

	WORK INSTRUCTION				Effectivity Date:		July 9, 2021		
	KITTING ASSEMBLY PROCESS				Validity Date:		n/a		
	Process Name/Title:				Document No.:		WI-ENG-PDE-223		
	Product Name/Code: 587B / 7M0533-7020		Customer: TRJ		Revision No.:		3 Page No.: 1 of 3		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO									

PARTS:	1. Connector 6188-0066 (GR) With inserted dummy seal P/N: 7160-9465 (B) [2pcs]	JIG:	1. Insertion jig w/ switch cover
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Wire insertion to Connector 6188-0066 (GR)	<div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <p>INSERTION JIG WITH SWITCH COVER</p> </div> <div style="width: 50%;"> <p>INSERTION JIG</p> </div> <div style="width: 50%;"> <p>CONNECTOR ORIENTATION</p> </div> <div style="width: 50%;"> <p>1. Press the lock of insertion jig using left thumb.</p> </div> <div style="width: 50%;"> <p>2. Insert the connector 6188-0066 (GR) into jig using right hand and release the lock.</p> </div> <div style="width: 50%;"> <p>3. Push the guide upward using right thumb. Check the holes/terminal slot for B/W wire.</p> </div> </div>	<div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<div style="border: 1px solid blue; padding: 5px;"> <p style="text-align: center; color: red;">Connector Orientation Illustration</p> <div style="display: flex; justify-content: space-around;"> <div> <p>GOOD</p> </div> <div> <p>NG</p> </div> </div> <p><i>NOTE: Refer to WI-PRO-ASY-075 for dummy seal insertion</i></p> </div>

Revision History							Prepared by	Reviewed by	Approved by	Noted by
07/08/21	3	Removal of validity date; Added control number reference for dummy seal insertion	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	 J. Loterte	 C. Villanueva	 A. Shimamura	 A. Arañes
01/20/21	2	Transfer of process owner from Production (WI-PRO-ASY-171) to Engineering (WI-ENG-PDE-223); Add insertion jig for GR and B/W wires; Change 2x pulling to Pull-Push-Pull-Push for insertion quality pointers.	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
07/30/20	1	Inclusion of completeness of inserted rubber seal in quality pointers	C. Diaz	W. Carbillon	O. Merin	n/a				
11/14/19	0	Initial issue.	C. Diaz	W. Carbillon	O. Merin	n/a				
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Note	Est. Date:	November 14, 2019		

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KITTING ASSEMBLY PROCESS

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Product Name/Code: **587B / 7M0533-7020**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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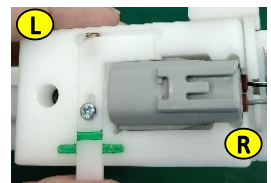
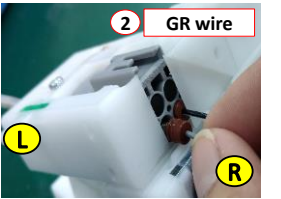
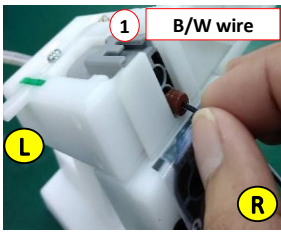
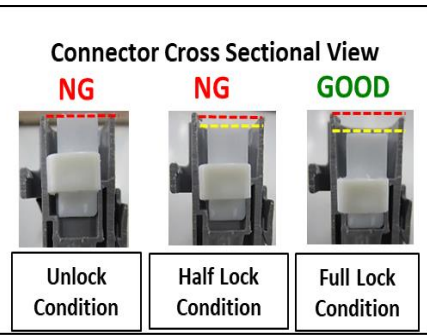
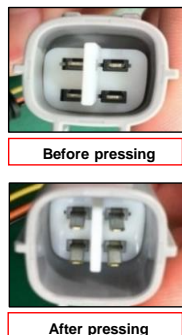

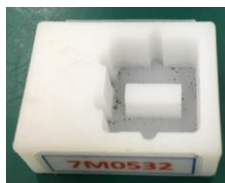
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PARTS:

1. TVSSf 0.3 wires GR L=826mm; B/W L=826mm

JIG

1. Insertion jig w/ switch cover
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to connector 6188-0066 (GR)	<div><p>1. Get the B/W wire then insert to terminal slot 1 using right hand.</p><p>2. After insertion of B/W wire, press the button using right thumb. The slot for GR wire will be opened.</p><p>3. Get the GR wire then insert to terminal slot 2 using right hand.</p><p>4. After insertion, push the lock button using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>	n/a	<ol style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deformed terminal5. No wrong wire facing <p>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p>
3	Connector lock	<div><p>1. Put the connector into locking jig using right hand then press 2x. Check if properly</p></div>	Locking jig 	<ol style="list-style-type: none">1. No unlocked/half-locked connector

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PROTOTYPE



PRE-LAUNCH





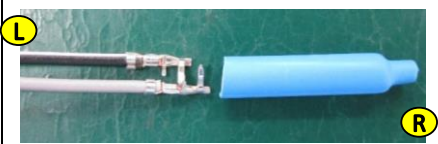
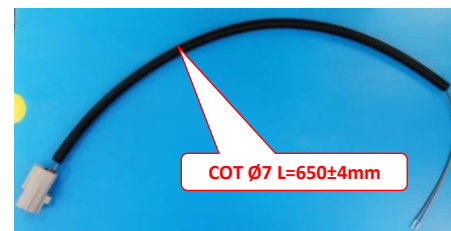

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PARTS:		1. Black Corrugated tube Ø7 L=650±4mm (no slit) 2. Assy parts			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to COT Ø7 L=650±4mm (no slit)	<div><div><p>1. Get the terminal cover jig using right hand and then insert the B/W-GR wires using left hand.</p></div><div><p>2. Get the corrugated tube (no slit) Ø7 L=650±4mm (no slit) using right hand and then insert the B/W and GR wires using left hand.</p></div><div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div><div></div></div> <div>Terminal cover jig</div> <div></div> <div>1. No wrong use of parts 2. No deformed terminal</div>				

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