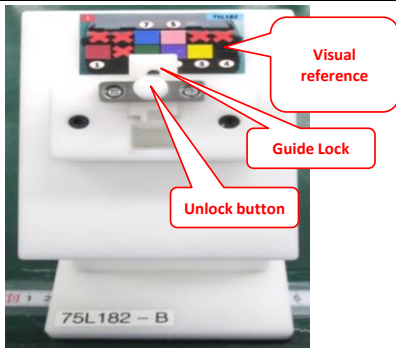
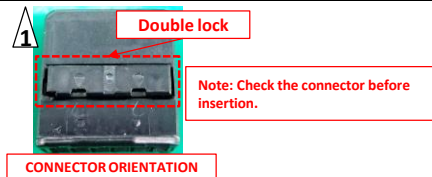
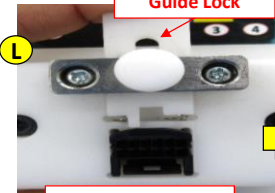
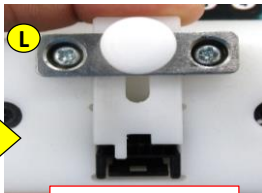
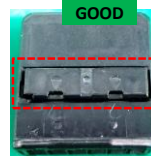



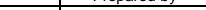




WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	June 15, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-297B		
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Process Name/Title:	TAPING ASSEMBLY PROCESS		
Product Name/Code:	011B / 75L182-0031	Customer:	TRJ
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	1. Connector 1746872-1 (B)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	<div><div><div><p>75L182 - B</p><p>INSERTION JIG</p></div><div><div><p>1. Get the connector 1746872-1 (B) using right hand then insert to insertion jig. <i>Note: Follow the connector orientation above.</i></p></div><div><div><p>BEFORE PRESSING</p></div><div><p>AFTER PRESSING</p></div><div><p>2. Press the guide lock using left index finger. You will notice the holes that needs to be inserted are only open.</p></div></div></div></div><div><div><p>Safety Instruction</p><p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p></div><div><p>Housekeeping</p><p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p></div><div><p>Alert level</p><p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p></div></div></div>	<div><p>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p></div> <div><p>1. CONNECTOR LOCK APPEARANCE CHECK</p><div><div><p>GOOD</p><p>UNLOCK</p></div><div><p>NG</p><p>HALF-LOCKED</p></div></div><p>1. <i>Note: Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</i></p></div>	

Revision History						Prepared by	Reviewed by	Approved by	Noted by
06/15/21	1	Transfer process owner from Production (WI-PRO-ASY-017) to Engineering (WI-ENG-PDE-297B). Apply some improvements and update pictures in all process.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes			
07/10/17	0	Initial issue	J. Montañallo L. Briones	O. Merin	T. Sugiyama	n/a	M. Catapang	C. Villanueva	A. Shimamura
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted
						Est. Date:	July 10, 2017		

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WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Product Name/Code: **011B / 75L182-0031**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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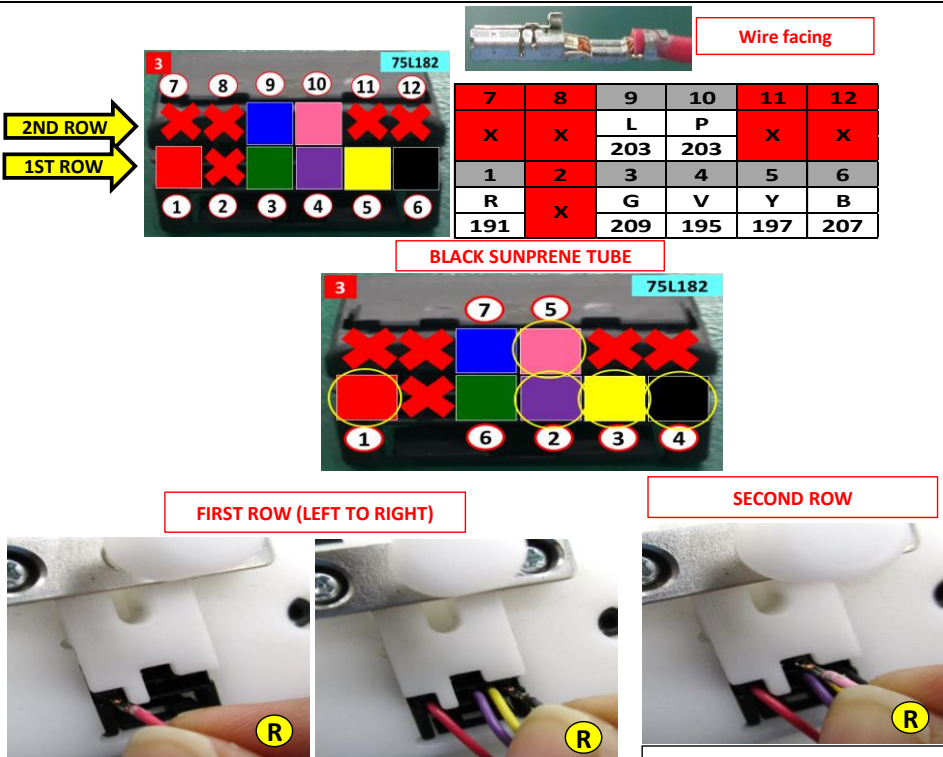
2 of 6

