



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number:

D94L

/ 7N0030-7020

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

October 22, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-054A

Revision No.:

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Page No.:

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PARTS:		1. Connector 7282-1027 (W); Connector 4G5400-0000 (W); Black SV tube (Vinyl) Ø7 L=74±3mm; Black Corrugated tube (no slit) Ø7 L=245±3mm; Black SV tube (Vinyl) Ø5 L=119±3mm; Black Vinyl tube Ø7 L=32±3mm; AVSSf 0.3 P L=439±2mm; AVSSf 0.3 OR L=439±2mm ±2mm; AVSSf 0.3 wire B L=685±3mm; AVSSf 0.3 wire Y L=510±2mm; AVSSf 0.3 wire B L=919±3mm; Blue tape					JIG:		1. Insertion jig w/ and w/o Switch cover 2. pushing jig 3. Locking jig			
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION					TOOLS/PPE		QUALITY POINTERS	
1		P1		<div><div>Connector 7282-1027 (W)/ Connector tray</div><div>Connector 4G5400-0000 (W)/ Connector tray</div><div>Black SV tube (Vinyl) Ø5 L=119±3mm</div><div>Connector 6098-2220 (W)/ Connector tray</div><div>Black SV tube (Vinyl) Ø7 L=74±3mm</div><div>Black Corrugated tube (no slit) Ø7 L=245±3mm</div><div>Locking jig Connector- (6098-2220) (W)</div><div>Insertion jig (A) with switch cover</div><div>Insertion jig (B)</div><div>Insertion jig (C)</div><div>Insertion jig D</div><div>Locking jig</div><div>Pushing jig</div><div>Tape holder/ Blue tape</div><div>AVSSf 0.3 P L=439mm ±2mm</div><div>AVSSf 0.3 OR L=439mm ±2mm</div><div>Black SV tube (Vinyl) Ø7 L=32±3mm</div><div>AVSSf 0.3 wire B L=685±3mm</div><div>AVSSf 0.3 wire Y L=510±2mm</div><div>AVSSf 0.3 wire B L=919±3mm</div></div> <div>TABLE LAY-OUT</div>					<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>		<div>1. No missing parts/tools. 2. No excess parts/tools.</div> <div>Document reference/s: 1. Refer to WI-PRO-CNC-017- for Wire and Strip length tolerance.</div>	
Revision History												
10/22/24	5	Additional Work procedure/Illustration and notes on page 12-13 as countermeasure for the customer claim (Broken lock of connector 6098-2220 (W)).				D.castillo	C. Villanueva	A. Arañes	n/a	<div><div>Prepared by</div><div>Reviewed by</div><div>Approved by</div><div>Noted by</div></div>	<div><div>Prepared by</div><div>Reviewed by</div><div>Approved by</div><div>Noted by</div></div>	
06/07/23	4	Excluded process no.2,3 and 4 from Offline Assembly Process transfer to P1; Transfer process no.8, 13 and 14 from P1 to P2 due to change process distribution. Inclusion of Quality Checkpoints on page no.14. Improve Quality Checkpoints: Reminders/notes and references. Change table lay-.out. Inclusion of Locking process for Connector 6098-2220 (W); Standardized tube description: SV tube (Vinyl)				M. Ariola	J. Loterte	C. Villanueva	A. Arañes			
04/26/21	3	Change connector color in accordance with color standardization for plastic parts Refer to GL-COM-003				J. Loterte	C. Villanueva	A. Shimamura	A. Arañes			
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	December 07, 2019	

