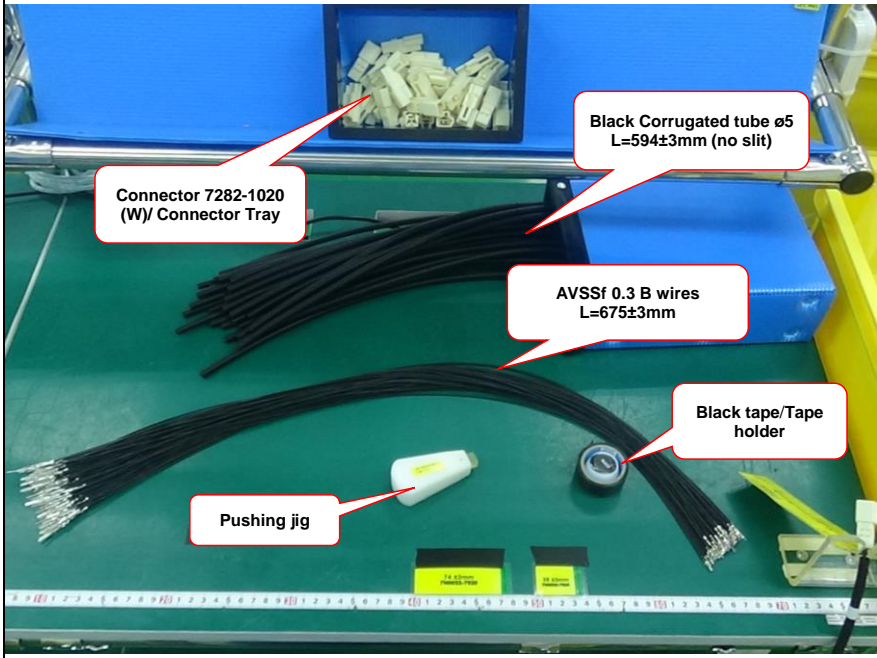


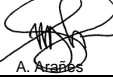
	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date:	July 15, 2024		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: <b>YKC / 7N0032-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>SUZUKI SOLIO</b>	Document No.:	<b>WI-ENG-PDE-294</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	5	Page No.:	1 of 7

<b>PARTS:</b>	1. Connector 7282-1020 (W); AVSSf 0.3 B L=675±3mm; Black corrugated tube (no slit) ø5 L=594±3mm; Black tape			JIG:	1. Pushing jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	P1	Table Lay-out	<div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;">TABLE LAY-OUT</div> 	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            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;"> <b>Housekeeping</b>            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;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools

Revision History						Prepared by	Reviewed by	Approved by	Noted by		
07/15/24	5	Seprate assembly jig (Spot taping) to Clamp assembly process. Change process sequence due to removal of cover jig. Inclusion of car model "SUZUKI-SOLIO". Improved table lay-out, measurement and visual inspection/quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a	
01/18/23	4	Inclusion of Batching quantity: 6pcs. Process identification per table by providing table 1 and table 2. Inclusion of quality checkpoints.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
10/10/22	3	Improve table lay-out. Merge offline assembly process (WI-ENG-PDE-293 7N0032-7020 - Offline Assembly Process) from Offline and P1 to P1 due to capacity improvement. Process no.2,3 and 4 transfer to P1 process.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	June 29, 2021

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**TAPING ASSEMBLY PROCESS**

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**PARTS:**

1. Black Corrugated tube  $\phi 5$  L=594 $\pm$ 3mm
2. AVSSf 0.3 B L=675 $\pm$ 3mm [2pcs]

JIG:

n/a

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

2

P1

Wire insertion to  
Corrugated tube  
(no slit)  
 $\phi 5$  L=594 $\pm$ 3mm



1. Get Black Corrugated tube  $\phi 5$  L=594 $\pm$ 3mm (no slit) using left hand and insert Black wires L=675 $\pm$ 3mm using right hand.


