

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

September 29, 2022

Process Name/Title:

Model code/Part number:

TP1 / 7L0089-7023

Customer:

TRQSS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-058A

Revision No.:

5

Page No.:

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**PARTS:**

1. Connector 4F5260-0000 (W)

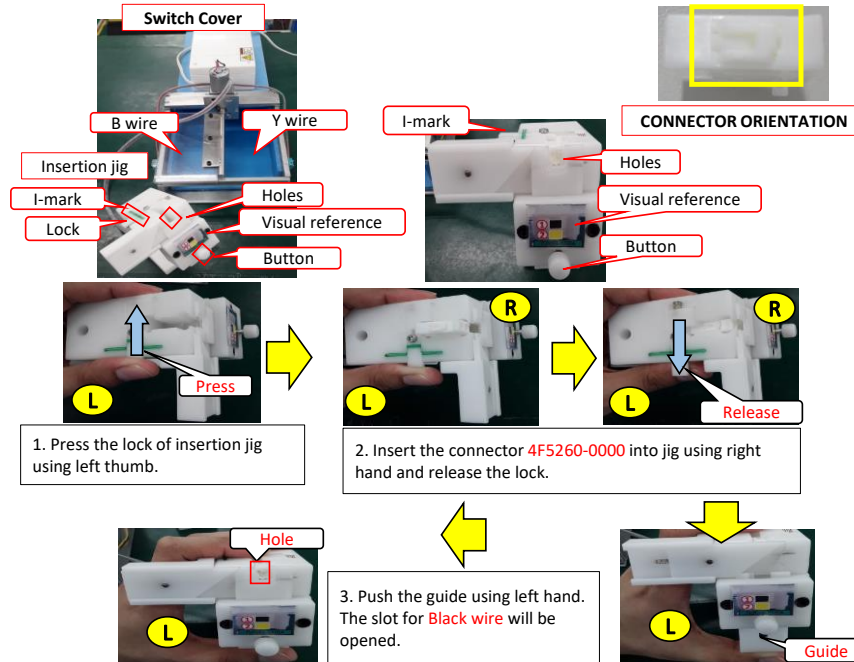
JIG:

1. Insertion jig with switch cover

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

1

P1

Connector setting to  
insertion jig  
Connector 4F5260-0000  
(W)**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

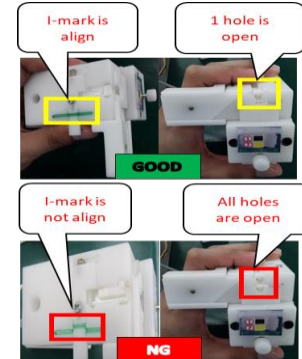
**Housekeeping**

1. Maintain and always practice 5's.  
2. Personal things on the workplace is prohibited. Keep it in your locker.

**Alert level**

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector.
4. No damage Connector.

**Connector Orientation Illustration****Revision History**

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
09/29/22	5	Improve quality pointers: Reminders/notes and references in process no.1, 2, 3, 4, 5, 6, 7 and 8 due to document improvement. Work procedure/illustration in process no.3 and 8 -Connector lock	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
02/22/21	4	Change part number; Change tape color of spot taping process from Black to Orange	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
01/30/21	3	Change connector color in accordance with standardization for plastic parts; Update pictures using terminal cover jig. Removal of cycle time; Conduct semi-annual review of doc's; Put assy parts on parts section Pg. 3, 5-7.	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
Est. Date:			October 2, 2021							