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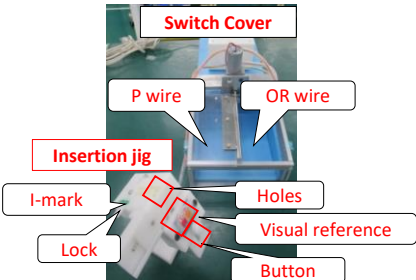
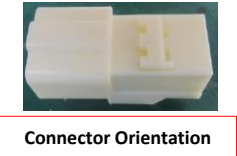
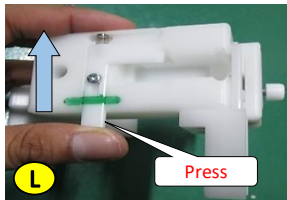
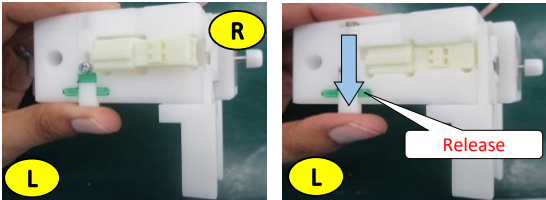
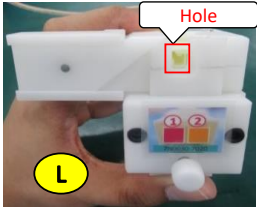
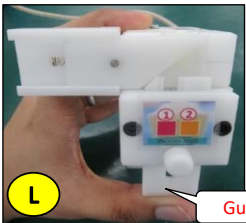

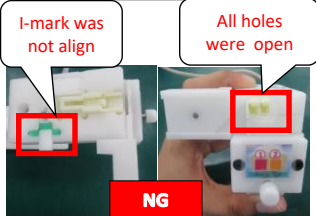
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PARTS:		1. Connector 7282-1027 (W)		JIG:	1. Insertion jig 2. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<p>Connector setting to insertion jig 7282-1027 (W)</p>       <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Get the connector (7282-1027) using right hand and insert to insertion jig. Release the lock after insertion.</p> <p>3. Push the guide upward using left hand. The slot for Pink wire will be open.</p>		n/a	<p>Connector Orientation Illustration</p>   <p>1. Use the provided jig tool per model 2. No wrong orientation of connector</p>

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PARTS:

1. AVSSf 0.3 P L=439±2mm; OR L=439±2mm

JIG:

1. Insertion jig
2. Pushing jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

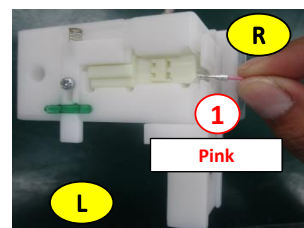
TOOLS/PPE

QUALITY POINTERS

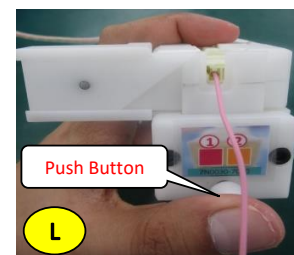
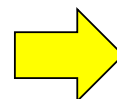
3

P1

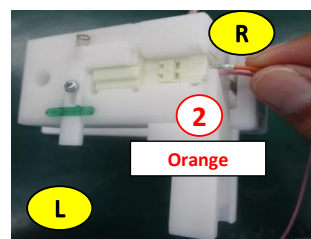
Wire insertion to
Connector
7282-1027 (W)



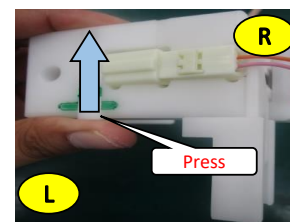
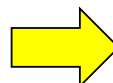
1. Hold the insertion jig using left hands. Get **Pink wire** then insert to terminal slot **①** using right hand.



2. After insertion of Pink wire press the button using left hand. The slot for **Orange wire** will be open.



3. Get **Orange wire** then insert to terminal slot **②** using right hand.



4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.

N/A

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

Important reminders/Note/s:

1. Please hold the wire near terinal during insertion
 2. Insertion of wire must be from left to right.
 3. Make sure wires are properly inserted.
- Conduct Pull-Push-Pull-Push after insertion.**
- Do not exert extra force.**

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
2. Refer to GL-PRO-ASY-029 fro Pull-Push procedure.

