

	WORK INSTRUCTION				Effectivity Date:		July 04, 2024	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: TM3 / 7L0145-7020A		Customer: TRQSS		Car Model: SUBARU-ASCENT	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-714A		Revision No.: 2		Page No.: 1 of 10	

PARTS: 1. (Assy parts (Connector 7283-1138 (W) with inserted jointed wire (7L0145-2000A and Black corrugated tube Ø7, L=224±3mm (no slit); AVSSf 0.3 B L=419±2mm; AVSSf 0.3 Y L=339±2mm; Connector 7282-1028 (W); Black corrugated tube Ø5, L=59±3mm (no slit)			JIG:		1. Insertion with and without switch cover 2. Pushing jig 3. Terminal cover jig	
NO.	PROCESS NAME	<div style="text-align: center;"> <p>Table Lay-out</p> </div>	TOOLS/PPE	QUALITY POINTERS		
1	P1	<div style="display: flex; justify-content: space-between;"> <div style="width: 48%;"> <p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div> <div style="width: 48%;"> <p>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-ENG-PDE-709 for Offline assembly process</p> <p>1. No deformed terminal 2. No wrong usage of parts</p> </div> </div>				

Revision History							Prepared by	Reviewed by	Approved by	Noted by
07/04/24	2	Transfer Spot taping and Taping 1 to P2 due to process improvement. Improved table lay-out and Visual inspection/Quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
08/26/23	1	Change from Pre-launch to Masspro. Inclusion of table lay-out and quality pointers. Provide insertion jig .	D.Castillo	J.Loterte	C.Villanueva	A. Arañes				
07/24/23	0	Initial issue.	D.Castillo	J.Loterte	C.Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	July 24, 2023		

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PARTS:	1. Assy parts			JIG:	1. Insertion jig with switch cover	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P1 Connector Setting to insertion jig 7283-1138 (W) (Assy parts)	<div><div>Insertion jig</div><div>Insertion jig orientation</div><div>Connector Orientation</div><div>Visual reference</div><div>Slider</div><div>I-mark</div><div>Connector lock</div><div>Visual reference</div><div>Press</div><div>Hole</div><div>1. Push the lower wire guide using right hand.</div><div>2. Press the lock of insertion jig using left thumb.</div><div>3. Insert the connector 7283-1138 (W) into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></div><div>4. Check the hole/terminal slot for Yellow wire.</div></div>			n/a	<div><div>Connector Orientation Illustration</div><div>I-mark is align</div><div>1 hole were only open</div><div>GOOD</div><div>I-mark is NOT align</div><div>1 hole were open</div><div>NG</div><div>CONNECTOR ILLUSTRATION</div><div>GOOD</div><div>NG</div><div>7283-1030 (W)</div><div>7283-1138 (W)</div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div>

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PARTS:

1. AVSSf 0.3 B L=419±2mm
2. AVSSf 0.3 Y L=339±2mm

JIG:

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

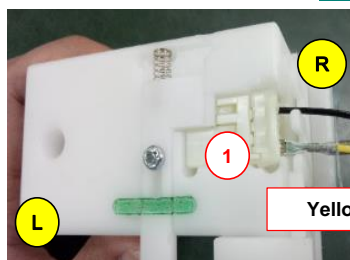
3

P1

Wire insertion to connector
7283-1138(W)
(Assy parts)

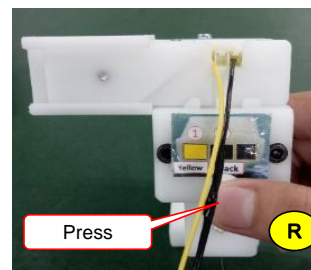


Wire Facing



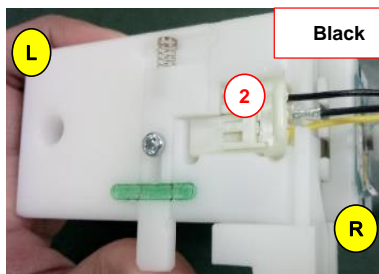
Yellow

1. Get the **Yellow wire** using right hand then insert to terminal slot **1** using right hand.



Press

2. Press the button using right hand, the slot for **Black wire** will be opened.



Black

3. Get the **Black wire** using right hand then insert to terminal slot **2** using right hand.

n/a

Important reminders/Note/s:

1. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted . Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force

