



# WORK INSTRUCTION

## KITTING ASSEMBLY PROCESS

Effectivity Date:

October 14, 2021

Process Name/Title:

Validity Date:

n/a

Product Name/Code:

ES1 / 7M0508-7020B

Customer:

TRJ

Document No.:

WI-ENG-PDE-181

Purpose:


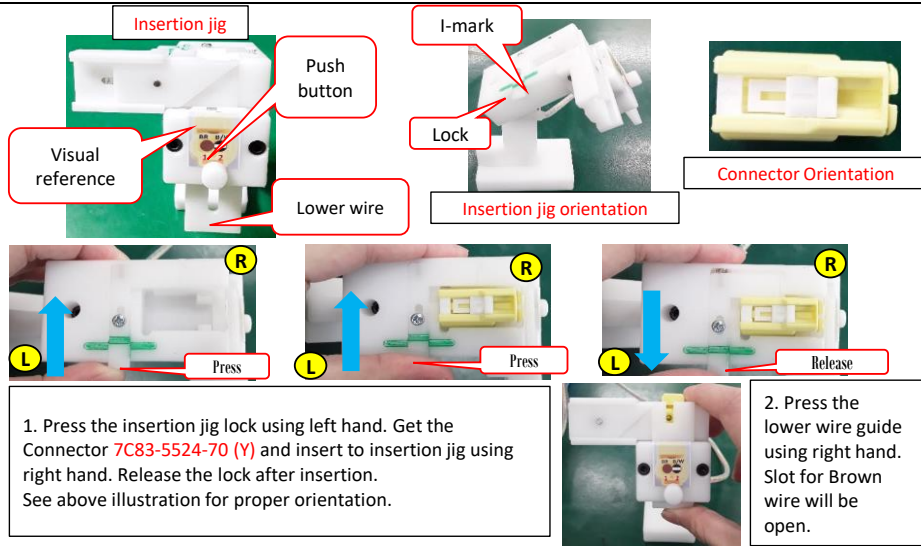

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Black corrugated tube $\phi 7$ L=619 $\pm$ 4mm (no slit) 2. Connector 7C83-5524-70 (Y)		3. MR SW CP 7M0508-7040 (Hotmelted AVSSf 0.3 wires BR and B/W L=740mm)		JIG:	1. Insertion jig			
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS	
1		Wire insertion to Corrugated tube $\phi 7$ L=619 $\pm$ 4mm (no slit)		 <p>1. Hold the corrugated tube <math>\phi 7</math> L=619<math>\pm</math>4mm 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>		1. No wrong use of parts 2. No deformed terminal	
2		n/a  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>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>		<div><b>Connector Orientation Illustration</b></div>  <p>1. No wrong orientation of connector</p>	
Revision History							Prepared by:	Reviewed by:	Approved by:	Noted by:
10/14/21	4	Removal of pushing process.				K. Doria	J. Loterte	C. Villanueva	A. Arañes	
04/28/21	3	Remove validity date.				J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	
10/29/20	2	Transfer process owner from Production (WI-PRO-ASY-096) to Engineering (WI-ENG-PDE-181), Apply some improvements; Update pictures				J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes	
09/24/19	0	Initial issue				C. Ricafort	W. Carbillon	O. Merin	n/a	
Eff. Date	Rev. No	Details of Change				Revise	Check	Approve	Noted	Est. date: September 24, 2018

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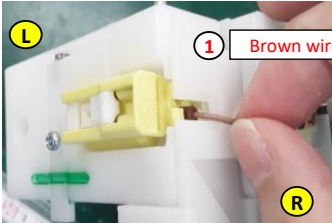
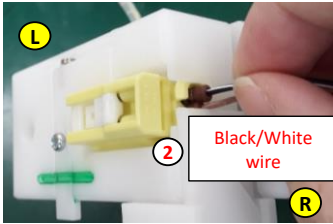
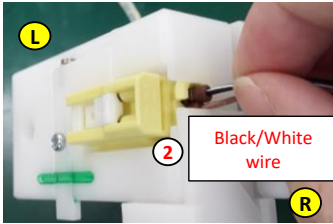
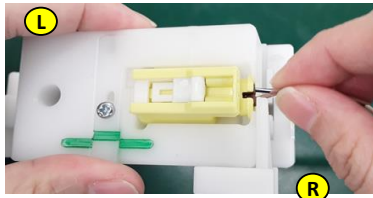
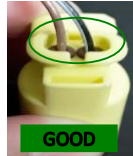



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PARTS:		1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	n/a	<p>Wie insertion to connector 7C83-5524-70 (Y)</p> <div><p>Wire facing</p></div> <div><p>1. Get the <b>Brown wire</b> and insert to terminal <b>slot 1</b> using right hand.</p></div> <div><p>2. After insertion of <b>Brown wire</b>, press the button using right thumb. Slot for <b>Black/White wire</b> will be open.</p></div> <div><p>3. Get the <b>Black/White wire</b> and insert to terminal <b>slot 2</b> using right hand.</p></div> <div><p>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.</p></div>			n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing.</p> <p>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p> <p><b>Note:</b> Please hold the wire near terminal during insertion.</p> <p><b>RUBBER SEAL CONDITION ILLUSTRATION</b></p> <div><p>GOOD</p></div> <div><p>NG</p></div> <p><b>EMERGED RUBBER SEAL CROSS SECTIONAL VIEW</b></p> <div><p>GOOD</p></div> <div><p>NG</p></div>

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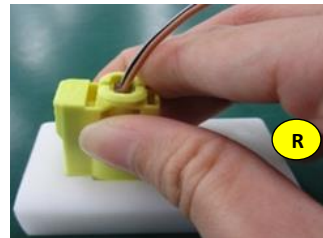


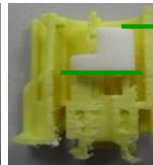
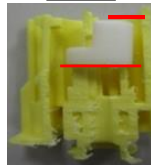
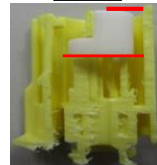
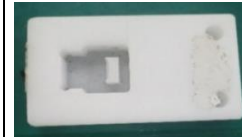
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PARTS:		1. Assy parts			JIG	1. Locking jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	Connector lock	<div></div> <div>1. Hold the connector using right hand and insert into locking jig. Push to lock 2x.</div> <div><div><b>CROSS SECTIONAL VIEW</b></div><div><div>Unlock      Half-locked      Fully locked</div></div></div>		Locking Jig 	<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>

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