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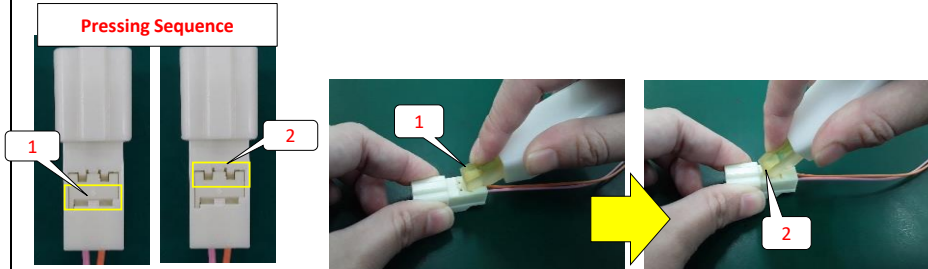
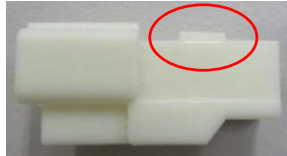


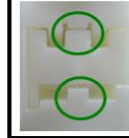
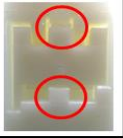
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PARTS:		1. Assy parts			JIG:	1. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P1	<div><p>Pressing Sequence</p><p>1. Place the connector on the table while holding using left hand. Get the pushing jig using right hand and start the sequential locking based on above illustration. Push the lower part of the conector lock first and then push the upper part <i>Position of pushing jig during locking must be slant.</i></p><div><div><p>Before pressing</p></div><div><p>After pressing</p></div></div></div>			<div><p>PUSHING JIG</p></div>	<p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock</p> <div><div><p>GOOD</p></div><div><p>NG</p></div></div> <p>1. No unlocked/half-locked connector</p>

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PARTS:		1. Black SV tube (Vinyl) Ø7 L=74±3mm 2. Black Corrugated tube (no slit) Ø7 L=245±3mm	3. Black Vinyl tube Ø7 L=32±3mm 4. AVSSf 0.3 wire Y L=510±3mm	5. AVSSf 0.3 wire B L=685±3mm	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to Black SV tube (Vinyl) Ø7 L=74±3mm		1. Get the Black SV tube (Vinyl) Ø7 L=74±3mm using left hand then insert the combined parts of Yellow and Black wires and Pre-assy parts of Pink and Orange wires.	n/a	1. No wrong use of parts 2. No deformed terminal Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
6		Wire insertion to Black Corrugated tube (no slit) Ø7 L=245±3mm		1. Get the black corrugated tube (no slit) Ø7 L=245±3mm using left hand then insert the combined parts of Y-B-P-O wires using right hand.	n/a	1. No wrong use of parts 2. No deformed terminal
7		Wire insertion to Black SV tube (Vinyl) Ø7 L=32±3mm		1. Get the Black SV tube (Vinyl) Ø7 L=32±3mm using left hand insert the combined parts Y-B-P-O wires.	n/a	1. No wrong use of parts 2. No deformed terminal  GOOD  NG

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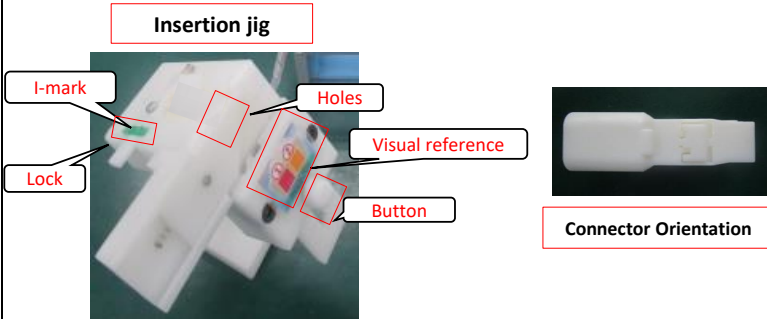
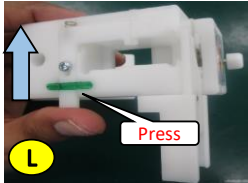
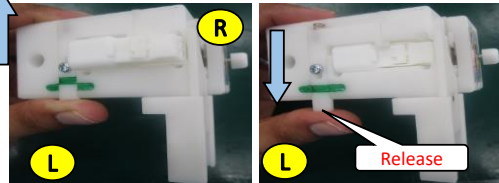
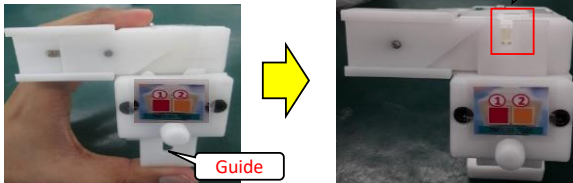
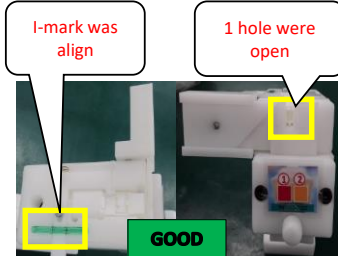
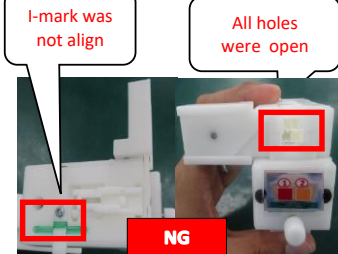
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PARTS:		1. Connector 4G5400-0000 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	<p>Connector setting to insertion jig 4G5400-0000 (W)</p>     <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 4G5400-0000 (W) into jig using right hand and release the lock.</p> <p>3. Push the guide using left hand. The slot for Pink wire will be open.</p>		N/A	<p>Connector Orientation Illustration</p>  <p>GOOD</p>  <p>NG</p> <p>1. Use the provided jig tool per model 2. No wrong orientation of connector</p>