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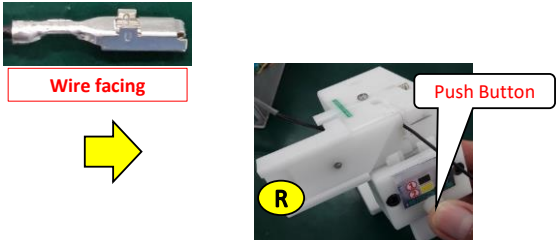
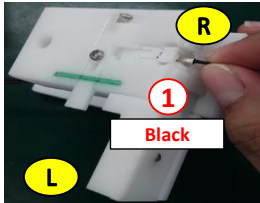
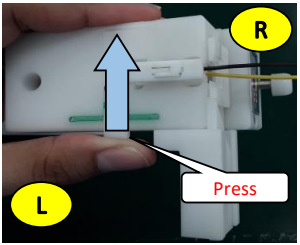
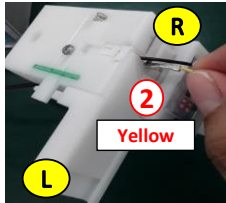
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PARTS:		1. AVSSf 0.3 Y L=316±2mm; B L=421±2mm		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div><p>1. Get <b>Black wire</b> then insert to terminal slot ① using right hand.</p><p>2. After insertion of Black wire press the button using left hand. The slot for <b>Yellow wire</b> will be open.</p></div> <div><p>3. Get <b>Yellow wire</b> then insert to terminal slot ② using right hand.</p><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>		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>5 <b>Important reminders/Note/s:</b> 1. <b>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</b> 2. <b>Please hold the wire during insertion.</b></div> <div>5 <b>Document references:</b> 1. <b>Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</b> 2. <b>Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></div>

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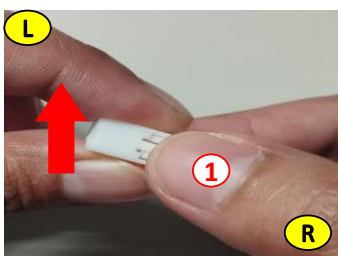
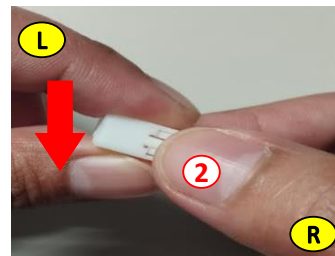

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PARTS:		1. Assy parts		JIG	1. Locking jig
NO.	PROCESS NAME	5 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	Connector Lock	<div><div></div><div><p>1. Put the connector into locking jig using right hand then push down to lock 2x.</p></div><div><div></div><div></div></div><div><div></div><div></div><div><p>2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</p></div></div></div>	<div><div>LOCKING JIG</div></div>	<div>1. No unlock and half-locked connector. 2. No damaged lock</div> <div><b>Important reminders/ Note/s:</b></div> <div>51. Manual locking may cause damaged connector lock.</div>

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PARTS:		1. Black Corrugated tube Ø5 L=243±3mm (no slit) 2. Black Corrugated tube Ø5 L=23±3mm (no slit)			3. AVSSf 0.3 wire B L=175±2mm 4. Assy parts		JIG	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS
4	P1	Wire insertion to Black Corrugated tube Ø5 L=243±3mm (no slit)	<div><div><p>1. Get the terminal cover jig and insert to terminal using right hand.</p></div><div><p>2. Get the <b>Corrugated tube Ø5 L=243±3mm (no slit)</b> using right hand and insert the wires using left hand.</p></div><div><p>3. Remove the terminal cover jig after insertion.</p></div></div>			TERMINAL COVER JIG 		1. No wrong usage of parts 2. No deformed terminal
5		Wire insertion to Black Corrugated tube Ø5 L=23±3mm (no slit)	<div><div><p>1. Get the <b>Black wire L=175mm</b> and combine to Yellow wire. Get the <b>Corrugated tube Ø5 L=23±3mm</b> using right hand. Insert both wires to COT using left hand.</p></div><div></div></div>			n/a		1. No wrong usage of parts 2. No deformed terminal <div>5 <b>Document references:</b> <b>1. WI-PRO-CNC-017 for Wire and Strip length tolerance.</b></div>

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## PARTS:

1. Connector 7282-1028 (W)

## JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

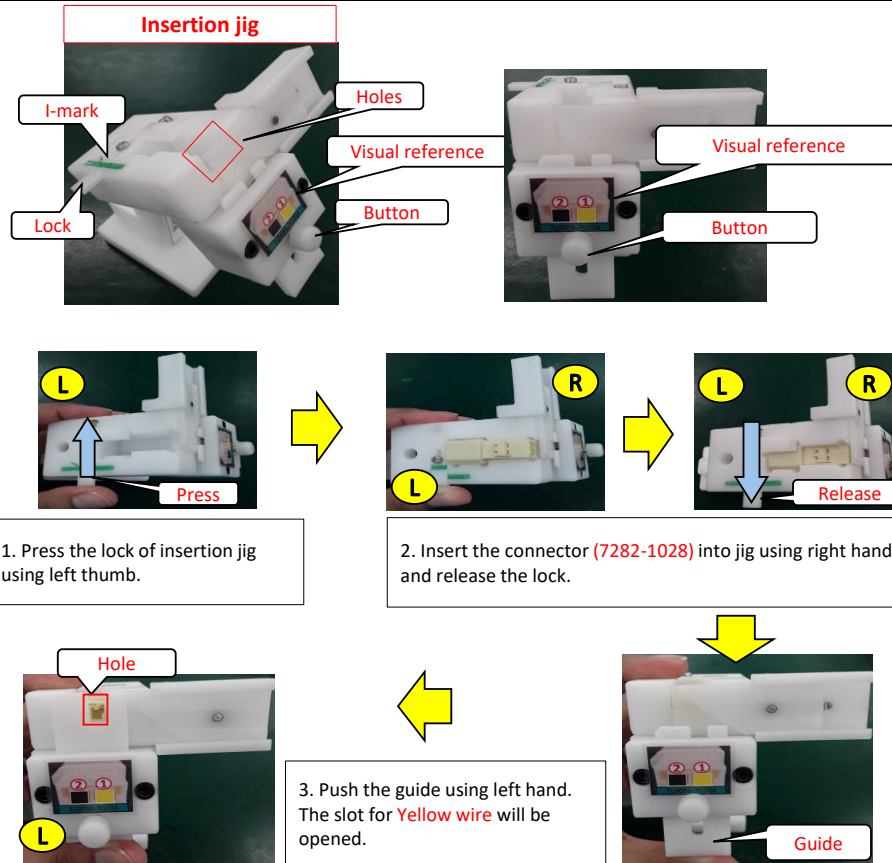
TOOLS/PPE

QUALITY POINTERS

6

P1

Connector setting to  
insertion jig  
7282-1028 (W)



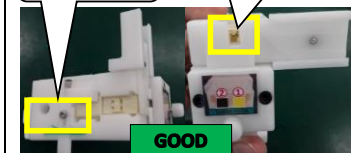
n/a

1. Use the provided jig per model
2. No wrong orientation of connector

## Connector Orientation Illustration

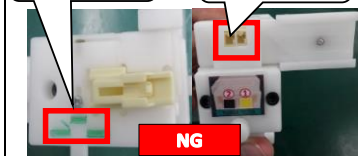
I-mark is align

1 hole is open



I-mark is not align

All holes are open



## CONNECTOR ILLUSTRATION

GOOD

NG

7282-1028 (W)

7282-1020 (W)

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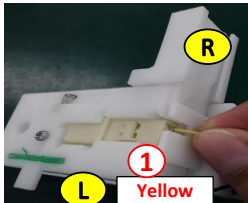

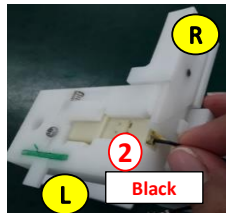
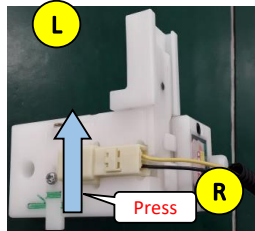
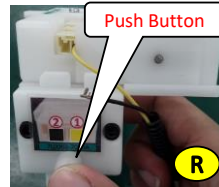
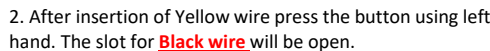
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PARTS:		1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
7	P1	<div><p>1. Get <b>Yellow wire</b> then insert to terminal slot ① using right hand.</p></div> <div><p>Wire facing</p></div> <div><p>3. Get <b>Black wire</b> 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><p>Push Button</p></div> <div><p>2. After insertion of Yellow wire press the button using left hand. The slot for <b>Black wire</b> will be open.</p></div>			n/a	<div>1. No loose insertion 2. No wrong dimension 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div><b>Important reminders/Note/s:</b></div> <div>1. <b>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</b></div> <div>2. <b>Please hold the wire near terminal.</b></div> <div><b>Document references:</b></div> <div>1. <b>Refer to GL-PRO-ASSY-029 for Pull-Push procedure.</b></div>

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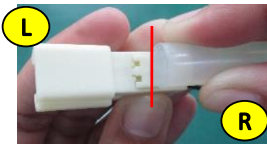

