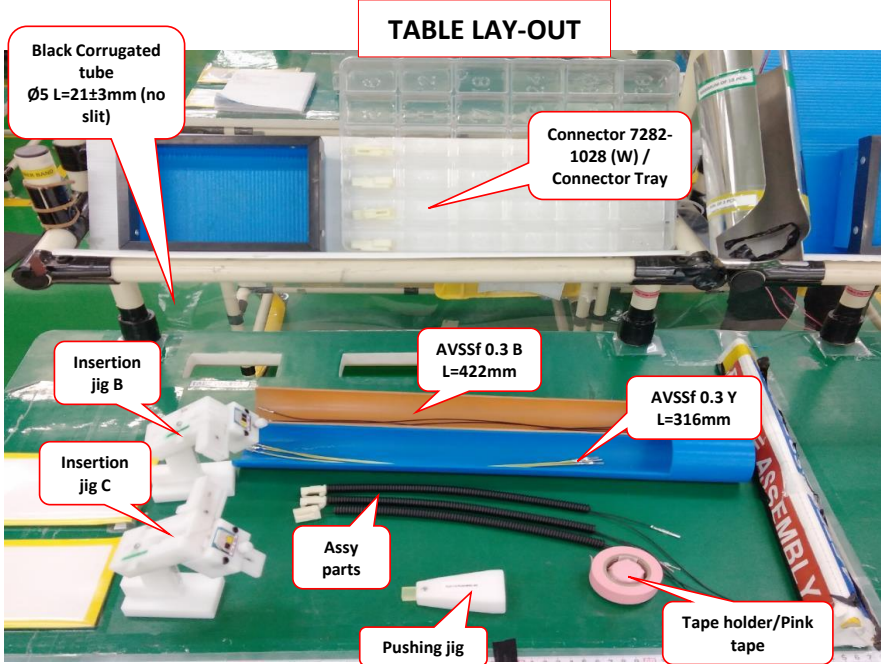


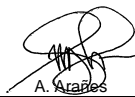
	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>April 28, 2023</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model Code/Part Number: <b>TM3 / 7L0114-7020A</b>		Customer: <b>TRQSS</b>		Document No.:	<b>WI-ENG-PDE-314A</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revis 3	3	Page No.:	1 of 9

<b>PARTS:</b>		1. Assy parts; Connector 7282-1028 (W); AVSSf 0.3 Y wire L=316mm; B wire L=422mm; Black corrugated tube Ø5 L=21±3mm (no slit); Pink tape				JIG:	1. Insertion jig with flip cover 2. Pushing jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
1	P1	<p><b>TABLE LAY-OUT</b></p> 				<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 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> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>1. No missing parts/tools 2. No excess parts/tools</p> <p><b>Document references:</b> <b>1. Refer to WI-ENG-PDE-340 for Offline Assembly Process</b></p>	

Revision History								Prepared by	Reviewed by	Approved by	Noted by
04/28/23	3	Inclusion of quality checkpoints		J. Loterte	C. Villanueva	A. Arañes	n/a	 J. Loterte	 C. Villanueva	 A. Arañes	n/a
10/07/22	2	Improve quality pointers: Reminders/notes and references on page no. 1, 2, 3, 4, 5, 6, 7, and 8 due to document improvement. Work procedure/illustration in process no.5 and 9 -Connector lock		M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
09/24/21	1	Revise due to transfer of insertion process to Kitting (Refer to WI-ENG-PDE-340); Provide insertion jig and pushing jig; Improve all process description and illustration; Change from pre-launch to masspro. Change spot tape color from Black tape to Pink tape.		M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
08/02/21	0	Initial issue		M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	August 02, 2021

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### PARTS:

