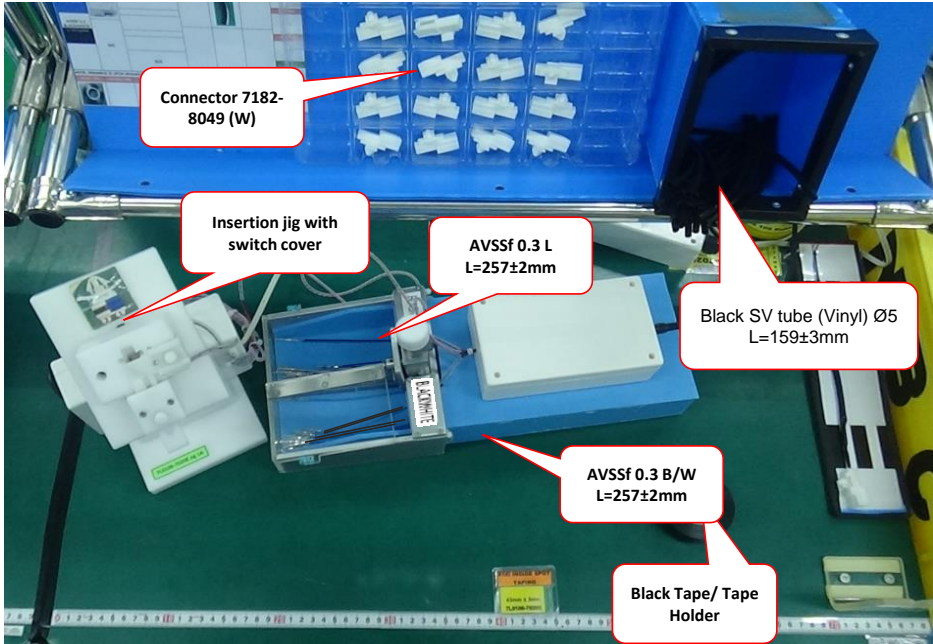




WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Process Name/Title:	J34A / 7L0106-7020F			Customer:	TRQSS	Car Model:	MAZDA MX	Effectivity Date:	October 01, 2024		
Model code/Part number:	J34A / 7L0106-7020F			Customer:	TRQSS	Car Model:	MAZDA MX	Validity Date:	n/a		
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Document No.:	WI-ENG-PDE-1077			Revision No.:	1	Page No.:	1 of 7

PARTS:	1. Connector 7182-8049 (W) ; AVSSf 0.3 (B/W, L) L=257±2mm; Black SV tube (Vinyl) Ø5 L=159±3mm; Black Tape				JIG:	1. Insertion jig with switch cover					
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS			
1	P1	BLACKWHITE Table Lay-out	<p>TABLE LAY-OUT</p>  <p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <p>Document reference/s: 1. Refer to WI-PRO-CNC-071 Wire and Strip Length Tolerance</p> <p>1. No misisng parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools</p>								
Revision History											
				Prepared by		Reviewed by		Approved by		Noted by	
10/1/24 1 Change "pre-launch to mass pro".				A.Hernandez		C.Villanueva		A.Arañes		n/a	
9/24/24 0 Initial issue.				A.Hernandez		C.Villanueva		A.Arañes		n/a	
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	September 24, 2024	

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Car Model:

MAZDA MX

Validity Date:

n/a

Document No.:

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Purpose:



PROTOTYPE



PRE-LAUNCH



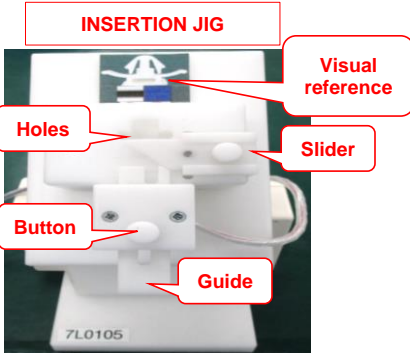
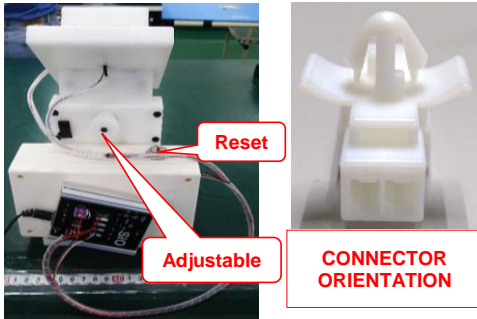
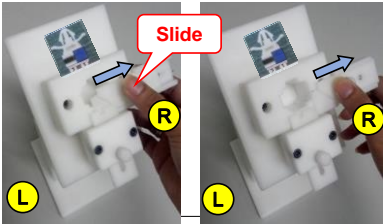
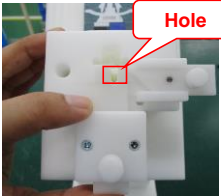
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PARTS:		1. Connector 7182-8049 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div><div><div>INSERTION JIG</div><div></div></div><div><div></div><div><div></div><div><div></div></div><div><div>1. Slide the slide lock using right thumb..</div><div>2. Insert the connector 7182-8049 (W) into jig using left hand and release the side lock using right hand. Note: Follow the connector orientation; Cannot insert the inverted connector.</div><div>3. Push the guide using left thumb. The slot for Blue wire will be opened.</div></div></div></div></div>		n/a	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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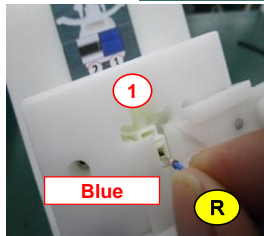
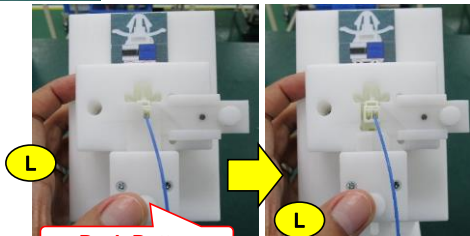
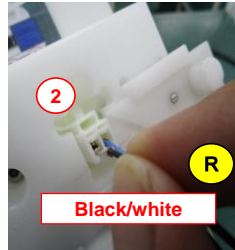
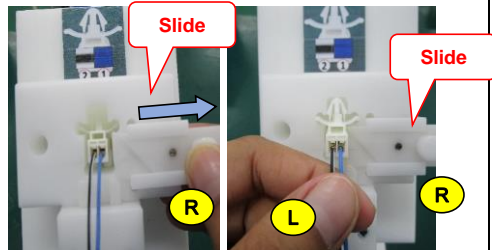
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PARTS:		1. AVSSf 0.3 L L= 257mm; B/W L= 257mm 2. Connector 7182-8049 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 7182-8049 (W)	<div><div>WIRE TERMINAL FACING</div></div> <div><div>1</div><div>Blue</div><div>R</div><div>1. Get the Blue wire then insert to terminal slot ① using right hand. Conduct Pull-Push-Pull-Push after insertion.</div></div> <div><div>L</div><div>Push Button</div><div>L</div><div>2. Press the button using left thumb. The slot for Black/White wire will be opened.</div></div> <div><div>2</div><div>Black/white</div><div>R</div><div>3. Get the Black/white wire then insert to terminal slot ② using right hand. Conduct Pull-Push-Pull-Push after insertion. Note: Insertion jig will alarm if Black/White wire will not insert before 5 seconds.</div></div> <div><div>Slide</div><div>R</div><div>L</div><div>R</div><div>4. After insertion, GO sound will be heard. Slide the slider lock using right thumb then hold the wires and gently pull out the connector from jig using left hand.</div></div>		n/a	Important reminders/Note/s: 1. Please hold the wire near terminal during insertion. 2. Insertion of wire must be inserted. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 4. Insertion jig will alarm if will not conduct Pull-Push-Pull-Push method. 5. This connector has NO DOUBLE LOCK , proper insertion method must be followed. 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip lenght Tolerance 2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure.

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Car Model:

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PROTOTYPE



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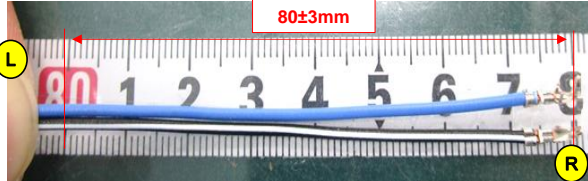
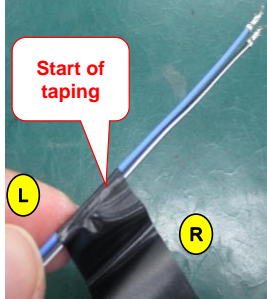
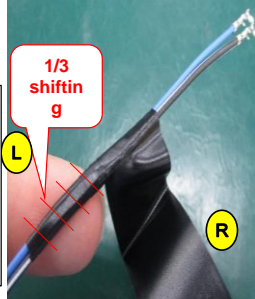