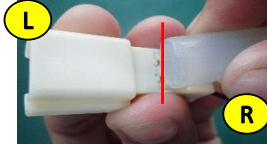
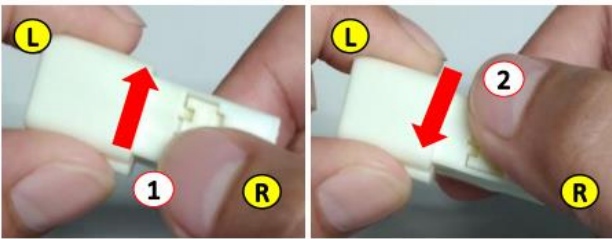
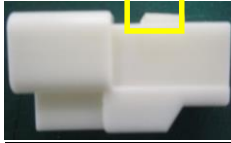
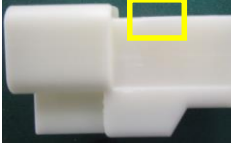


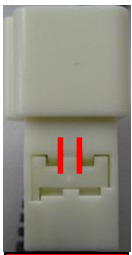
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PARTS:		1. Assy parts		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	Connector Lock	<div><div><p>1. Get the Glue stick using right hand and hold the connector using left hand and then push down the lower part of the connector lock using glue stick.</p></div><div><p>2. Push down the upper center part of the connector lock using glue stick.</p></div><div><p>3. Push down the upper part as a whole to properly lock the connector.</p></div><div><p>2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</p></div></div> <div><p>BEFORE PRESSING</p><p>AFTER PRESSING</p></div>	<p>GLUE STICK</p> 	<p>1. No unlocked/half-locked connector 2. No damage connector 3. Use provided jig tool per model to avoid damaged lock.</p> <p><b>Important reminders/Note/s</b></p> <p>1. Manual locking may cause damaged connector lock. 2. Position of glue stick must be slanted.</p> <p><b>LOCK CONDITION</b></p> <div><p>GOOD</p><p>NG</p></div>

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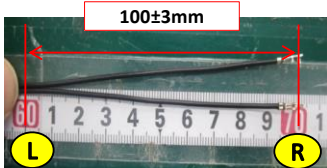
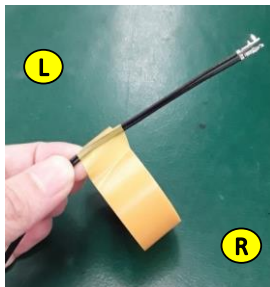

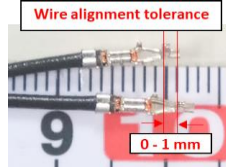

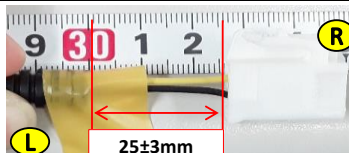
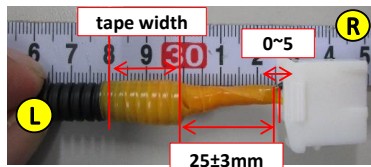

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PARTS:		1. Orange tape 2. Assy parts	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	Spot taping	 <p>1. Hold wires using left hand, get Orange tape then start taping using right hand <b>100±3mm</b>. Make <b>2 winds</b>.</p>	 <b>MEASUREMENT</b> 	1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension <b>5. Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b> <b>2. Use ORANGE TAPE only.</b> 
10	Taping 1 COT to wire near connector	 <p>1. Hold the COT using left hand, get Orange tape and start pre-taping using right hand.</p>  <p>2. Hold the COT using left hand and measure the COT up to the end of connector <b>25mm</b>, proceed on taping process.</p>  <p>3. After taping, check the dimension and taping condition.</p>	<b>MEASUREMENT</b> 	1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape <b>5. Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b> <b>2. Use ORANGE TAPE only.</b>

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PARTS:		1. Black Corrugated tube Ø5 L=85±3mm (No slit) 2. Assy parts			JIG	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	Wire insertion to Black Corrugated tube (no slit) Ø5 L=85±3mm	<div><div><p>1. Get the terminal cover jig using right hand then insert the 2 Black wires.</p></div><div><p>2. Get the Black corrugated tube Ø5 L=85±3mm (no slit) using right hand and insert the 2 Black wires.</p></div><div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div></div>		<b>TERMINAL COVER JIG</b> 	1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension

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