1. Assy parts

JIG

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

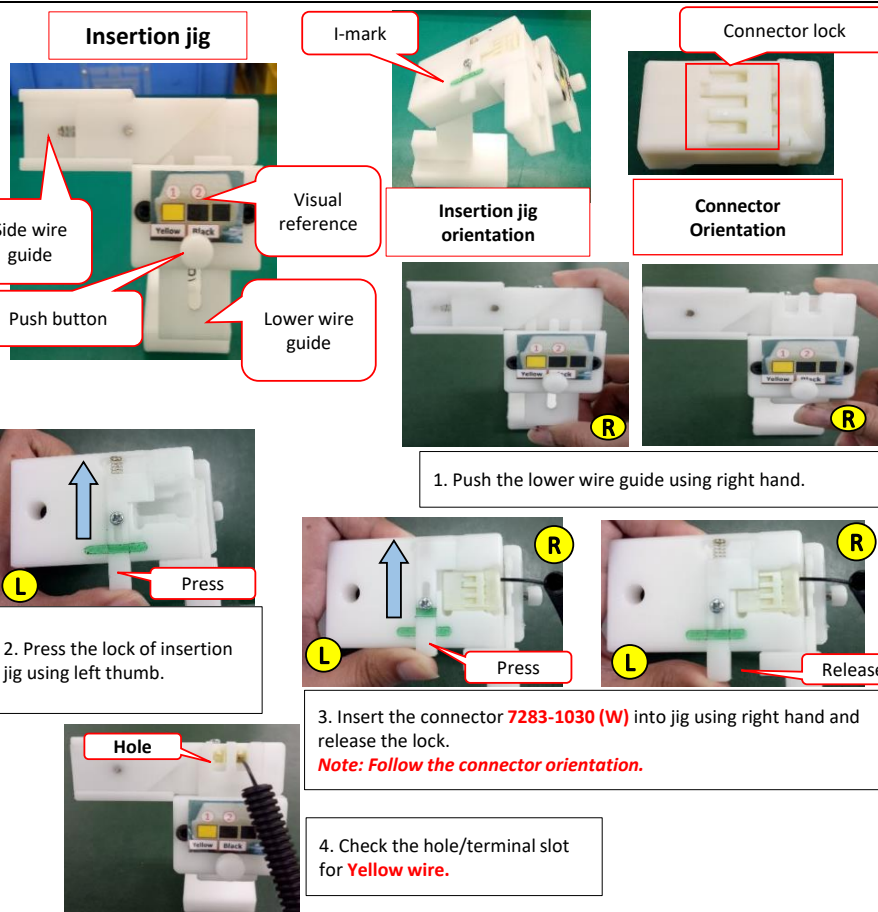
### TOOLS/PPE

### QUALITY POINTERS

2

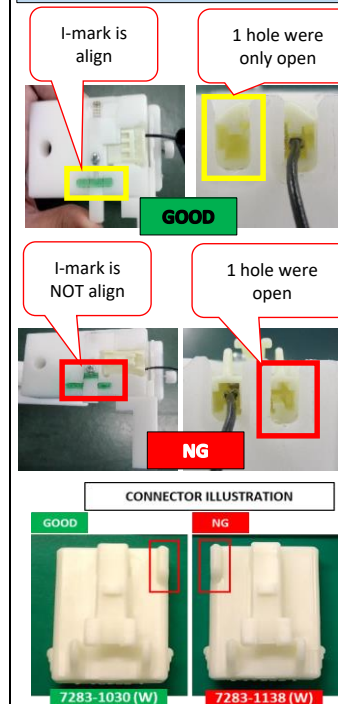
P1

Connector setting to  
insertion jig  
7283-1030 (W)  
(Assy parts)



n/a

### Connector Orientation Illustration



1. Use provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

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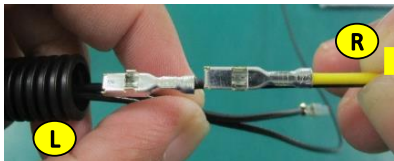
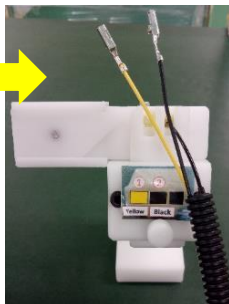
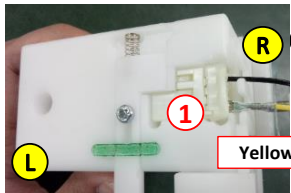