n/a

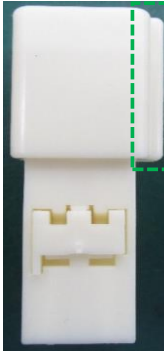


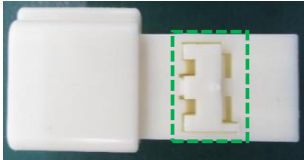
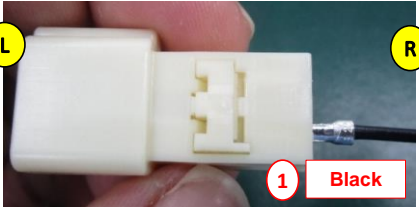
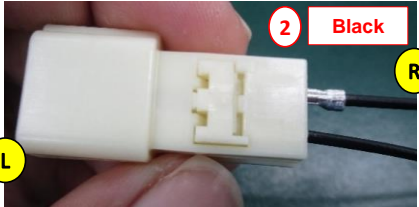
1. No wrong use of parts
2. No deformed terminal

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	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>YKC / 7N0032-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>SUZUKI SOLIO</b>	Document No.:	<b>WI-ENG-PDE-294</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	5	Page No.:	3 of 7

<b>PARTS:</b>	1. Connector 7282-1020 (W) 2. Assy parts			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	P1  Wire insertion to connector 7282-1020 (W)	<div><div><div>GOOD</div></div><div><div>NO GOOD</div></div></div> <div><div>WIRE FACING</div></div> <div><div>CONNECTOR ORIENTATION</div></div> <div><div><div>L</div><div>R</div></div><div>1. Get the <b>1st Black wire</b> then insert to terminal slot <b>1</b> of connector using right hand. <b>Note: Insertion of wires must be from left to right.</b></div></div> <div><div><div>L</div><div>R</div></div><div>2. Get the <b>2nd Black wire</b> then insert to terminal slot <b>2</b> of connector using right hand.</div></div>			

n/a

GOOD



NO GOOD



UNLOCK      HALF-LOCKED

**Important reminders/Note/s:**  
  
1. Please hold the wire near terminal.  
2. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion.  
Do not exert extra force.  
  
**Document references:**  
  
1. Refer to **GL-PRO-ASY-029** for Pull-Push procedure.  
2. Refer to **WI-PRO-CNC-017** for Wire and Strip Length Tolerance

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

July 15, 2024

Process Name/Title:

Model code/Part number:

YKC / 7N0032-7020

Customer: TRJ

Car Model: SUZUKI SOLIO

Validity Date:

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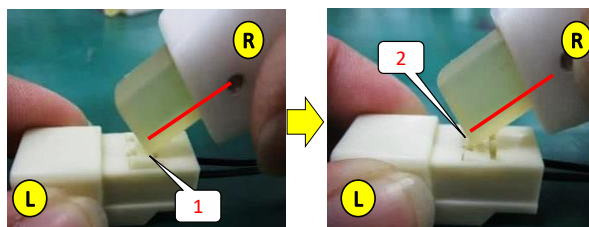
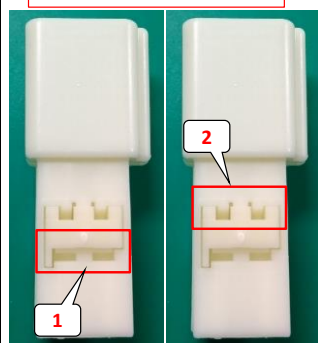
PARTS: 1. Assy parts

JIG: 1. Pushing jig

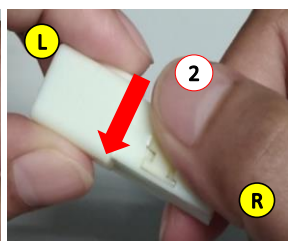
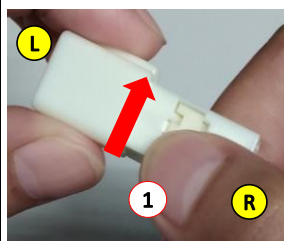
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
-----	--------------	------------------------------	-----------	------------------

4	P1	Connector lock		
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### Pressing sequence

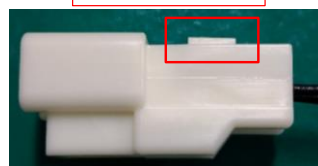


1. Hold the connector **using left hand** and place on the table. Get the pushing jig using right hand and start the sequential locking based on the above illustration.  
**Push the lower part of the connector lock first and then push the upper part.**



2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

### Before pressing



### After pressing



### Pushing jig

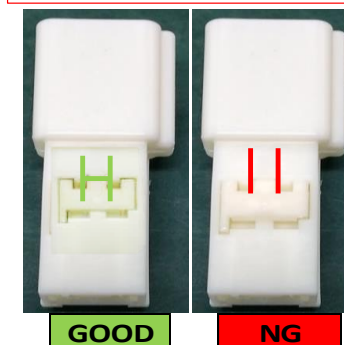


### Important reminders/Note/s:

1. **MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.**
2. Use the provided jig tool to lock the connector.
3. Position of pushing jig during locking must be slanted

