



## WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number **ES1 / 7M0519-7020A**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

October 13, 2021

Validity Date:

n/a

Document No.:


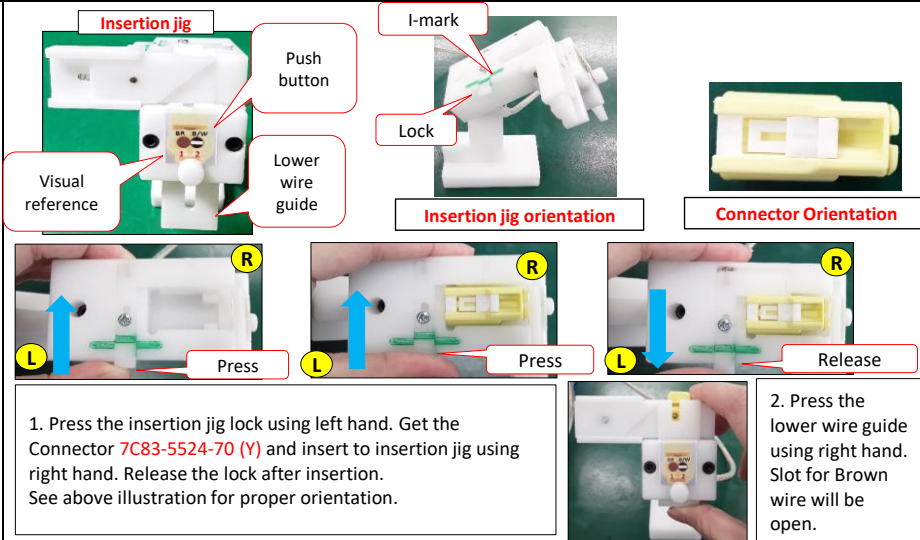
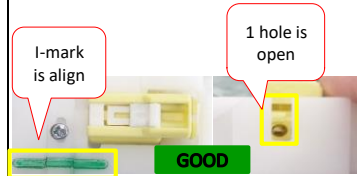
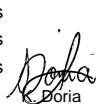



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<b>PARTS:</b>		1. Black corrugated tube $\phi 7$ L=644 $\pm$ 5mm (no slit) 2. Connector 7C83-5524-70 (Y)				3. MR SW CP 7M0519-7040 (Hotmelted AVSSf 0.3 wires BR and B/W L=765mm)		<b>JIG:</b>	1. Insertion jig					
<b>NO.</b>		<b>PROCESS NAME</b>		<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>				
1		Wire insertion to Corrugated tube $\phi 7$ L=644 $\pm$ 5mm (no slit)		 <p>1. Hold the corrugated tube <math>\phi 7</math> L=644<math>\pm</math>5mm using left hand then get the hot melted BR and B/W wires and insert to COT using right hand.</p>				<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><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><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		1. No wrong use of parts 2. No deformed terminal				
2		P1  Connector setting to insertion jig 7C83-5524-70 (Y)		 <p>1. Press the insertion jig lock using left hand. Get the Connector 7C83-5524-70 (Y) and insert to insertion jig using right hand. Release the lock after insertion. See above illustration for proper orientation.</p> <p>2. Press the lower wire guide using right hand. Slot for Brown wire will be open.</p>				<div><b>Connector Orientation Illustration</b></div>  <p>1. No wrong orientation of connector</p>						
<b>Revision History</b>										Prepared by:		Checked by:	Approved by:	Noted by:
10/13/21	6	Removal of pushing process.				K. Doria	J. Loterte	C. Villanueva	A. Arañes					
04/30/21	5	Remove validity date				J. Loterte	C. Villanueva	A. Shimamura	A. Arañes					
10/29/20	4	Apply some improvements, Update pictures; removal of cycle time				J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes					
03/01/18	n/a	Previously established Engineering instruction (EI-ENG-PDE-018). Initial issue.				J. Loterte	R. Alcantara	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change				Revise	Check	Approve	Noted	Est. date:	September 24, 2018			

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

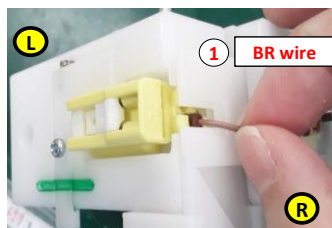
QUALITY POINTERS

3

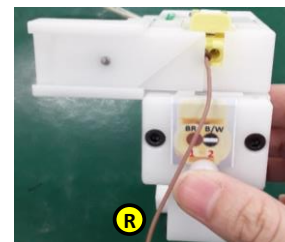
P1

Wire insertion to  
connector  
7C83-5524-70 (Y)

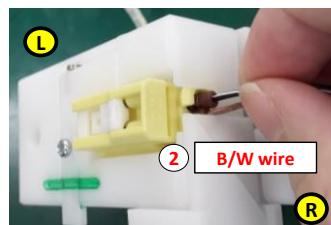
Wire facing



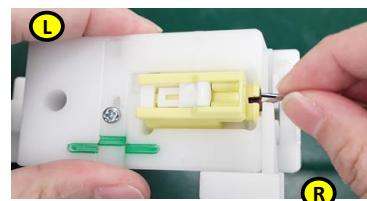
1. Get the **Brown wire** and insert to terminal **slot 1** using right hand.