Document references:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

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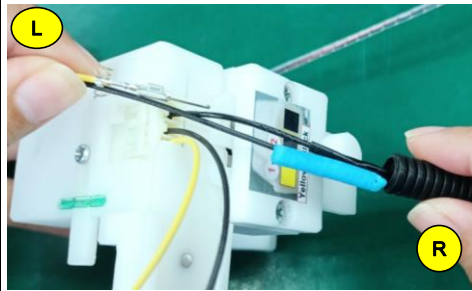
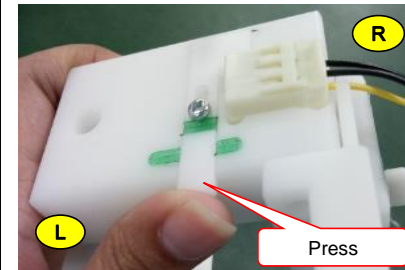

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PARTS:		1. Assy parts		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<div><div></div><div></div><div></div><div>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B wire using left hand.</div><div>2. Hold the corrugated tube (no slit) Ø5 L=224±3mm using right hand then insert the B and Y wires using left hand.</div><div>3. After insertion, press the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div></div> <div>TERMINAL COVER JIG</div> <div></div> <div>1. No deformed terminal 2. No wrong usage of parts</div>			

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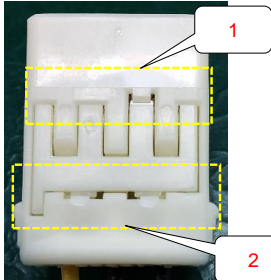
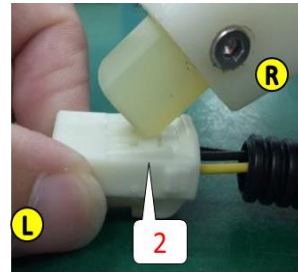
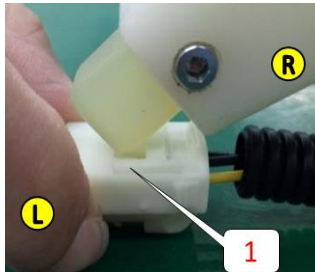
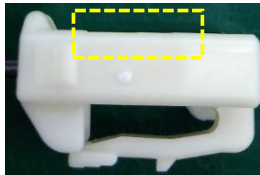
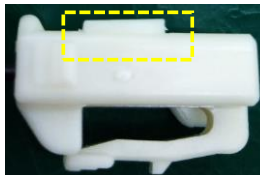
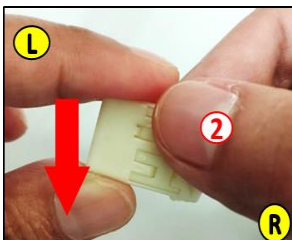
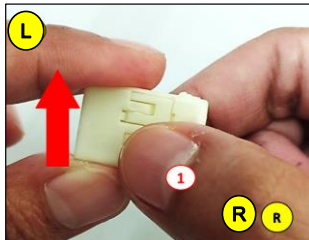


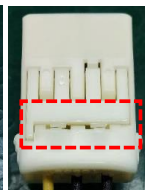
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PARTS:	1. Assy parts		JIG:	1. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 Connector lock	<div><div>LOCKING SEQUENCE</div><div></div><div></div><div>1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on above illustration. Push the lower part of the connector lock first and then push the upper part.</div><div></div><div>BEFORE PRESSINGAFTER PRESSING</div><div></div><div>2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</div></div>	<div>PUSHING JIG</div> <div></div>	<div>Important reminders/Note/s:</div> <div>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</div> <div>2. Use provided jig tool per model to avoid damaged lock.</div> <div>1. No unlocked/half-locked connector 2. No damage connector</div> <div>LOCK CONDITION</div> <div><div> GOOD</div><div> NG</div></div>

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PARTS:		1. Black Corrugated tube (no slit) Ø5 L=59±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	<div><p>Wire insertion to Black Corrugated tube (no slit) Ø5 L=59±3mm</p><div><p>1. Get the corrugated tube Ø5 L=59±3mm using right hand then insert the Y and B jointed wire using left hand.</p></div></div>		n/a	1. No deformed terminal 2. No wrong usage of parts

