



# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

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Validity Date:	n/a		
Document No.:	WI-ENG-PDE-144		
Revision No.:	2	Page No.:	1 of 5

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

Product Name/Code: **740A / Z02-81090-R740A** Customer: **NBC-HAYASHI**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

**PARTS:** 1. Connector PAP-02V-S (W)  
2. Connector 7282-5845 (W)

**JIG:** 1. Insertion jig with lock

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 2 Connector setting to Insertion jig	<p><b>Insertion Jig</b></p> <p>Visual reference</p> <p>Connector locking handle</p> <p>Connector receiver base</p> <p>(1) Lock</p> <p>(2) Lock</p> <p>Visual reference</p> <p>Connector receiver base</p> <p>Adjustable stand</p> <p><b>GOOD</b></p> <p>Terminal lock</p> <p>Connector lock</p> <p><b>Connector orientation</b></p> <p><b>Press</b></p> <p>1. Hold the insertion jig using left hand, get the connector <b>7282-5845 (W)</b> using right hand and insert to Insertion jig. Press the lock (1) using right hand and proceed to next process.</p> <p>2. Hold the insertion jig using left hand, get the connector <b>PAP-02V-S (W)</b> using right hand and insert to Insertion jig. Press the lock (2) using right hand and proceed to next process.</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> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>NG</b></p> <p><b>Connector orientation</b></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>

## Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by	Reviewed by	Approved by	Noted by
01/21/21	2	Change 2x pulling to Pull-Push-Pull-Push in insertion quality pointers; Remove cycle time; Change connector colors in accordance with standardization for plastic parts; Combine the insertion and locking process due to combined jig for insertion and locking.	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes
07/28/20	1	Change Part number only	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes

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Revision No.:

2

Page No.:

2 of 5

### PARTS:

1. AVSS 0.3 wires R L=177mm; B L=117mm

### JIG

1. Insertion jig with lock

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

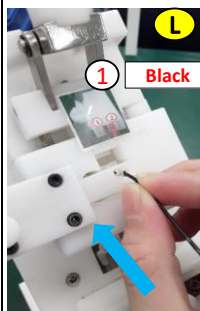
### QUALITY POINTERS

2

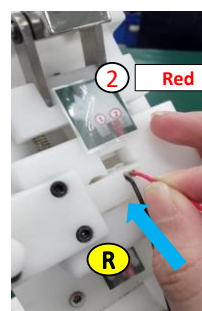
P1

2

Wire Insertion to  
Connector 7282-5845  
(W)  
and locking

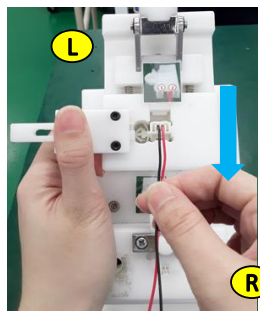


Black



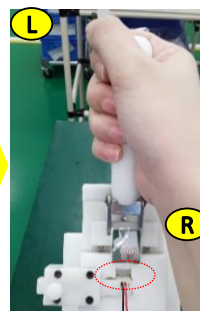
Red

1. Hold the insertion jig using left hand, get the **Black wire** using right hand and insert to connector. Repeat the process for **Red wire**.  
*Note: Follow insertion sequence based on visual reference attached to jig.*



3. Press the lock (1) using left hand and gently pull out the assy parts using right hand. Check the insertion.

Wire facing



2. Hold the insertion jig using left hand. Pull down the Connector locking handle using right hand to lock the connector. Make it 2x to ensure that the connector lock is already pressed.



n/a

2

- Note: Please hold the wire near terminal during insertion.*
1. No loose insertion
  2. No wrong insertion
  3. One by one insertion
  4. No deform terminal
  5. No wrong wire facing.
  6. No unlock connector
  7. No half-locked connector
  8. No damaged connector lock

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

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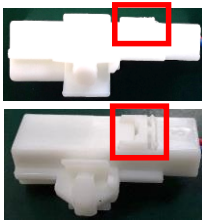
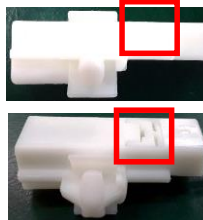
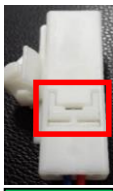