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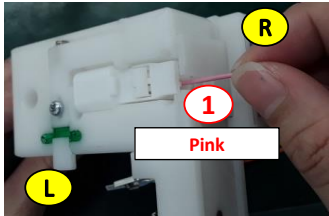
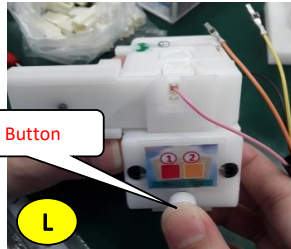
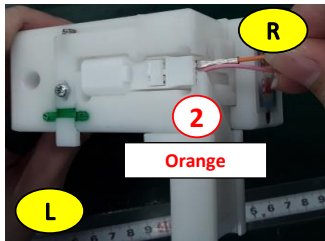
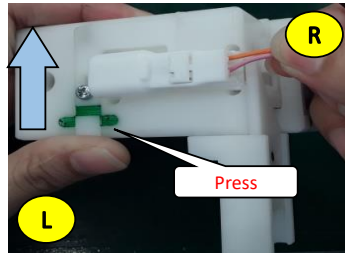
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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	<div><div><p>Wire facing</p></div><div><p>1. Get Pink wire then insert to terminal slot ① using right hand.</p></div><div><p>2. After insertion of Pink wire press the button using right hand. The slot for Orange wire will be open.</p></div><div><p>3. Get Orange wire then insert to terminal slot ② using right hand.</p></div><div><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div></div>		N/A	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Please hold the wire near terminal during insertion. 2. Insertion of wire must be from left to right. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document reference/s: 1. Refer to GL-PRO-029 for Pull-Push procedure.</div>

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1	<p>Connector setting to insertion jig and wire insertion 4G5400-0000 (W) (Y-B)</p> <p>Insertion jig</p> <p>I-mark Lock Holes Visual reference Button Guide</p> <p>Connector Orientation</p> <p>Wire facing</p> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector to insertion jig with P-OR inserted wires and release the lock. Push the lower wire guide using right hand.</p> <p>3. Get Yellow wires and then insert to terminal slot 3 using right hand. After insertion, push the button using right hand, the slot for Black wires will be open. Note: Before inserting Y-B wires, make sure P-OR wires are lifted up to easily insert the Y-B wires.</p> <p>4. Get Black wires and then insert to terminal slot 4 using right hand. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p> <p>N/A</p>			<p>Connector Orientation Illustration</p> <p>I-mark was align 1 hole were open GOOD</p> <p>I-mark was not align All holes were open NG</p> <p>1. Use the provided jig tool per model 2. No wrong orientation of connector 3. No loose insertion 4. No wrong insertion 5. One by one insertion 6. No deformed terminal</p> <p>Document reference/s:</p> <p>1. Refer to GL-PRO-029 for Pull-Push procedure.</p>

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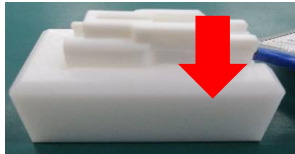
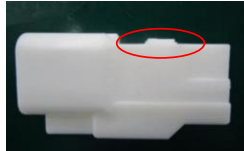
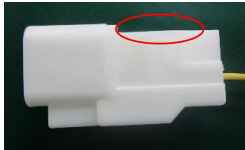

