



# WORK INSTRUCTION

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

Model Code/Part Number: **RE7 / 15F856-0020** Customer: **TRP**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

**October 28, 2022**

Validity Date:

n/a

Document No.:

**WI-ENG-PDE-023A**

Revision No.:

5

Page No.:

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## PARTS:

1. Connector 505570-0600 (W)
2. AVSS 0.3 Black, Yellow, Green and Red L= 265±2mm

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P1

Wire insertion to Connector  
505570-0600 (W)

**Insertion Jig**

**Wire sequence**

**Before pressing**

**After pressing**

1. Get the connector **505570-0600 (W)** and set it to jig using right hand. *Note: Follow the connector orientation.*

2. Press the lock button using left index finger. You will notice the holes that needs to be inserted are only open.

3. Get the **R wire** and insert to terminal slot **1** using right hand, conduct pull-push **2x**. Repeat the process for **G-Y- and B wires**.  
*Note: Follow wire sequence based on visual reference attached on jig.*

### 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. No removed wires or wrong insertion
2. Must have slight movement after insertion
3. No stuck-up terminal tip
4. No deformed terminal
5. No loose insertion
6. No wrong insertion
7. One by one insertion
8. No wrong wire facing

### Important reminders/Note/s:

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.

### Document reference/s:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
10/28/22	5	Improve Quality pointers: Reminders/notes and references on page no. 1 and 3 due to document improvement.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
04/12/22	4	Removal of validity date. Additional procedure description, notes and quality pointers on page 1 - 3.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
01/09/21	3	Standardize the color of connectors in accordance with color standardization for plastic parts; Change quality pointers for insertion process from 2x pulling to Pull-Push-Pull-Push; Put assy parts on Parts section on Page 2-4	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				

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☐ PROTOTYPE

☐ PRE-LAUNCH

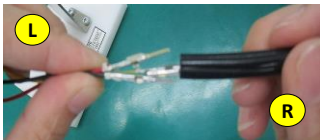
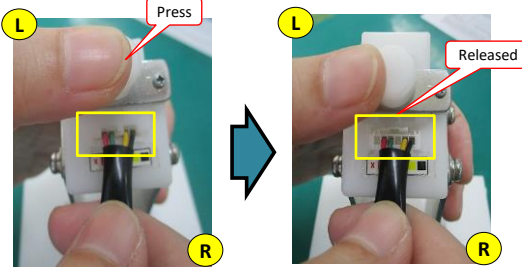


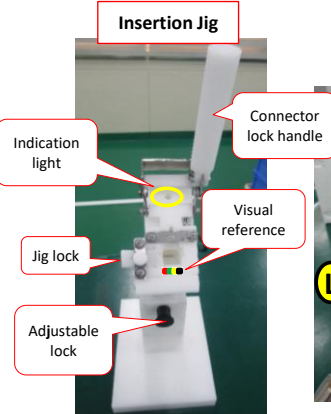
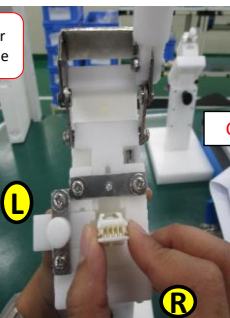
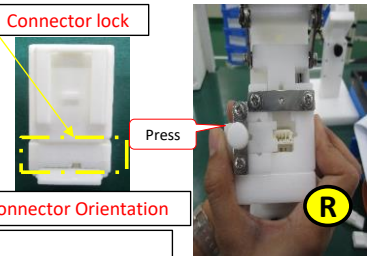
☒ MASSPRO

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PARTS:		1. Black vinyl tube $\phi 6$ L=218 $\pm$ 3mm 2. Connector 7282-5976 (W)	3. Assy parts	JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to Vinyl tube $\phi 6$ L=218 $\pm$ 3mm	<div><p>1. Get the vinyl tube <math>\phi 6</math> L=218<math>\pm</math>3mm using right hand and insert the wires.</p></div> <div><p>2. Press the unlock button using left thumb to release the lock. Then slowly remove the harness from jig.</p></div> <div><p>3. Compare the wire insertion to visual aid then check the condition of terminal claw.</p></div>	n/a	<div>1. No wrong use of parts 2. Terminal claw must be seen in connector holes</div> 
3		Connector setting to connector 7282-5976 (W)	<div><p>Indication light Connector lock handle Visual reference Jig lock Adjustable lock</p></div> <div><p>Connector lock Press</p></div> <div><p>Connector Orientation</p></div> <div><p>1. Get the connector 7282-5976 (W) and insert to jig using right hand.</p></div> <div><p>2. Press the lock using right thumb after insertion</p></div>	n/a	<div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>