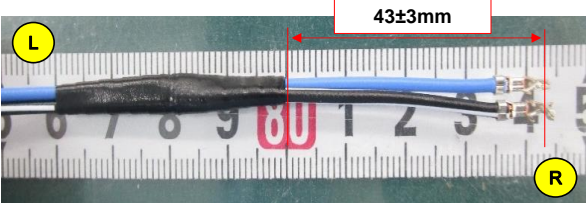

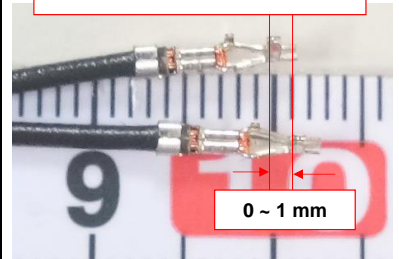
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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 1 Wire taping	<div><p>1. Hold the wires using left hand then measure 80±3mm up to terminal pointed tip using both hands.</p></div> <div><p>2. Initially attach Black tape using right hand then make 2 windings of tape before shifting.</p></div> <div><p>3. Make 1/3 shifting of tape then continue the taping process using both hands.</p></div> <div><p>4. Confirm measurement then make 3 windings of tape before cut.</p></div> <div><p>5. After taping, check the measurement, taping condition and terminal appearance.</p></div>		<div>Measuring Tape</div> 	<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape</p> <div>WIRE ALIGNMENT TOLERANCE</div> 

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J34A / 7L0106-7020F

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PROTOTYPE



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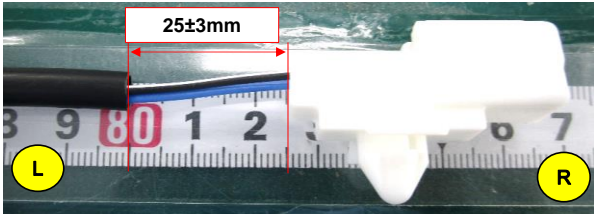
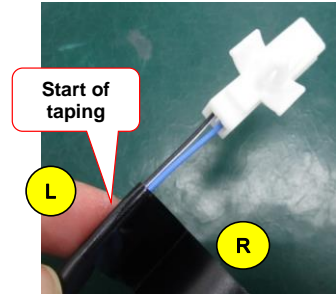
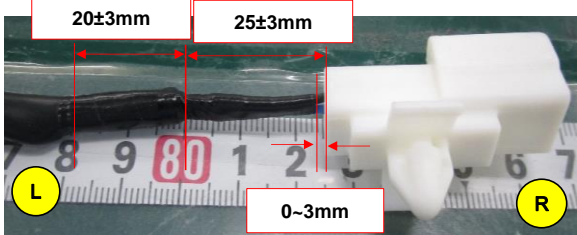

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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=159±3mm		3. Black tape	JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to Black SV tube (Vinyl) Ø5 L=159±3mm	<div><div></div><div><p>1 Get the SV tube (Vinyl) Ø5 L=159±3mm using right hand then insert the L-B/W wires using left hand.</p></div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal
6		Taping 2 Black SV tube (Vinyl) to wire near connector	<div><div><div><p>25±3mm</p></div><div><p>1. Hold the SV tube (Vinyl) using left hand then measure from end of vinyl tube up to edge of connector 25±3mm using both hands.</p></div></div><div><div><p>Start of taping</p></div><div><p>20±3mm 25±3mm 0~3mm</p></div><div><p>2. Hold the SV tube (Vinyl) using left hand, get the Black tape using right hand then start taping process using both hands.</p></div><div><p>3. After taping, check the taping condition and measurement.</p></div></div></div>		<div>Measuring Tape</div> 	<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Please refer to GL-PRO-ASY-001 for taping procedure.</p> <p>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape</p>