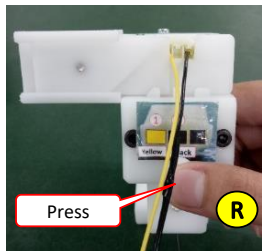
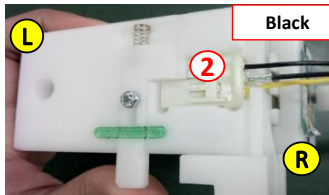
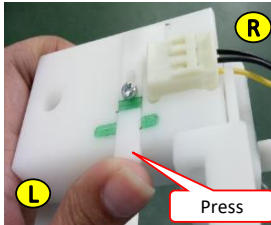
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PARTS:		1. Assy parts 2. AVSSf 0.3 Y wire L=316±2mm 3. AVSSf 0.3 B wire L=422±2mm			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3		   <p>2. Get the 2 wires (Yellow L=316mm and Black L=422mm) and insert to assy parts (corrugated tube Ø7 L=240±3mm) using right hand.</p>			n/a	1. No wrong usage of parts 2. No deformed terminal  <b>Document references</b> <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</b>
4	P1	     <p>1. Get the <b>Yellow wire</b> using right hand then insert to terminal slot <b>1</b> using right hand.</p> <p>2. Press the button using right hand, the slot for <b>Black wire</b> will be opened.</p> <p>3. Get the <b>Black wire</b> using right hand then insert to terminal slot <b>2</b> using right hand.</p> <p>4. After insertion, press the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p>			n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing  <b>Important reminders/Note/s:</b> <b>1. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b> <b>2. Please hold the wire near terminal during insertion.</b>  <b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b>

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**PARTS:**

1. Assy parts
2. Black corrugated tube Ø5 L=21±3mm (no slit)

**JIG**

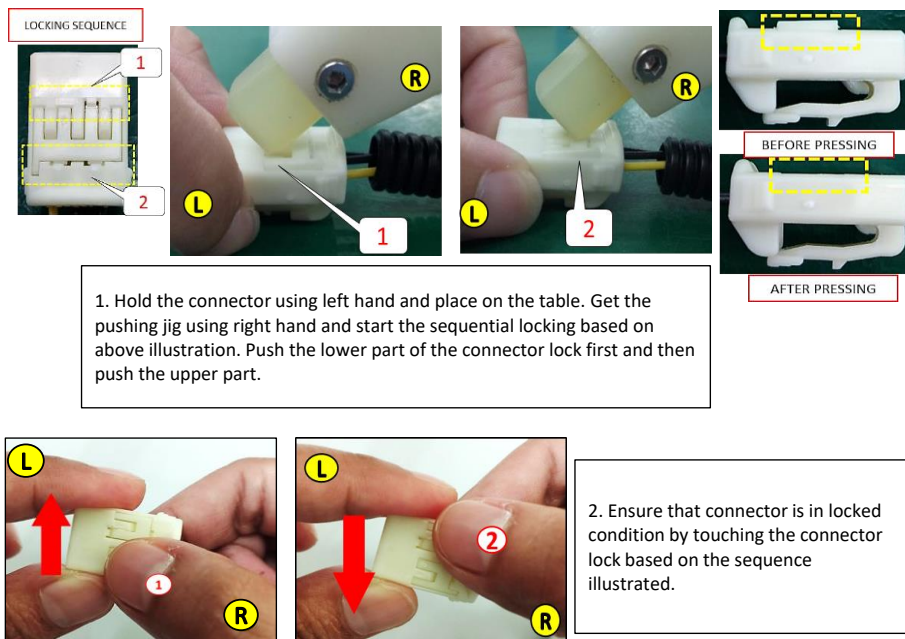
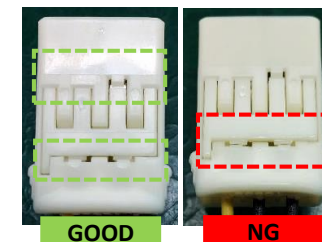
1. Pushing jig

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

P1

Connector lock

**PUSHING JIG****LOCK CONDITION**

1. No unlocked/half-locked connector
2. No damage connector

**Important reminders/Note/s:**

1. Manual locking may cause damaged connector lock.
2. Position of pushing jig during locking must be slanted.

6

Wire insertion to  
Corrugated tube  
Ø5 L=21±3mm  
(no slit)