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### PARTS:

1. Connector 7282-5976 (W)
2. Assy parts

### JIG

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

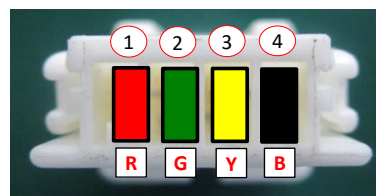
### TOOLS/PPE

### QUALITY POINTERS

4

P1

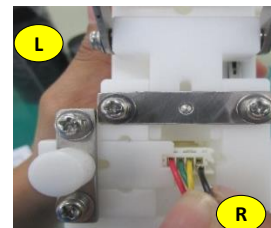
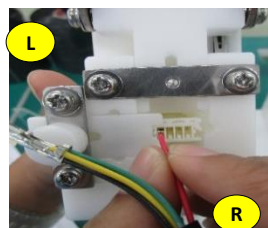
Wire Insertion to Connector  
7282-5976 (W)



Wire sequence



Wire facing



1. Get the **R** wire and insert to terminal slot **1** using right hand, conduct pull-push **2x**. Repeat the process for **G-Y** and **B** wires.

**Note:** Follow wire sequence based on visual reference attached to jig.

n/a

### Important reminders/Note/s:

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.

### Document reference/s:

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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**5**

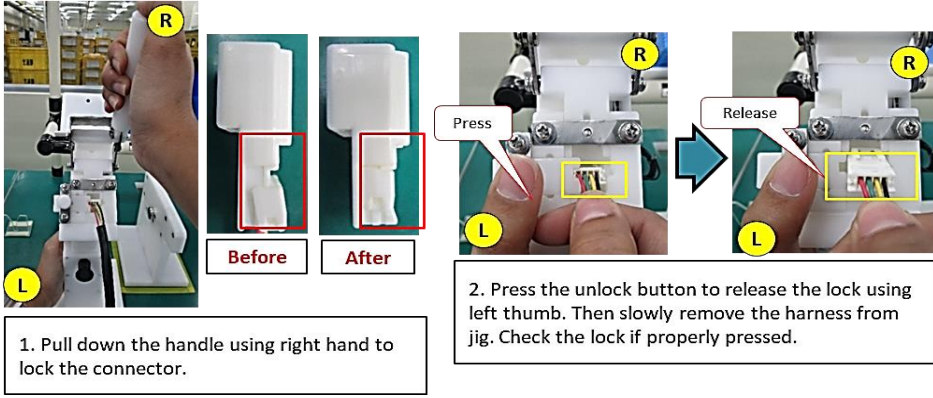
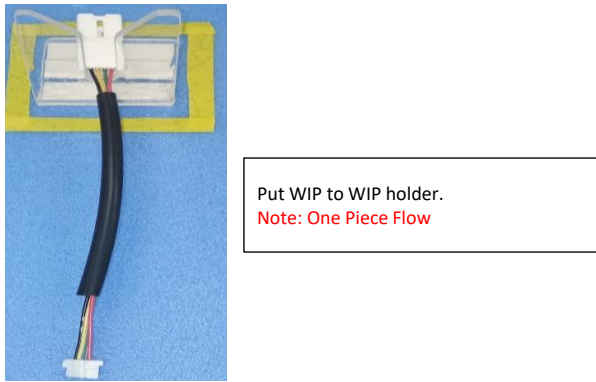
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**4 of 4****PARTS:**

1. Assy parts

**JIG**

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Connector Lock		n/a	1. No unlock/half-locked connector 2. No damaged connector
6	Pass WIP to P2			1. No WIP overflow

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