

**WORK INSTRUCTION****OFFLINE ASSEMBLY PROCESS**

Process Name/Title:

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

Customer:

TRQSS

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

September 30, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-327

Revision No.:

1

Page No.:

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| PARTS: | | 1. Connector 7283-1030 (W); Jointed wire B-B 7L0113-2000; Black corrugated tube Ø7, L=218±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 | | <div>TABLE LAY-OUT</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>1. No missing parts/tools 2. No excess parts/tools</div> <div>CONNECTOR ILLUSTRATION</div> <div>GOOD 7283-1030 (W)</div> <div>NG 7283-1138 (W)</div> | |
| Revision History | | | | | | |
| 09/30/22 | 1 | Improve: Work procedure/Illustration on process no. 3 And 4; Quality pointers nad notes on page no. 1 and 3. | | M. Ariola | J. Loterte | C. Villanueva |
| 08/26/21 | 0 | Initial issue | | D. Castillo | C. Villanueva | A. Shimamura |
| Eff. Date | Rev. No | Details of Change | | Revised | Reviewed | Approved |
| | | | | Noted | Est. Date: | August 26, 2021 |

| Prepared by | Reviewed by | Approved by | Noted by |
|---------------|----------------|-------------------|--------------|
| M. Ariola | J. Loterte | C. Villanueva | A. Arias |

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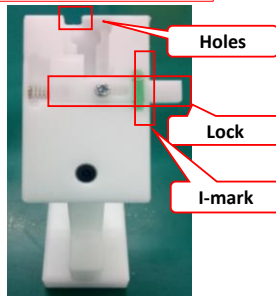
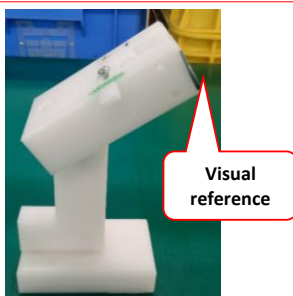


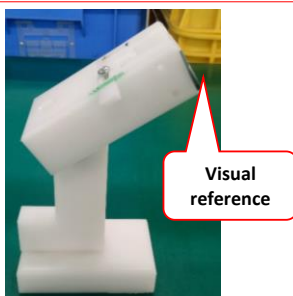
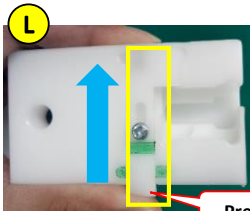
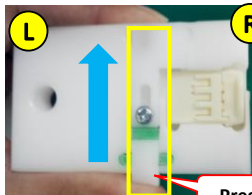
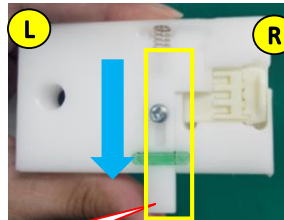
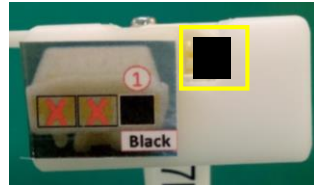
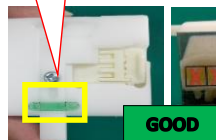

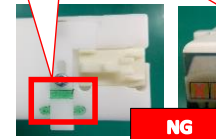
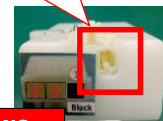
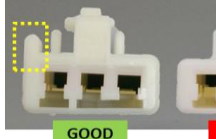
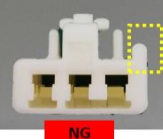
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PARTS:

1. Connector 7283-1030 (W)

JIG

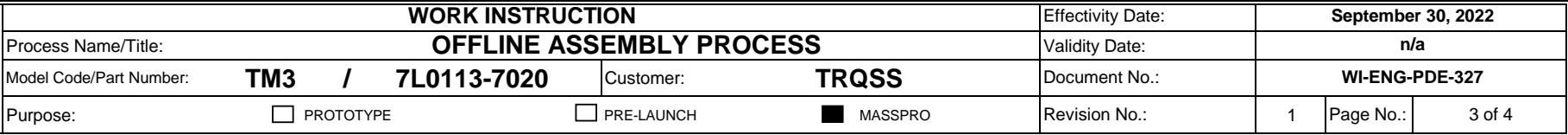
1. Insertion jig

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|-----|--------------|--|--|-----------|------------------|
| 2 | n/a | Connector Setting to insertion jig 7283-1030 (W) | <div><div><div><div>Insertion Jig</div></div><div><div>Insertion Jig Orientation</div></div><div><div>Connector lock</div></div><div><div>Connector Orientation</div></div><div><div>Visual reference</div></div></div><div><div><div><div>L</div></div><div><div>L</div></div><div><div>L</div></div></div><div><div>Press</div><div>Press</div><div>Release</div></div><div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 7283-1030 (W) using right hand and release the lock.</div><div>3. Check the holes/terminal slot for Jointed wire (B).</div></div><div></div></div></div><div>n/a</div><div><div><div>Connector Orientation Illustration</div><div><div>I-mark was align</div></div><div><div>1 hole were only open</div></div><div><div>I-mark was not align</div></div><div><div>1 hole were open</div></div></div><div><div>Connector Differences</div><div><div>GOOD</div></div><div><div>NG</div></div></div><div><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></div> | | |

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| PARTS: | | 1. Assy parts 2. Black corrugated tube Ø7, L=218±3mm (no slit) | | | JIG | 1. Terminal cover jig |
|--------|--------------|---|--|--|-----|---|
| NO. | PROCESS NAME | | 1 WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | | QUALITY POINTERS |
| 4 | n/a | Wire insertion to Corrugated tube Ø7, L=218±3mm (no slit) | <div><p>1. Hold the wires using left hand, get the terminal cover jig using right hand and insert the terminal.</p></div> <div><p>2. Get the corrugated tube Ø7, L=218±3 (no slit) using right hand and insert to wires.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div> | <div>TERMINAL COVER JIG</div>  | | 1. No wrong usage of parts 2. No deformed terminal |

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