



WORK INSTRUCTION

Effectivity Date:

March 1, 2021

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

-

Product Name/Code:

780B



7R0105-7020B

Customer:

TRMX

Document No.:

WI-ENG-PDE-200A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

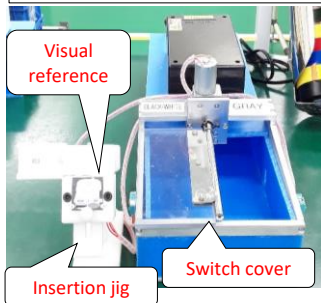
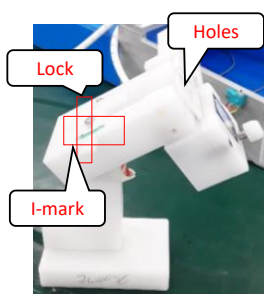

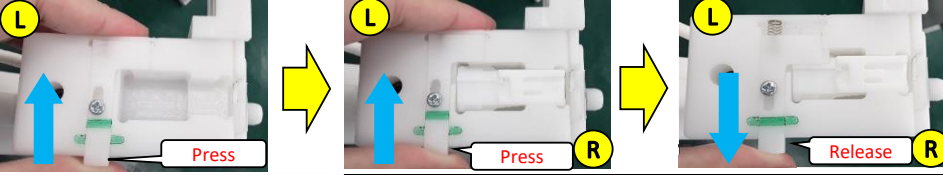
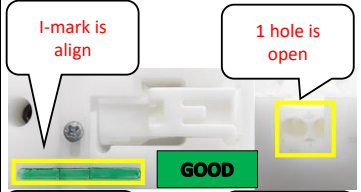
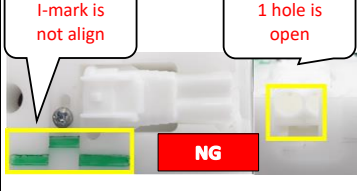
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PARTS:

1. Connector 6188-0407 (W)

JIG:

1. Insertion jig with switch cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Connector setting to Insertion jig 6188-0407 (W)	<p>Insertion jig with switch cover</p>    <p>Connector orientation</p>  <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></p> <p>3. Check the holes/terminal slot for B/W wire.</p>	<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>	<p>Connector Orientation Illustration</p>   <p>1. Use the provided jig per model 2. No wrong orientation of connector</p>

Revision History

Prepared by: Reviewed by: Approved by: Noted by:

03/01/21	1	Part number change; change status from pre-launch to masspro; change wire GR and B/W length from 559mm to 583mm; change sunprene tube length from 301mm to 325mm	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	J. Loterte	C. Villanueva	Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	December 1, 2020		

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PARTS:



1. TVSSf 0.3 wires B/W L=583mm; GR L=583mm

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

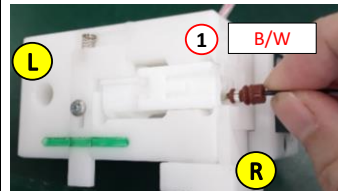
TOOLS/PPE

QUALITY POINTERS

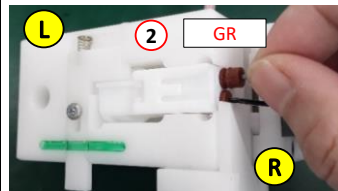
2

P1

Wire Insertion to
connector
6188-0407 (W)



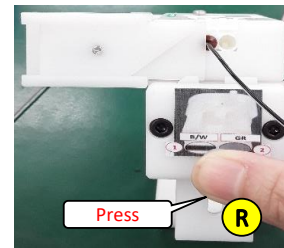
1. Get **B/W wire** then insert to terminal slot **①** using right hand.



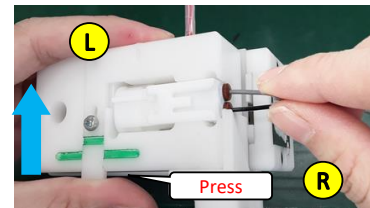
3. Get **GR wire** then insert to terminal slot **②** using right hand.