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


### LOCKED CONDITION



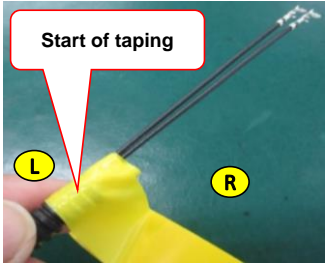
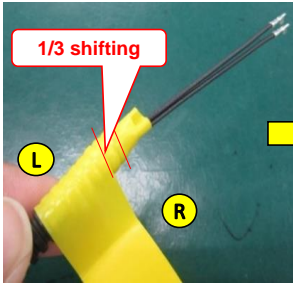
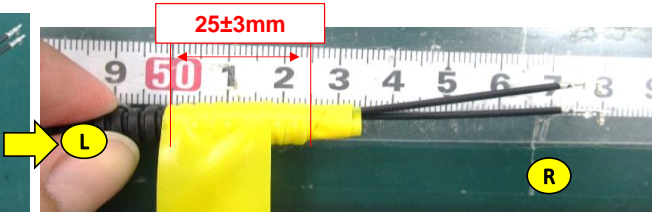

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	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		5	Page No.:


  

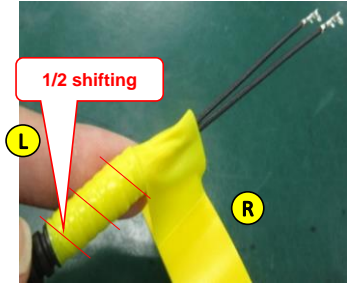

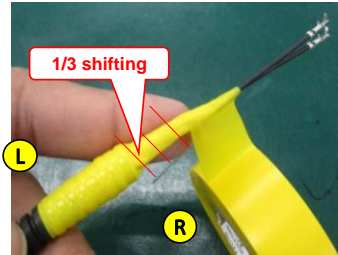
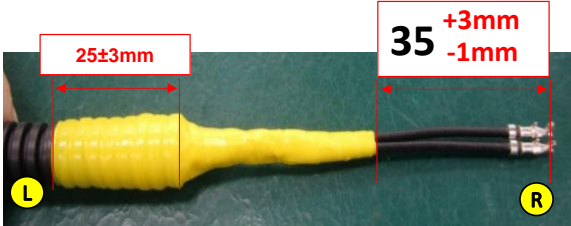

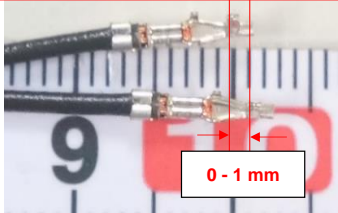
<b>PARTS:</b>		1. Assy parts 2. Black tape		<b>JIG:</b>		n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
5	P1 Taping 1 Black corrugated tube to wire near terminal	<div>  <p>Start of taping</p> <p>1. Hold the COT using left hand, get the <b>Black tape</b> using right hand then start pre-taping using both hands.</p> </div> <div>  <p>1/3 shifting</p> </div> <div>  <p>25±3mm</p> </div> <div> <p>2. Wind the tape <b>1/3 shifting</b> going to COT until it reach <b>25mm</b> then make <b>2 windings</b> of tape before shifting.</p> </div>		<div> <p><b>MEASURING TAPE</b></p>  </div> <div> <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> </div>		<p><b>Important reminders/Note/s:</b></p> <p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p>	

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<b>PARTS:</b>	1. Assy parts 2. Black tape			JIG:	n/a		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
5	P1 Taping 1 Black corrugated tube to wire near terminal (Continuation)	<div><p>1/2 shifting</p><p>3. Wind the tape <b>1/2 shifting</b> going to wires.</p></div> <div><p>74±3mm</p><p>4. Measure from end of COT up to terminal pointed tip <b>74±3mm</b> then continue the taping process using both hands.</p></div> <div><p>1/3 shifting</p></div> <div><p>25±3mm</p><p>35 <b>+3mm</b> <b>-1mm</b></p><p>5. Make <b>1/3 shifting</b> to wires until it measure from end of tape up to terminal pointes tip <b>35+3mm/-1mm</b>. Make <b>3 windings</b> of tape before cut.</p><p>6. After taping, check the measurement, taping condition and terminal appearance.</p></div>	<div><b>MEASURING TAPE</b></div> 	<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><b>Important reminders/Note/s:</b></p> <p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document references:</b></p> <p>1. Refer to <b>WI-ENG-PDE-588</b> for Tape and tube end standard tolerance.</p> <div><p><b>Wire alignment tolerance</b></p><p>0 - 1 mm</p></div>			

