

	WORK INSTRUCTION				Effectivity Date:		August 07, 2024	
	Process Name/Title: SUB-ASSEMBLY/ CONTINUITY TESTER MACHINE SET-UP				Validity Date:		n/a	
	Model code/Part number: GC7 / 15E210-0091		Customer: TRP	Car Model: LEGACY	Document No.:		WI-ENG-PDE-130	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.: 1 of 4

PARTS:	n/a			JIG:	1. Continuity test machine 2. Tester jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
1	P3 Machine Set-up	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> Jig Connector </div> <div style="text-align: center;"> Jig Connection Cable </div> <div style="text-align: center;"> Screw </div> </div> <p style="text-align: center;">1. Attach the jig inspection cable to jig connector. Fix by tightening the 2 screw using screw driver.</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> 2. Connect the Input for OK marking. </div> <div style="text-align: center;"> 3. Plug the power cord plug into the power outlet. </div> </div> <div style="text-align: center;"> 4. Push the button to turn-on the machine </div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	<div style="display: flex; align-items: center;"> <div style="border: 1px solid red; padding: 5px; margin-right: 10px;"> <div style="text-align: center;">3</div> Machine Setup </div> </div> <p>1. Make sure that the power switch on the main unit is set to "OFF".</p> <p>2. Before connecting cables and jigs, please turn off the power of the main unit.</p> <p>3. Reset counter every after "END" of shift.</p>			

Revision History						Prepared by		Reviewed by		Approved by		Noted by	
08/07/24	3	Change Tester jig from checker to mating connector due to improvement.	D.Castillo	C.Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a			
01/25/21	2	Extension of validity date. Remove cycle time.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes							
06/22/20	1	Transferred process owner from Production to Engineering. Changed control number from WI-PRO-ASY-159 to WI-ENG-PDE-130. Additional cycle time.	M. Catapang	J. Loterte	A. Shimamura	A. Arañes							
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 3, 2019					

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Model code/Part number:

GC7 / 15E210-0091

Customer: TRP

Car Model:

LEGACY

Document No.:

WI-ENG-PDE-130

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

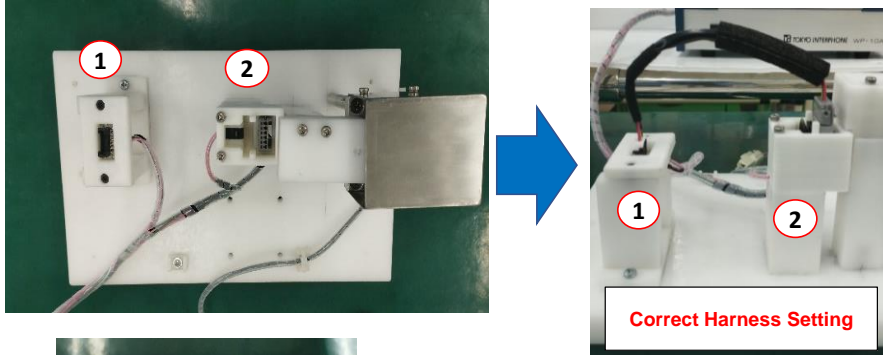
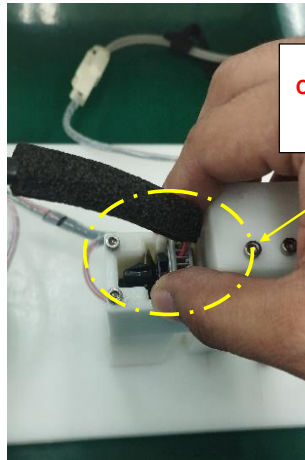
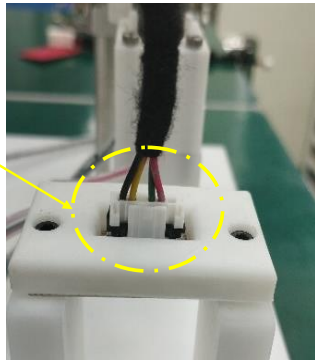
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PARTS:	1. Assy parts		JIG:	1. Continuity test machine 2. Tester jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	<div>3</div> <div>P3</div> <div>Wire harness testing</div>	<div></div> <div><div>Correct facing of the connector</div></div> <div><div>Correct facing of the connector</div></div> <div><div>1. Insert the connector 7282-5978-40 (GR) to Location 1 using right hand. Note: Hold the harness on connector part only.</div><div>2. Insert the connector 505570-0600 (W) to Location 2 using left hand. Marking will automatically punch to connector & sound will be heard if result was GOOD. Note: Hold the harness on connector part only.</div></div>	n/a	<div>Document reference/s: 1. Conduct equipment inspection before start of operation, refer to F-PRO-ASY-029 for Taping assembly process</div> <div>1. No damage or broken connector 2. Hold only on connector during insertion 3. No wrong setting of connector</div>