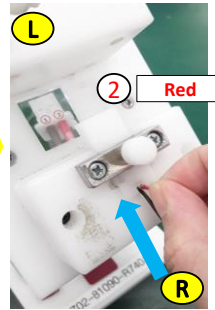

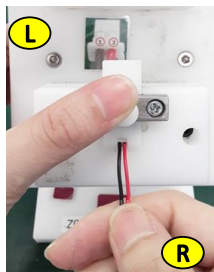

3 of 5

PARTS:  $\Delta$  2

1. Assy parts

JIG

1. Insertion jig with lock

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire Insertion to Connector 7282-5845 (W) and locking (continuation)	<p>4. Check the condition of lock.</p> <p><i>Please refer to GL-PRO-ASY-017 for verification of connector lock.</i></p>     <p>Before Pressing      After Pressing      GOOD      NG</p>	n/a	<ol style="list-style-type: none"><li>1. No unlock connector</li><li>2. No half-locked connector</li><li>3. No damaged connector lock</li></ol>
3	Wire Insertion to Connector PAP-02V-S (W)	   <p>1. Hold the insertion jig using left hand, get the <b>Black wire</b> using right hand and insert to connector. Repeat the process for <b>Red wire</b>.</p> <p><i>Note: Follow insertion sequence based on visual reference attached to jig.</i></p>   <p>2. Press the lock (2) using left thumb and gently pull out the assy parts using right hand. Check the insertion and terminal tip appearance.</p> <p>Note: Terminal tip must be visible.</p>	n/a	<p><i>Note: Please hold the wire near terminal during insertion.</i></p> <ol style="list-style-type: none"><li>1. No loose insertion</li><li>2. No wrong insertion</li><li>3. One by one insertion</li><li>4. No deform terminal</li><li>5. No wrong wire facing.</li></ol> <p>Make sure wires are properly inserted.</p> <p>Conduct <b>Pull-Push-Pull-Push</b> after insertion.</p> <p>Do not exert extra force.</p>

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WI-ENG-PDE-144

Revision No.:

2

Page No.:

4 of 5

PARTS:

1. Assy parts

JIG

1. Continuity checker jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P1

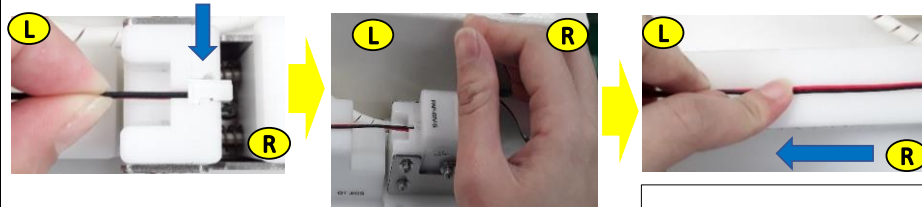
Continuity checking

### SETTING AND REMOVAL SEQUENCE



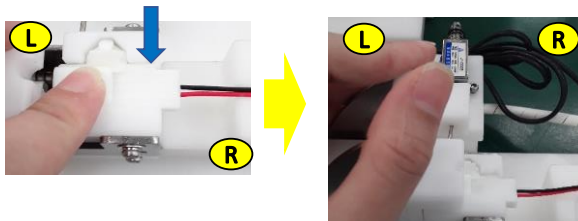
Connector setting

Connector setting



1. Get the assy parts using both hands. Put first the small connector PAP-02V-S to checker 1 and plug in using right hand.

2. Secondly, put the wires on wire guide. Straighten the wire and make sure no curve wires.



3. Lastly, put the connector 7282-5845 on checker 2 using left hand. Go sound will be heard after marking.

4. Plug-out the checker same as how to set the harness using both hands. Conduct **Point checking** and remove the assy parts carefully.

n/a

1. No wrong setting and attachment of harness to continuity test.  
2. If encountered problem, apply **STOP, CALL** and **WAIT**.

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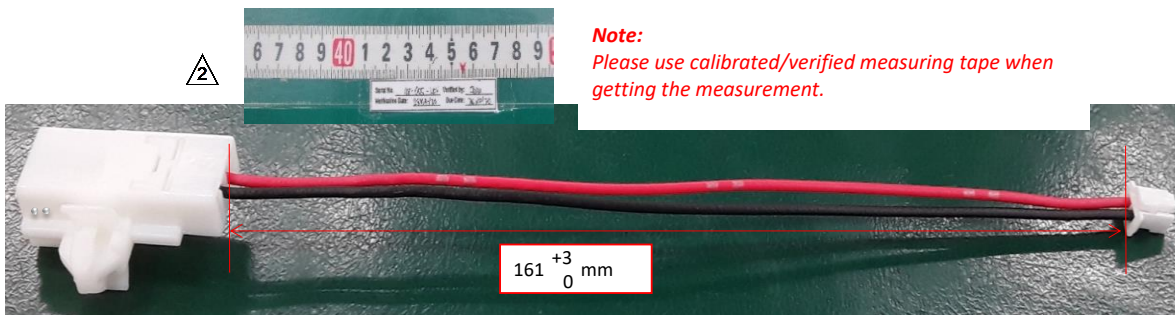
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2

Page No.:

5 of 5

PARTS:		n/a	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	<div>2</div> Visual/By two's inspection	<div>1. Check the connector lock and presence of marking. <i>Refer to GL-ENG-PDE-013 for Traceability Marking matrix.</i></div> <div>2. Check the wire insertion if there is terminal backing out.</div> <div></div> <div>3. Compare to Master Sample. <i>Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.</i></div>		<b>Master Sample</b> 
6	Measurement	<div>2</div> <div></div> <div><b>Note:</b> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div>161<sup>+3</sup><sub>0</sub> mm</div>		<div><b>NOTE: HATSUMONO AND OWARIMONO</b></div> <div>1. No wrong dimension</div>

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