1. Get the corrugated tube Ø5 L=21±3mm using right hand then insert the Yellow and Black jointed wire using left hand.

n/a

1. No wrong usage of parts
2. No deformed terminal

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**PARTS:**

1. Connector 7282-1028 (W)

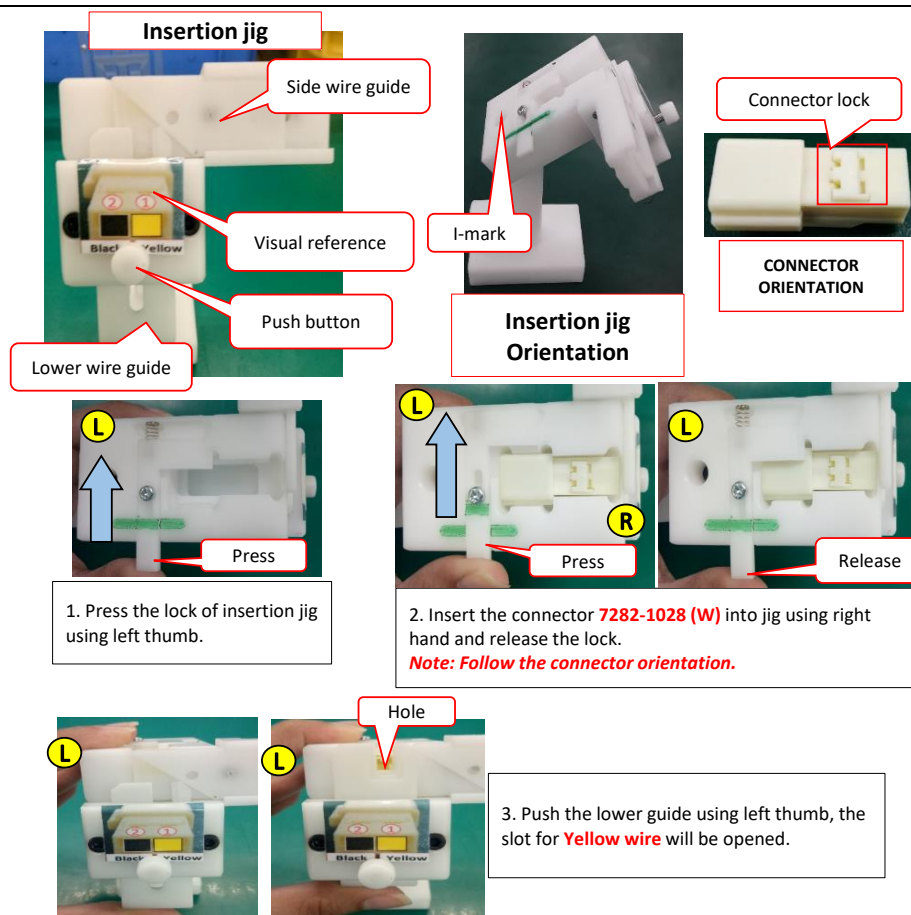
**JIG**

1. Insertion jig

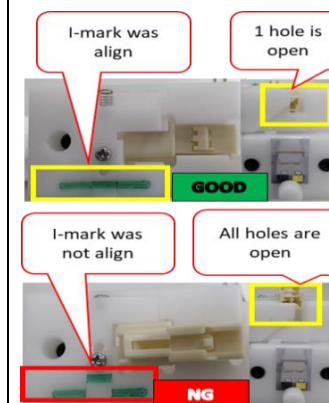
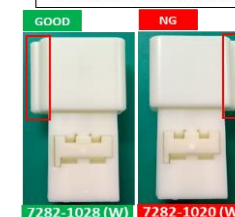
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

7

P1

Connector setting to  
Insertion jig  
7282-1028 (W)

n/a

**Connector Orientation  
Illustration****CONNECTOR ILLUSTRATION**

1. Use provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

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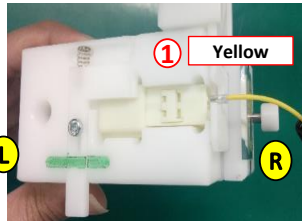

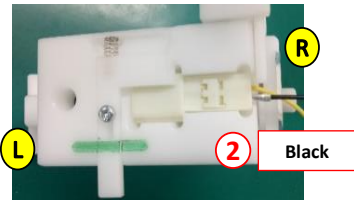
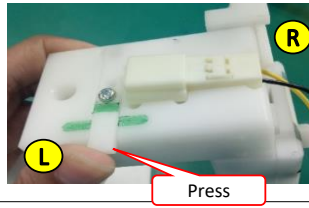
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PARTS:		1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
8	P1	<div><p>WIRE FACING</p></div> <div><p>1. Insert the <b>Yellow wire</b> using right hand then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p>2. Press the button using right hand, the slot for <b>Black wire</b> will be opened.</p></div> <div><p>3. Get <b>Black wire</b> using right hand then insert to terminal slot <b>2</b> using right hand.</p></div> <div><p>4. After insertion, press the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div>			n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b></p> <p><b>1. Manual locking may cause damaged connector lock.</b></p> <p><b>2. Please hold the wire near terminal during insertion.</b></p> <p><b>Document references:</b></p> <p><b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></p>