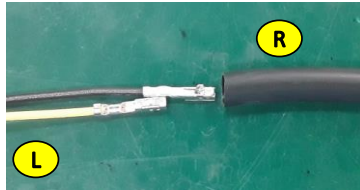
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PARTS:		1. Black SV tube (Vinyl) Ø5 L=119±3mm 2. AVSSf 0.3 wire B L=919±3mm			JIG	1. Locking jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	Connector Lock	<div><div>Put the connector into locking jig using right hand then push down the</div><div><div>Before pressing</div><div><div>After pressing</div></div></div></div>		<div>LOCKING JIG</div> 	<div>1. No unlock/half-locked connector</div> <div>Important reminders/Note/s:</div> <div>1. Manual locking may cause damaged connector lock</div>
12		Wire insertion to Black SV tube (Vinyl) Ø5 L=119±3mm)	<div><div>1. Get the Black wire (L=919mm) combine with Y wire then get the black vinyl tube (Ø5 L=119±3mm) using right hand then insert the Y-B wires.</div></div>	N/A	<div>Document reference/s:</div> <div>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</div> <div>1. No loose attachment 2. No wrong usage of parts 3. No missing clamp</div>	

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Model Code/Part Number:

D94L / 7N0030-7020

Customer:

TRJ

Document No.:

WI-ENG-PDE-054A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

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PARTS:		1. Connector 6098-2220 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1	<div><div><div><div><div>Insertion jig</div><div>I-mark</div><div>Lock</div><div>Holes</div><div>Visual reference</div><div>Button</div></div><div><div>Connector Orientation</div></div></div><div><div><div><div>↑</div><div>L</div><div>Press</div></div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div><div><div>↑</div><div>L</div><div>Release</div></div><div>2. Insert the connector (6098-2220) into jig using right hand and release the lock.</div></div><div><div><div><div>↑</div><div>L</div><div>Release</div></div><div>3. Push the guide using left hand. The slot for Yellow wire will be open.</div></div></div><div><div><div>Guide</div></div></div></div></div><div><div><div><div>I-mark was align</div><div>1 hole were open</div><div>GOOD</div></div><div><div><div>I-mark was not align</div><div>All holes were open</div><div>NG</div></div></div></div></div></div></div>		N/A	1. Use the provided jig tool per model 2. No wrong orientation of connector

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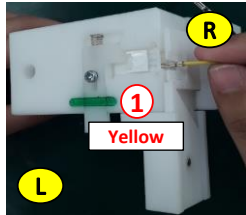
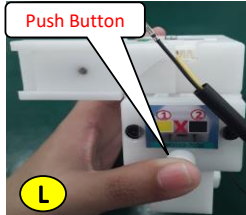
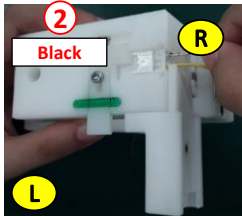
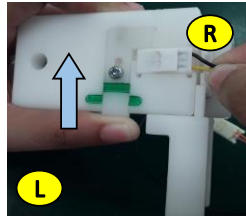
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PARTS:		1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	P1	Wire insertion to connector 6098-2220 (W) (Y,B)	<div><div><p>Wire facing</p></div><div><p>1. Get the assy parts, hold the Yellow wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Press the button using right thumb using left hand. The slot for Black wire will be open.</p></div><div><p>3. Hold the Black wire then insert to terminal slot 2 using right hand.</p></div><div><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div></div>		N/A	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Please hold the wire near terinal during insertion 2. Insertion of wire must be from left to right. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document reference/s: 1. Refer to GL-PRO-CNC-029 for Pull-Push Procedure.</div>

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PARTS:

1. Assy parts

JIG

1. Locking jig

NO.