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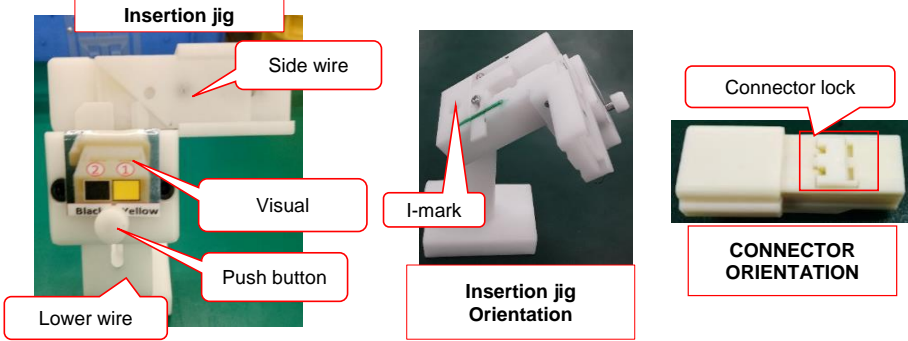
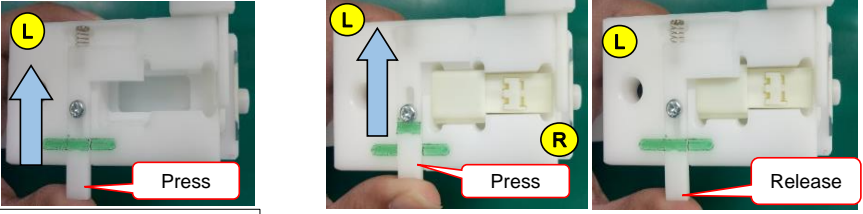
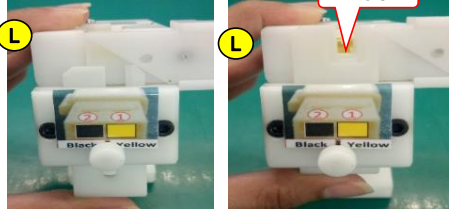
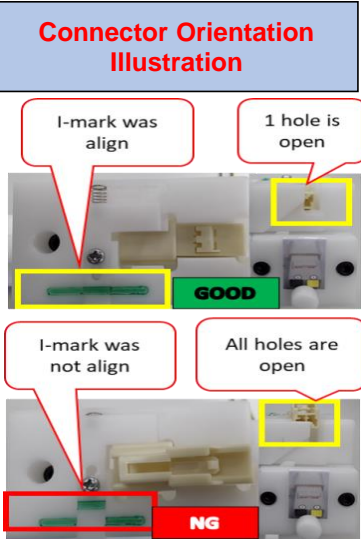
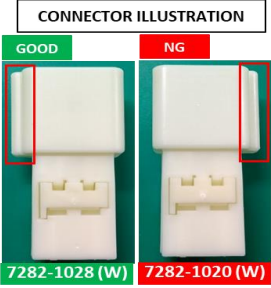
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PARTS:		1. Connector 7282-1028 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	<p>Connector setting to Insertion jig 7282-1028 (W)</p>   <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 7282-1028 (W) into jig using right hand and release the lock. Note: Follow the connector orientation.</p>  <p>3. Push the lower guide using left thumb, the slot for Yellow wire will be opened.</p>		n/a	<p>Connector Orientation Illustration</p>  <p>CONNECTOR ILLUSTRATION</p>  <p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>

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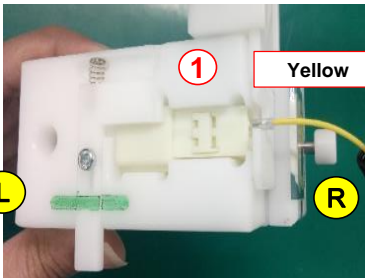
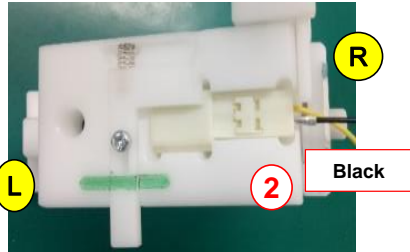

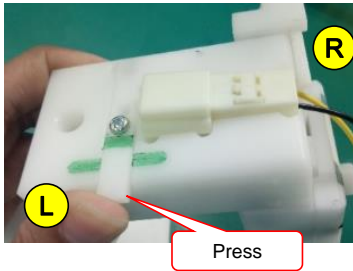
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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Wire insertion to connector 7282-1028 (W)	<div>WIRE FACING</div> <div><p>1. Insert the Yellow wire using right hand then insert to terminal slot 1 using right hand.</p></div> <div><p>3. Get Black wire using right hand then insert to terminal slot 2 using right hand.</p></div> <div><p>2. Press the button using right hand, the slot for Black wire will be opened.</p></div> <div><p>4. After insertion, press the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>2. Please hold the wire near terminal during insertion.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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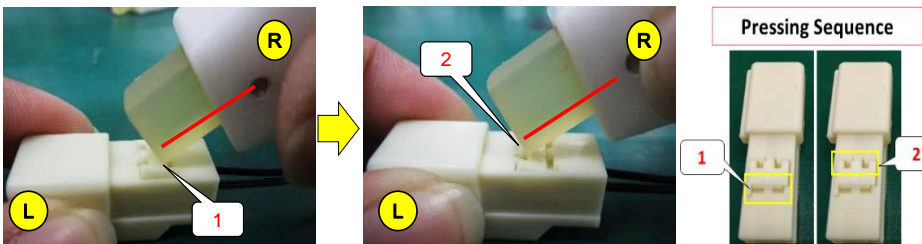
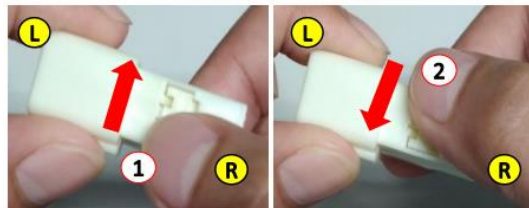
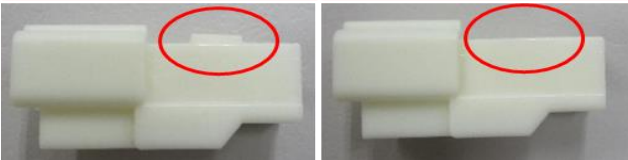