Wire facing



2. Push the button after insertion. Slot for **GR wire** will be open.



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.

n/a

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

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

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PARTS:

1. Assy parts
2. Clip type clamp 82711-1E360 (W)

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

Connector lock



Before lock



After lock

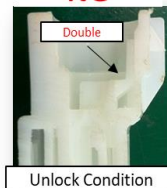


CONNECTOR CROSS SECTIONAL VIEW

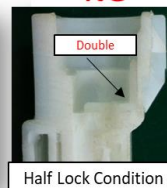
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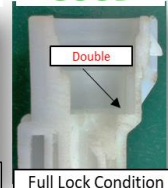
GOOD



Unlock Condition



Half Lock Condition



Full Lock Condition

1. Put the connector into locking jig using right hand then press to lock 2x.

LOCKING JIG



NOTE:
MANUAL LOCKING MAY CAUSE
DAMAGED LOCK

1. Use the provided locking per model
2. No unlock/half-locked connector

4

Clamp attachment
(Clip type clamp)
82711-1E360 (W)

1. Hold the connector using left hand. Get the clip type clamp 82711-1E360 (W) then insert the clamp using right hand.

Note Sound will be heard if properly inserted.



n/a

1. Must be fully inserted

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PARTS:



1. Black Corrugated tube Ø5 L=188±3mm (no slit)
2. Black Sunprene tube Ø5 L=325±3mm

JIG

1. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

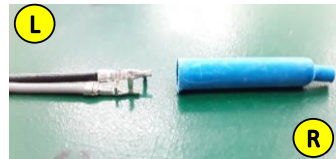
TOOLS/PPE

QUALITY POINTERS

5

P1

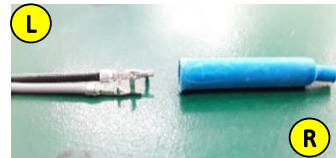
Wire insertion to
Corrugated tube
Ø5 L=188±3mm
(no slit)



1. Get the terminal cover jig using right hand then insert the GR and B/W wires.



2. Get the Corrugated Ø5 L=188±3mm (no slit) using right hand and insert the GR and B/W wires



3. After insertion, remove the terminal cover jig using right hand.

TERMINAL COVER JIG



1. No wrong use of parts
2. No deformed terminal

6



Wire insertion to
Sunprene tube
Ø5 L=325±3mm



1. Get the Black Sunprene tube Ø5 L=325±3mm using right hand and insert the GR and B/W wires

n/a

1. No wrong use of parts
2. No deformed terminal

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

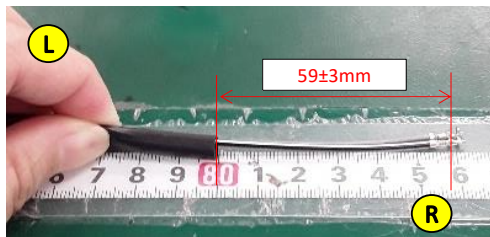
TOOLS/PPE

QUALITY POINTERS

7

P1

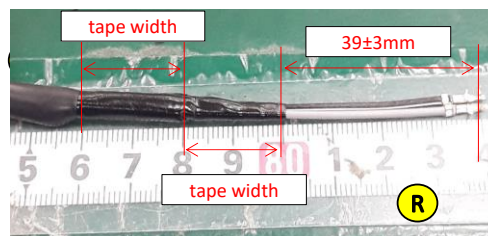
Taping
Sunprene to wire near
terminal



1. Hold the Sunprene tube using left hand. Measure from end of Sunprene up to the terminal pointed tip **59±3mm**.



2. Hold the Sunprene tube using left hand. Get Black tape using right hand and start taping using both hands.
Refer to WI-PRO-ASY-001 for taping procedure.

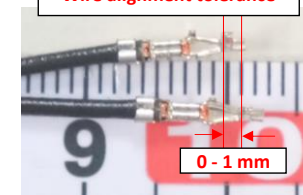


3. After taping, check the measurement, alignment and taping condition.

MEASURING TAPE



Wire alignment tolerance

**Note:**

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

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape

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