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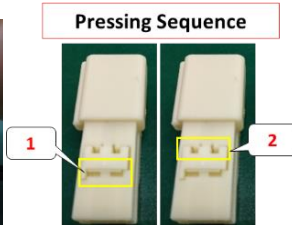
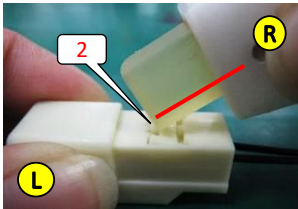
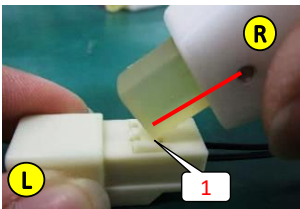
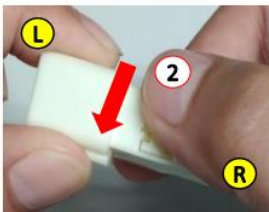
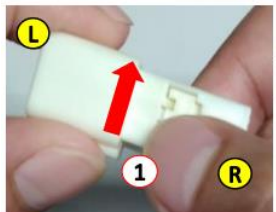



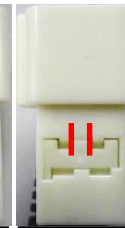

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PARTS:		1. Assy parts			JIG	1. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
9	P1	<div></div> <div>1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on the above illustration. Push the lower part of the connector lock first and then push the upper part.</div> <div></div> <div>2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</div> <div><div>Before pressing</div><div>After pressing</div></div>			<div><b>PUSHING JIG</b></div> 	<div>1. No unlocked/half-locked connector 2. No damage connector3.</div> <div><b>Document references:</b></div> <div>1. Manual locking may cause damaged connector lock.</div> <div>2. Use provided jig tool per model to avoid damaged lock.</div> <div>3. Position of pushing jig during locking must be slanted.</div> <div><b>LOCK CONDITION</b></div> <div></div> <div><b>GOOD</b> <b>NG</b></div>

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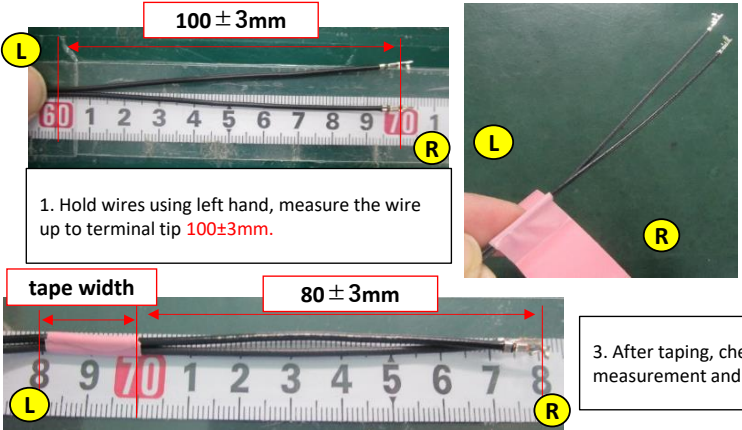

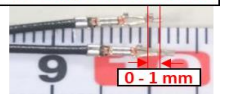
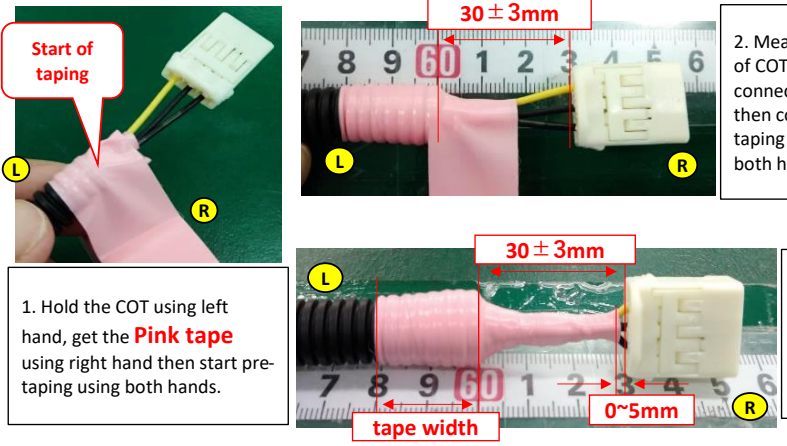

