



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 21, 2024

Model code/Part number:

GC7(FHI)/ 15G060-0010

Customer: TRP

Car Model: SUBARU-LEGACY

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-016A

Revision No.:

5

Page No.:

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PARTS:		1. Connector 505570-0600 (W)				JIG:		1. Insertion jig					
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS			
1		P1		<div><div>5</div><div>Connector setting to insertion jig 505570-0600 (W)</div><div><div>INSERTION JIG</div><div><div><div><div><div>Lock/unlock</div><div>Visual reference</div><div>Adjustable lock</div></div><div><div>CONNECTOR ORIENTATION</div></div></div><div><div><div><div><div>L</div><div>R</div></div><div><div>BEFORE PRESSING</div></div></div><div><div><div><div>L</div><div>R</div></div><div><div>AFTER PRESSING</div></div></div></div><div><div>1. Get the connector 505570-0600 and set it to jig using right hand. <i>Note: Follow the connector orientation.</i></div><div><div>2. Press the lock button using left index finger. You will notice the holes that needs to be inserted are only open.</div></div></div></div></div><div><div><div><div><div>Safety Instruction</div><div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div></div><div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</div></div><div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div></div></div><div><div><div>Important reminders/Note/s:</div><div>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push procedure. Do not exert extra force. 2. Please hold the wire near terminal during insertion. 3. Insertion must be from left to right.</div><div>Document reference/s:</div><div>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div></div></div></div></div></div></div></div>									
Revision History						Prepared by		Reviewed by		Approved by		Noted by	
03/21/24		5		Separate Connector setting and Wire insertion process. Change from 1 piece to 3 piece flow. Change term from Vinyl tube to SV tube (Vinyl).		D.Castillio		C.Villanueva		A. Arañes		n/a	
08/08/23		4		Update template; Inclusion of CAR MODEL "SUBARU-LEGACY". (Refer to ENGDRR-144 for Document revision request)		M. Ariola		J. Loterte		C.Villanueva		A. Arañes	
10/19/22		3		Remove validity date. Improve Quali pointers: Reminders/Notes and references on page no. 1,3 and 4 due to document improvement.		M. Ariola		J. Loterte		C.Villanueva		A. Arañes	
Eff. Date		Rev. No		Details of Change		Revised		Reviewed		Approved		Noted	
						Est. Date:		October 07, 2019					

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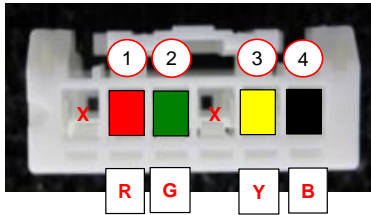

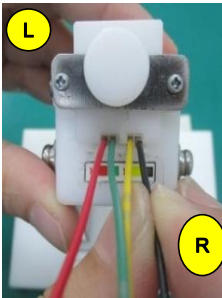
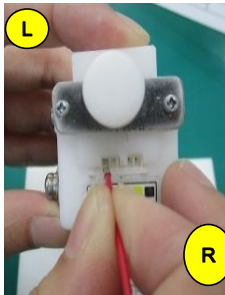
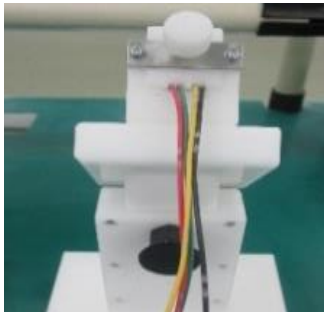
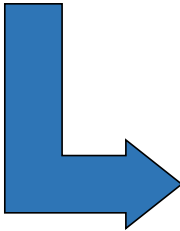
☒ MASSPRO

Revision No.:

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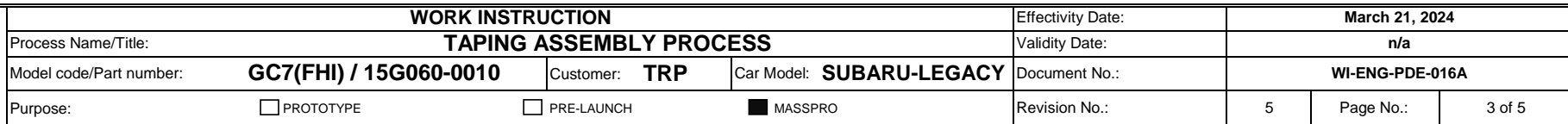
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PARTS:	1. AVSS 0.3 Black, Yellow, Green and Red L= 170mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Wire insertion to Connector 505570-0600 (W)	<div>WIRE SEQUENCE FROM LEFT TO RIGHT</div> <div></div> <div><div>WIRE FACING</div></div> <div><div></div><div></div></div> <div>1. Get R wire and insert to terminal slot using right hand. Conduct pull-push 2x. Repeat the process for G-Y and B wires. <i>Note: Follow wire sequence based on visual reference attached to jig.</i></div>	N/A	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s:</div> <div>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wire near terminal during insertion. 3. Insertion of wire must be from left to right.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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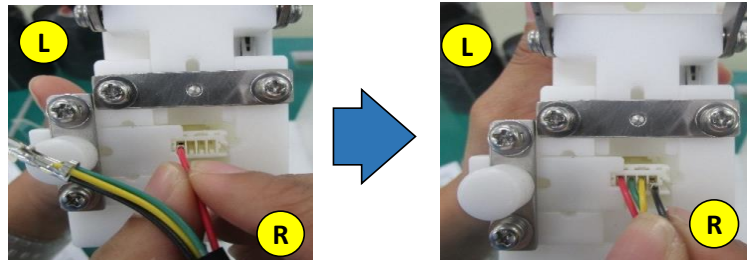
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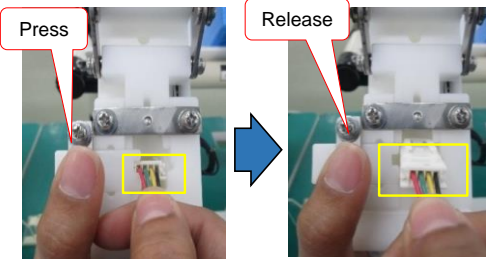
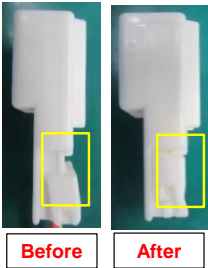

PARTS:		1. Connector 7282-5976 (W) 2. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Wire Insertion to Connector 7282-5976 (W)	<div><div><div><div><div>1</div><div>2</div><div>3</div><div>4</div></div><div><div>R</div><div>G</div><div>Y</div><div>B</div></div></div><div>Wire sequence</div></div><div><div></div><div>Wire facing</div></div><div><div></div></div><div><div>1. Get the R wire and insert to terminal slot using right hand. Conduct pull test 2x. Repeat the process for G-Y and B wires. <i>Note: Follow wire sequence based on visual reference attached to jig.</i></div></div></div>		N/A	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. 2. Please hold the wire near terminal during insertion. 3. Insertion of wire must be from left to right.</div> <div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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

PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Connector lock	<div><p>1. Pull down the handle using right hand to lock the connector.</p><p>2. Press the unlock button to release the lock using left thumb. Then slowly remove the harness from jig. Check the lock if properly pressed.</p></div>		n/a	1. No unlock/half-locked connector
7	P1 Pass WIP to P2	<div><p>1. Put WIP to WIP holder.</p></div>		N/A	<div><div>5</div><p>Important reminders/Note/s:</p><p>1. Three (3) Piece flow</p></div> <p>1. No WIP overflow</p>

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