PROCESS NAME

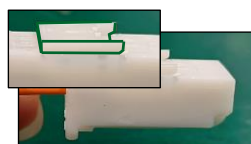
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

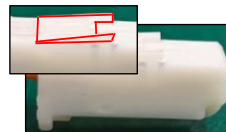
QUALITY POINTERS

5

CONNECTOR RETAINER ILLUSTRATION SIDE VIEW



GOOD



NG

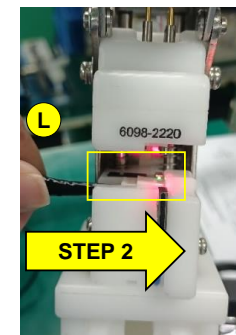
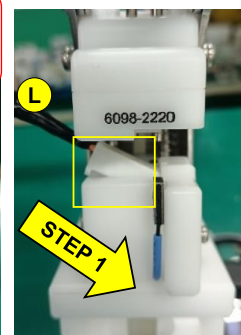
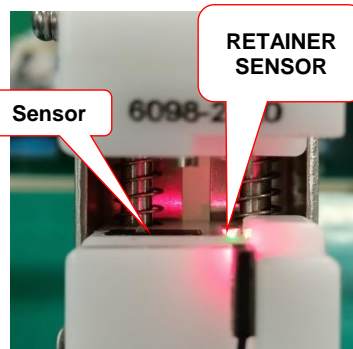
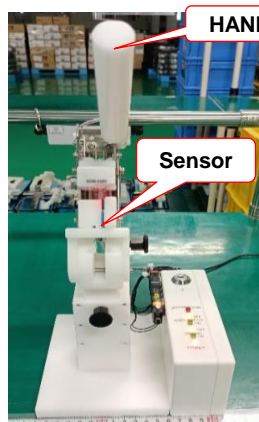
1. Check the Retainer lock of connector before insertion to locking jig.

*Note: Must be **NO** half-locked condition prior connector locking.*

15

P1

Connector Lock



2. Hold the assy parts using left hand and insert into connector locking jig based on the direction of arrow. Make sure the connector touch the sensor. Sound will be heard if properly lock.

NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.

1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector.
2. Maintain 10mm proper holding of wire to connector
3. Connector must be fully inserted to connector slot.
4. Make sure no offset setting before locking process.
5. No wrong setting of connector.
6. No damaged connector lock
7. No unlocked/ half-locked connector.

Important reminders/Note/s:

1. *Incomplete locking process will alarm the jig.*
2. *No retainer in connector cannot proceed.*
3. *If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process.*

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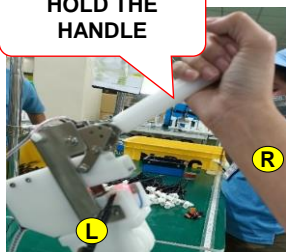
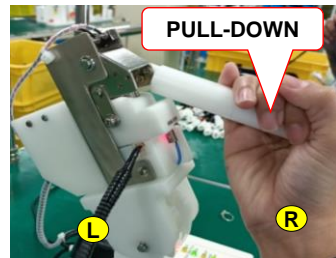
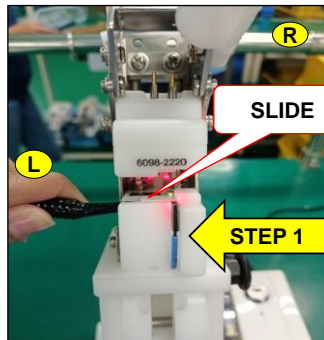
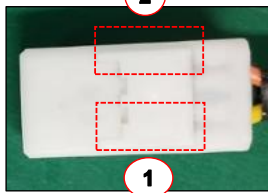

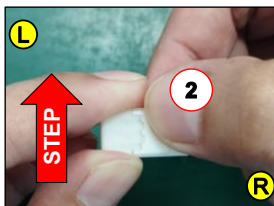
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PARTS:		1. Assy parts		JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
15	P1 Connector lock (Continuation)	<div><div><div><p>3. Hold the handle of the connector locking jig using right hand then gently pull down and bring back to original position after locking. Note: Pull down one time only.</p></div><div><p>4. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.</p></div><div><p>5. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div><div></div><div></div><div></div></div></div>			<p>1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector.</p> <p>2. Maintain 10mm proper holding of wire to connector</p> <p>3. Connector must be fully inserted to connector slot.</p> <p>4. Make sure no offset setting before locking process.</p> <p>5. No wrong setting of connector.</p> <p>6. No damaged connector lock</p> <p>7. No unlocked/ half-locked connector</p> <p>Important reminders/Note/s:</p> <p>1. <i>Incomplete locking process will alarm the jig.</i></p> <p>2. <i>No retainer in connector cannot proceed.</i></p> <p>3. <i>If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</i></p>