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PROTOTYPE



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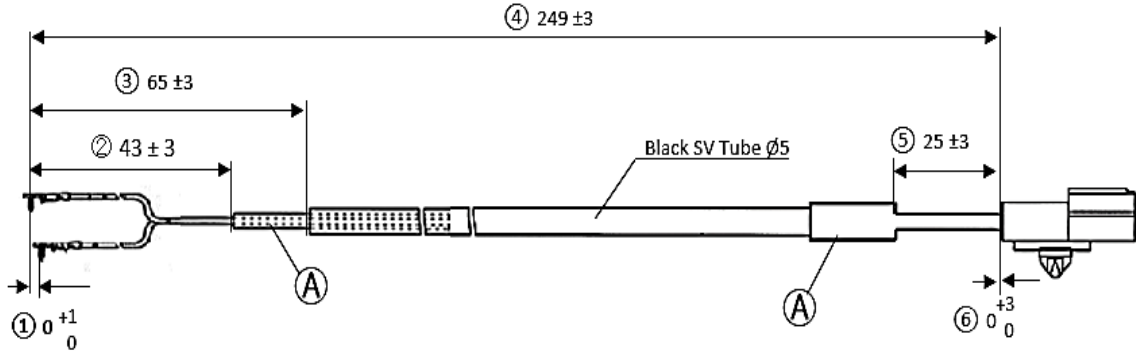
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PARTS:		1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	Measurement			<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>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

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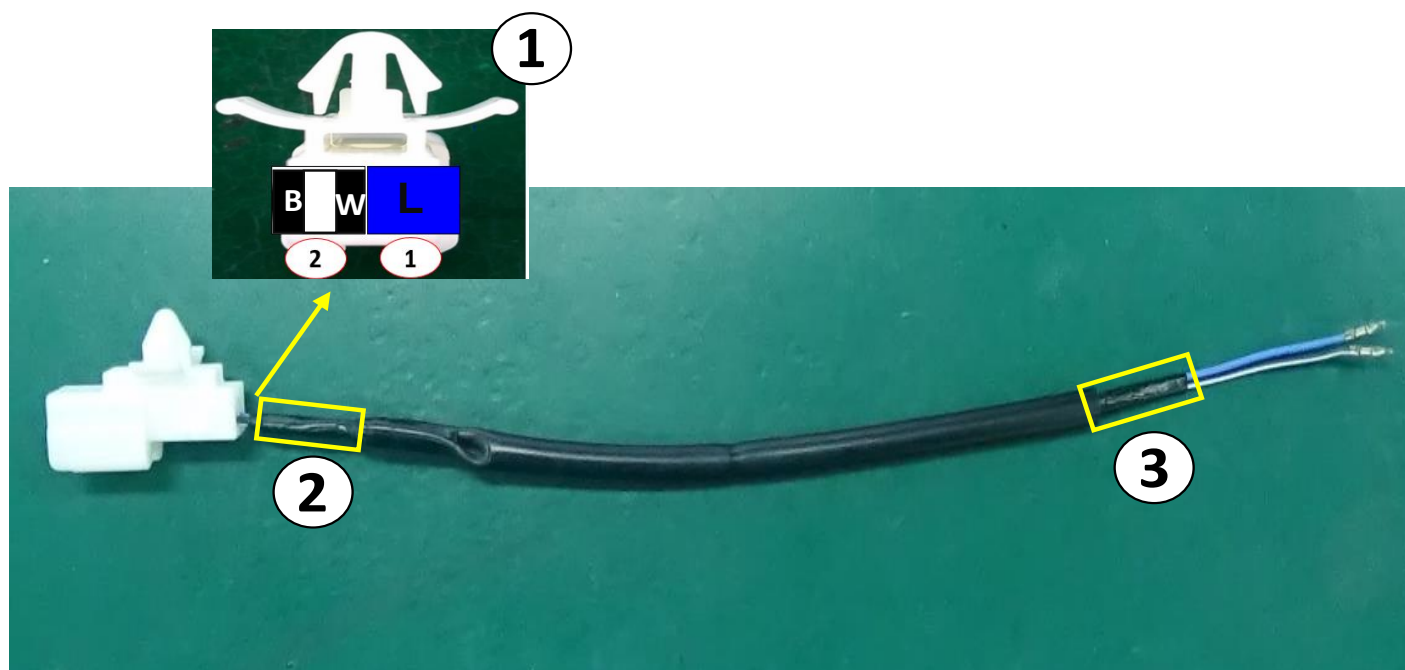
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P1****7L0106-7020F****① No Wrong Insert****② No Missing Tape****③ (Black Tape)****④ No Deformed Terminal****⑤ No Terminal Backing Out**

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