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Model code/Part number:

**YKC / 7N0032-7020**Customer: **TRJ**

Car Model:

**SUZUKI SOLIO**

Document No.:

**WI-ENG-PDE-294**

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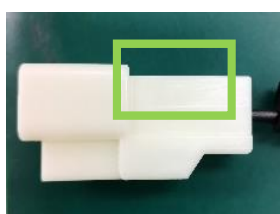
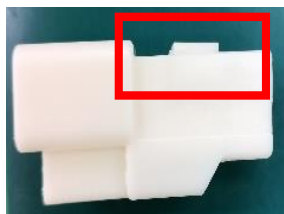
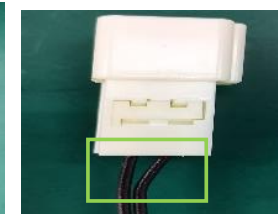
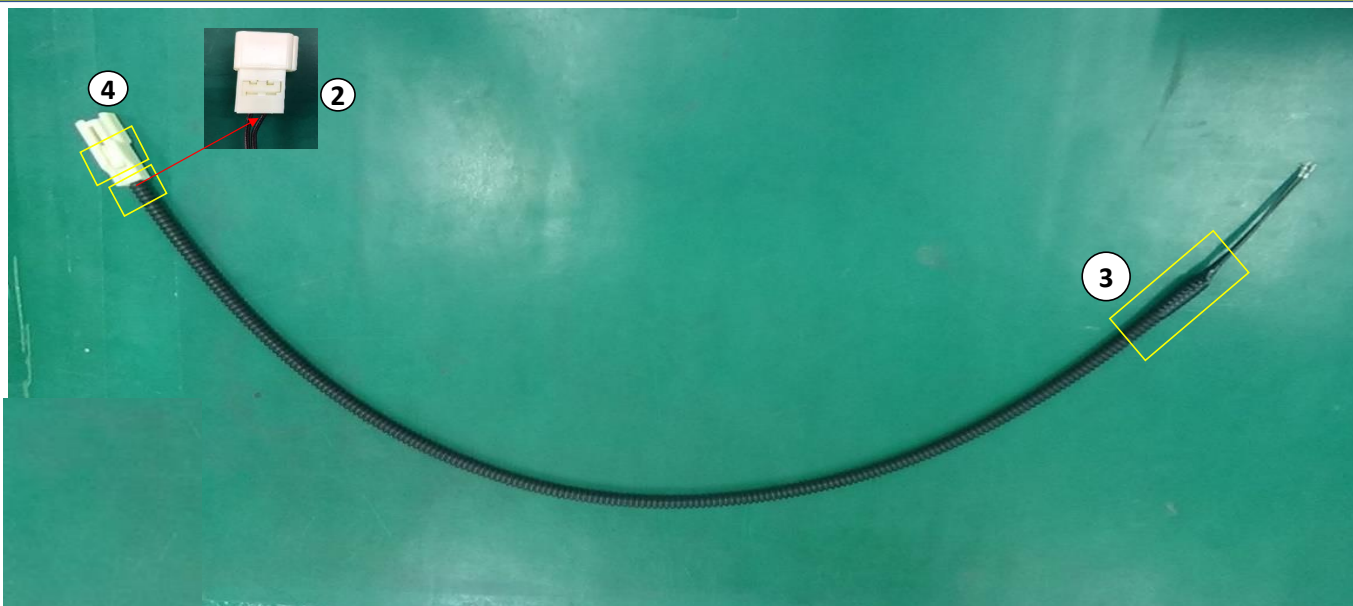
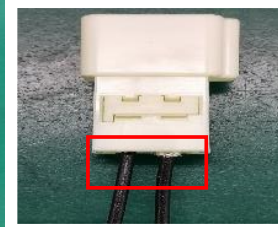
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7N0032-7020****GOOD****NO GOOD****GOOD****NO GOOD****① No unlocked/ half-locked connector****② No wrong insert****③ No missing of tape****④ No Deformed terminal****⑤ No Terminal backing out**

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