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Wire insertion to connector 1746872-1 (B)	<div><p>1. Insert the wires from Black Sunprene tube. Hold the R wire and insert to terminal slot 1 using right hand. Repeat the process for V-Y-B wires <i>Note: Follow the insertion sequence based on the illustration stated above.</i></p><p>2. Hold the P wire and insert to terminal slot 10 using right hand. <i>Note: Follow the insertion sequence based on the illustration stated above.</i></p></div>	n/a	<div><p>1. Use the provided jig per model</p><p>2. No wrong use of parts</p><p>3. No wrong insertion of wires</p><p>4. No deformed terminal</p><p>5. One by one insertion</p><p>6. No stuck-up of terminal tip</p></div> <div><p>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p></div> <div><p>Note: Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</p></div>

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☐ PRE-LAUNCH

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

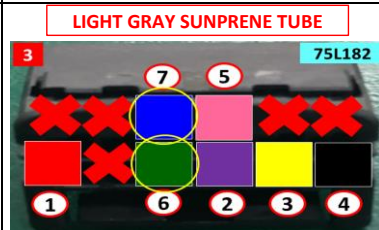
TOOLS/PPE

QUALITY POINTERS

2

P2

Wire insertion to connector 1746872-1 (B) (Continuation)



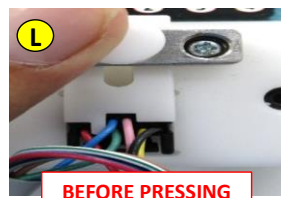
FIRST ROW (RIGHT TO LEFT)



3. Insert the wires from **Black sunprene tube**. Hold the **G wire** and insert to terminal **slot 3**.
Note: Follow the insertion sequence based on the illustration stated above.



4. Hold the **L wire** and insert to terminal **slot 9**.
Note: Follow the insertion sequence based on the illustration stated above.



BEFORE PRESSING



AFTER PRESSING

1. Press the unlock button using left thumb.



6. Hold the wires using right hand and gently pull-out the connector from jig.

n/a

1 **Note: Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force.**

1 **Note: Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.**

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH





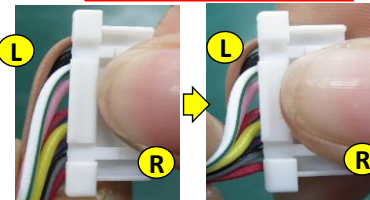


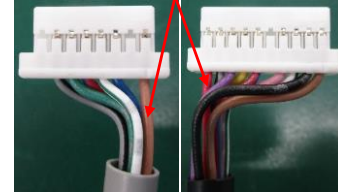
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PARTS:		1. Assy parts		JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Connector Lock	 1. Put the connector on locking jig and push down 2x using both hands. Touch the connector lock to check if properly locked.   BEFORE PRESSING AFTER PRESSING		 LOCKING JIG	NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK 1. Use the provided locking jig per model 2. No unlocked/half-locked connector
4	Wire folding	 1. Hold the connector PBVP-10V-S (W) using left hand and slightly fold the wires from Black sunprene tube (as shown in illustration above) using right hand. Repeat the process for connector of Light Gray sunprene tube.   BEFORE FOLDING AFTER FOLDING		n/a	1. No wrong orientation of connector 2. No tangled wires 3. No terminal backing out BR and R wire must be straight 

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TAPING ASSEMBLY PROCESS

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Product Name/Code:

011B / 75L182-0031

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Purpose:

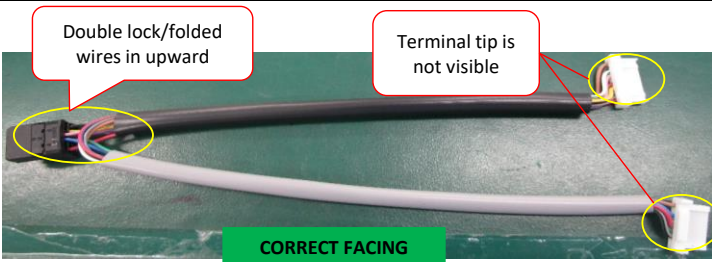
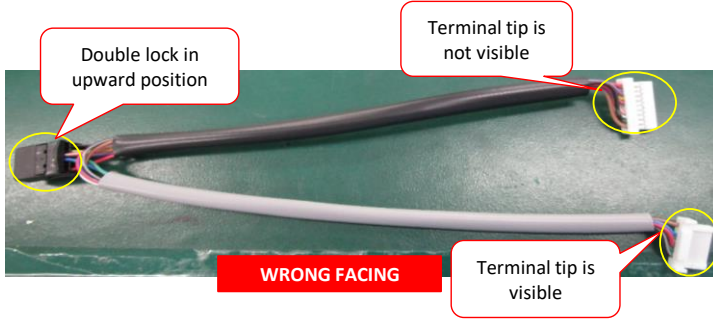
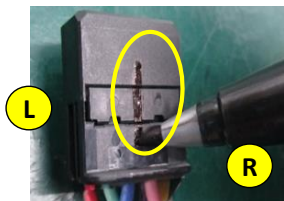


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Wire folding (Continuation) P2	 		n/a	1. No wrong facing 2. No tangled wires
5	Marking	 1. Hold the connector using left hand, get the marker and put mark on connector lock to check the lock condition. 		MARKER 	1. No missing mark Note: Marking should be at the center part of connector lock as standard location of mark.

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☐ PRE-LAUNCH

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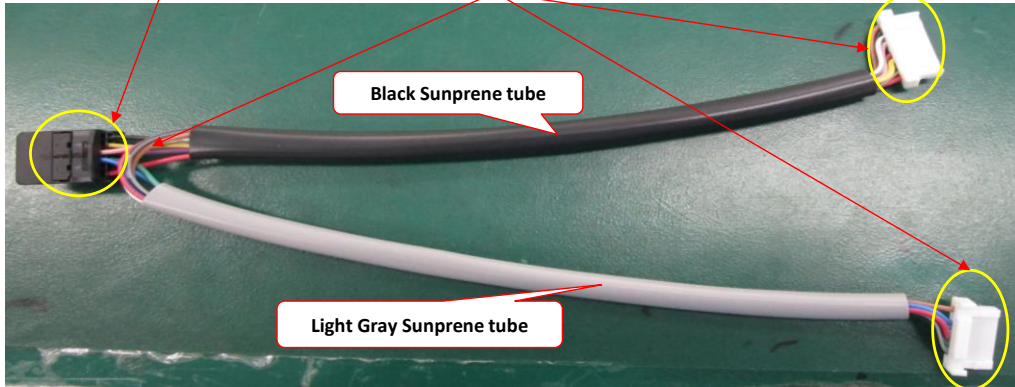

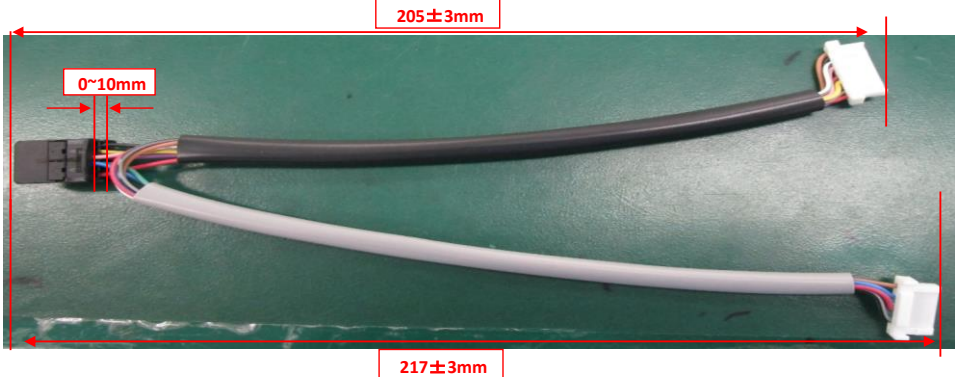

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PARTS:	n/a		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	<div>1</div> <div>Visual/By two's inspection</div> <div>P2</div>	<div><div>1. Check the connector lock.</div><div>2. Check the wire alignment. Make sure no tangled wires.</div><div>3. Check the terminal if with backing out (not fully inserted) or deformed terminal.</div></div> <div></div> <div><div>4. Compare to Master Sample</div><div><i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></div></div>		<div></div>	<div>MASTER SAMPLE</div>
7	<div>1</div> <div>Measurement</div>	<div></div> <div><div>1</div><div>Measuring tape</div><div></div><div><div>Note:</div><div>Please use calibrated/verified measuring tape when getting the measurement.</div></div></div>		<div><div>NOTE: FOR HATSUMONO AND OWARIMONO</div></div> <div>1. No wrong dimension</div>	

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