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**PARTS:**

1. Assy parts
2. Pink tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	Spot taping	 <p>1. Hold wires using left hand, measure the wire up to terminal tip <math>100 \pm 3\text{mm}</math>.</p> <p>2. Get the <b>Pink tape</b>, conduct <b>2x windings</b> of tape then cut using both hand.</p> <p>3. After taping, check the measurement and taping condition.</p>		<ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong use of tape</li><li>6. No wrong dimension</li></ol> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please use calibrated/verified measuring tape when getting the measurement.</li></ol> <p><b>Wire alignment tolerance</b></p> 
11	Taping 1 Black COT to wire near connector	 <p>1. Hold the COT using left hand, get the <b>Pink tape</b> using right hand then start pre-taping using both hands.</p> <p>2. Measure from end of COT up to edge of connector <math>30 \pm 3\text{mm}</math> then continue the taping process using both hands.</p> <p>3. After taping, check the measurement and taping condition.</p>		<ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong use of tape</li><li>6. No wrong dimension</li></ol> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please use calibrated/verified measuring tape when getting the measurement.</li><li>2. Use <b>PINK TAPE</b> only.</li></ol>

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PARTS:

1. Assy parts

JIG

n/a

3

### QUALITY CHECKPOINTS

P1

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GOOD



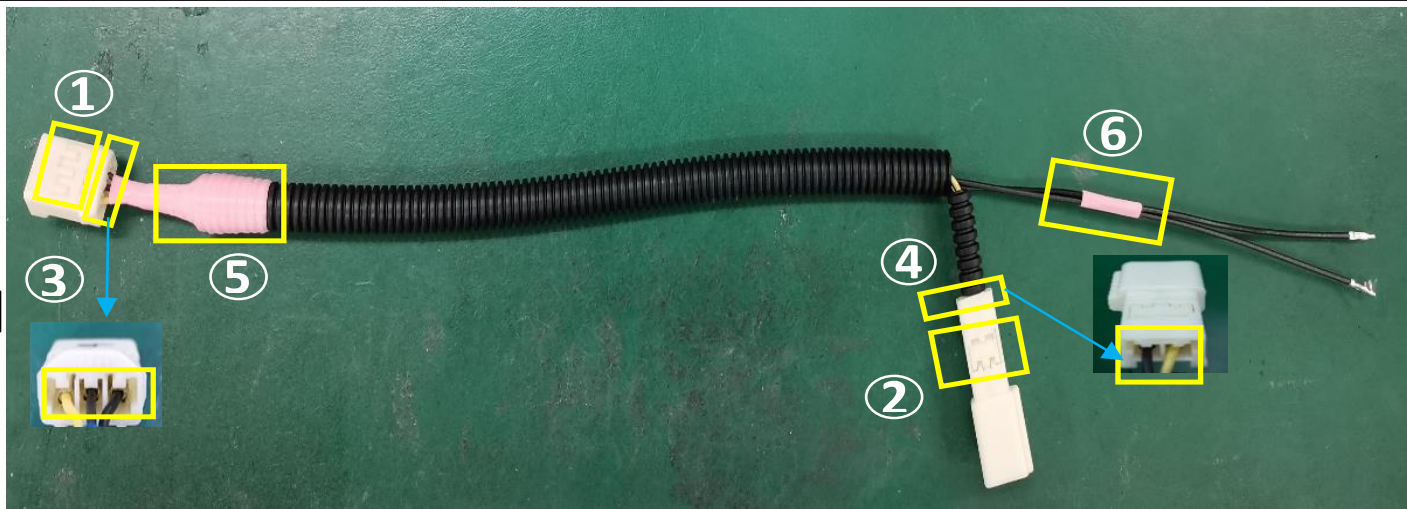
NO GOOD



GOOD



NO GOOD



GOOD



NO GOOD

① ② No Unlocked/ Half Locked Connector ⑤ No Missing Tape

③ ④ No Wrong Insert ⑥ No Missing Spot Tape ⑦ No Terminal Backing Out

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