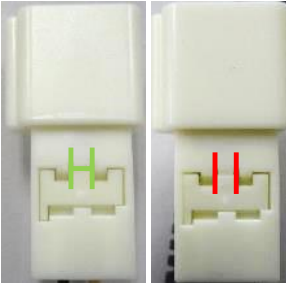
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PARTS:	1. Assy parts		JIG:	1. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1 Connector lock	<div></div> <div>1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on the above illustration. Push the lower part of the connector lock first and then push the upper part.</div> <div></div> <div>2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</div> <div><div>Before pressing</div><div>After pressing</div></div>	<div>PUSHING JIG</div> 	<div>Important reminders/Note/s:</div> <div>1. Manual locking may cause damaged connector lock.</div> <div>2. Use provided jig tool per model to avoid damaged lock.</div> <div>3. Position of pushing jig during locking must be slanted.</div> <div>LOCK CONDITION</div> <div></div> <div>GOOD</div> <div>NG</div> <div>1. No unlocked/half-locked connector</div> <div>2. No damage connector.</div>

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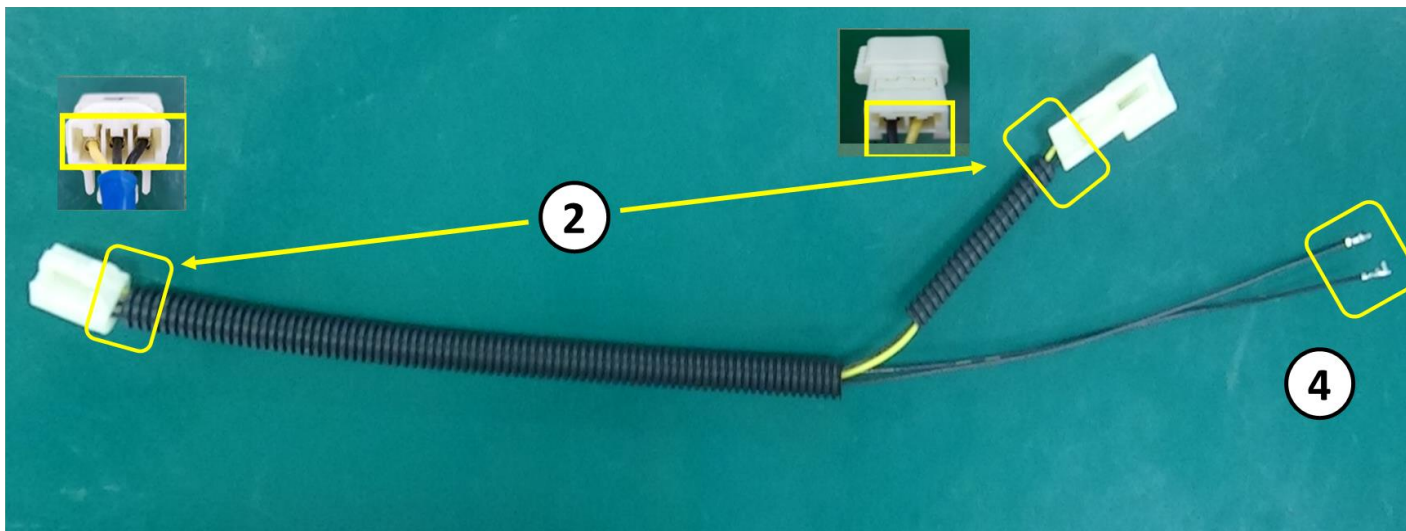
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7L0145-7020A****GOOD****NO GOOD****GOOD****NO GOOD****GOOD****NO GOOD****1 No Unlocked / Halflocked Connector****3 No Terminal Backing Out****2 No Wrong Insert****4 No Deformed Terminal**

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