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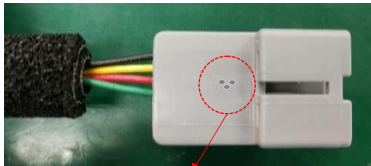
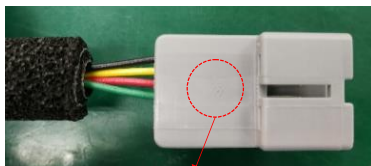

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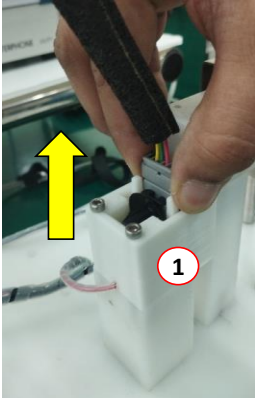

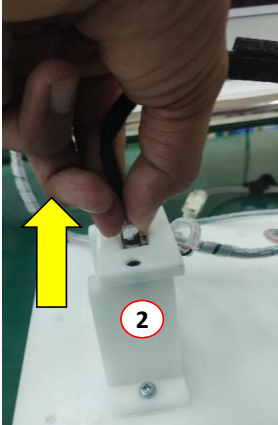


PARTS:	1. Assy parts		JIG:	1. Continuity test machine 2. Tester jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3 Wire harness testing (Continuation)	<div><div><div>GOOD RESULT</div><div><div>CORRECT LED LIGHT is ON</div></div></div><div><div>NG RESULT</div><div><div>Wiring numbers LED light are ON</div></div></div><div><div><div>With MARKING (THREE DOTS)</div></div><div><div><div>NO MARKING (THREE DOTS)</div></div></div><div><div><div>3. Conduct point checking if result was OK.</div></div></div></div><div>n/a</div><td><div>Important reminders/Note/s: 1. Declared marking is for visual reference only.</div><div>Document reference/s: 1. Refer to GL-ENG-PDE-010 for GC7 Traceability Marking Matrix.</div><div>1. If the result was NG, STOP, CALL the attention of the leader & WAIT for further instruction.</div></td></div>	<div>Important reminders/Note/s: 1. Declared marking is for visual reference only.</div> <div>Document reference/s: 1. Refer to GL-ENG-PDE-010 for GC7 Traceability Marking Matrix.</div> <div>1. If the result was NG, STOP, CALL the attention of the leader & WAIT for further instruction.</div>	

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
2	P3 <div>3</div> Harness removal from tester jig	<div><div>1. Remove the connector 505570-0600 (W) from location 2. <i>Note: Hold the harness on connector part only.</i></div><div>2. Remove the connector 7282-5978-40 (GR) from location 1. <i>Note: Hold the harness on connector part only.</i></div><div><div>3. After removal from jig, check the presence of marking.</div></div></div>			n/a	Document reference/s: 1. Refer to GL-ENG-PDE-010 for GC7 Traceability Marking Matrix. 1. No broken connector 2. Do not hold on wires during removal from jig 3. Marking should be visible		

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