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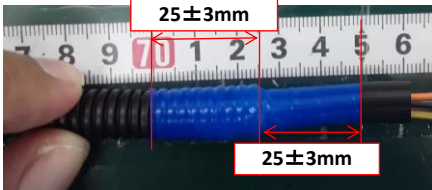

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PARTS:		1. Blue tape			JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
16	P1	Taping 1 COT to Vinyl tube near Connector	 <p>1. Get BLUE TAPE. Fix the Corrugated tube and Vinyl tube then start taping using both hands.</p>  <p>2. After taping, check the tape condition & measurement.</p>		<p>MEASURING TAPE</p> 	<p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p> <p>Important reminders/note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement. 2. Use BLUE TAPE only</p>

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PARTS:

1. Assy parts

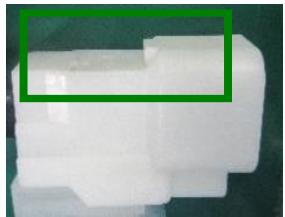
JIG

n/a

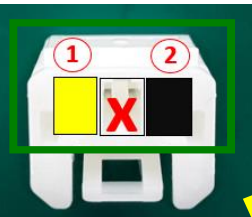
QUALITY CHECKPOINTS

P1

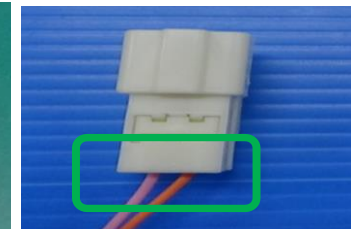
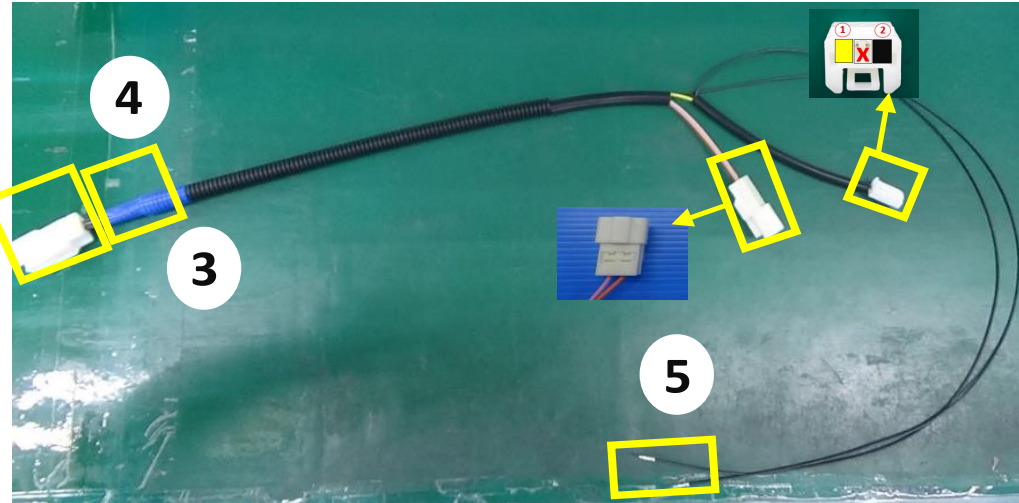
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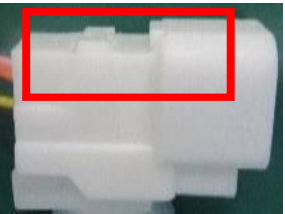
GOOD



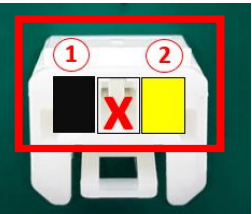
GOOD



GOOD



NO GOOD



NO GOOD



NO GOOD

1 No **Unlock/**
Halflocked Connector
(on 3 connector)

2 No **Wrong Insert**
(on 3 connector)

3 No **Missing Tape**
4 No **Wrong Used of**
Tape (blue tape)

5 No **Terminal**
Backing Out

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