2. After insertion of **BR wire**, press the button using right thumb. Slot for **B/W wire** will be open.



3. Get the **B/W wire** and insert to terminal **slot 2** using right hand.



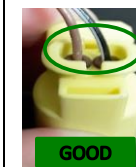
4. After insertion, press the insertion jig lock using left hand and then hold the wire and gently pull out the connector from jig using right hand.

n/a

#### EMERGED RUBBER SEAL CROSS SECTIONAL VIEW



#### RUBBER SEAL CONDITION ILLUSTRATION



Make sure wires are properly inserted.  
Conduct **Pull-Push-Pull-Push** after insertion.  
Do not exert extra force.

*Note: Please hold the wire near terminal during insertion.*

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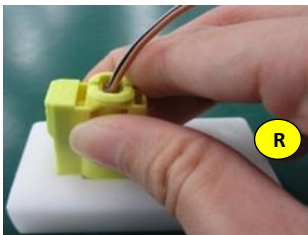
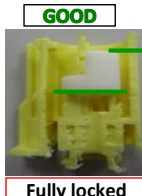
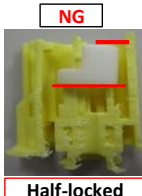
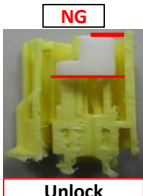


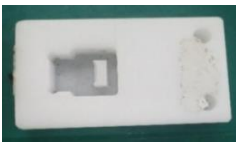
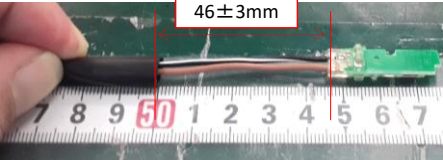
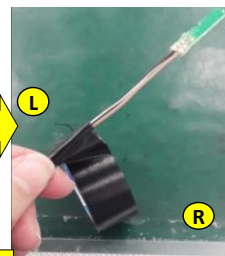
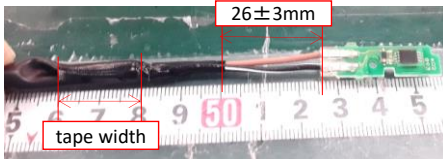

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PARTS:		1. Black tape 2. Assy parts			JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P1 Connector lock	 <p>1. Hold the connector using right hand and insert into locking jig. Push to lock 2x.</p> <div><b>CROSS SECTIONAL VIEW</b></div> <div><p>Unlock      Half-locked      Fully locked</p><p>Before Pressing      After Pressing</p></div>			<b>LOCKING JIG</b> 	<p><i>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK</i></p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p>
5	P1 Taping 1 Vinyl tube to wire near PCB	 <p>1. Measure from vinyl tube to edge of hotmelt 46mm.</p> <p>46±3mm</p>  <p>2. Hold the vinyl tube using left hand and start taping using right hand.</p> <p><i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>26±3mm</p> <p>tape width</p> <p>3. After taping, check the dimension and taping condition.</p>			<b>MEASURING TAPE</b> 	<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><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></p>

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**PARTS:**

1. Black tape
2. Assy parts

**JIG**

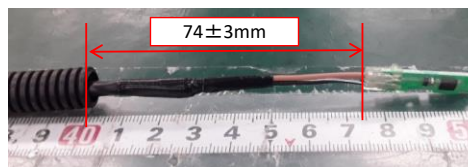
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**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

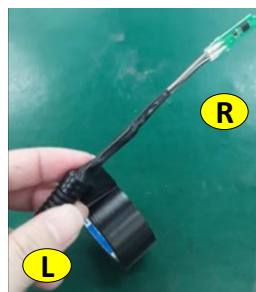
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P1

Taping 2  
Corrugated tube to vinyl  
tube

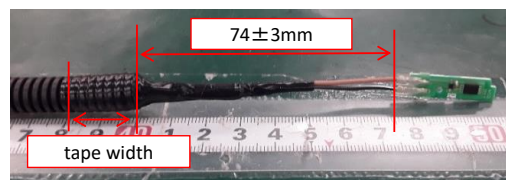


1. Measure the COT up to the edge of hotmelt  $74\pm 3\text{mm}$  using both hands.



2. Hold the corrugated tube using left hand and begin taping using right hand.

*Note: Please refer to WI-PRO-ASY-001 for taping procedure*



3. After taping, check the dimension and taping condition.

**MEASURING TAPE**

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

**Note:**  
*Please use calibrated/verified measuring tape when getting the measurement.*

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