



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **178D / 7N0127-7020**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Customer:

TRJ

Effectivity Date:

January 6, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-335A

Revision No.:

1

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PARTS:

1. All parts: Connector 6189-0451 (W); TVSSf 0.3 GR-B/W L=539mm±3mm; Black corrugated tube $\phi 7$ L= 474±3mm (no slit);

JIG:

1. Insertion jig with flip cover
2. Terminal cover jig
3. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<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 workplace 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>1. No missing parts/tools 2. No excess parts/tools</p> <p>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Established Date:	Prepared by	Checked by	Approved by	Noted by
1/06/2021	1	Change from Pre-launch to Masspro; Improve work procedure/Illustration and quality pointers; Additional Table Lay-out, checkpoint in checking of wire tolerance (Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.)	K. Doria	J. Loterte	C. Villanueva	A.Arañes					
09/06/21	0	Initial issue.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes					

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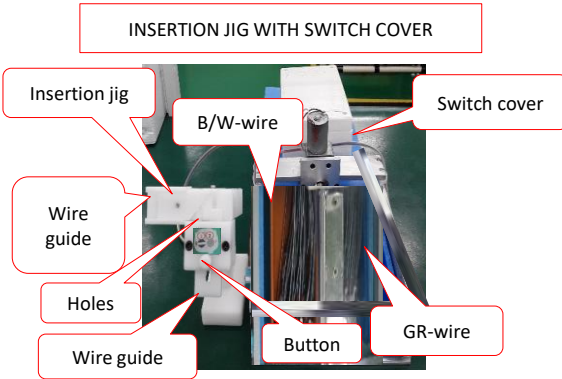

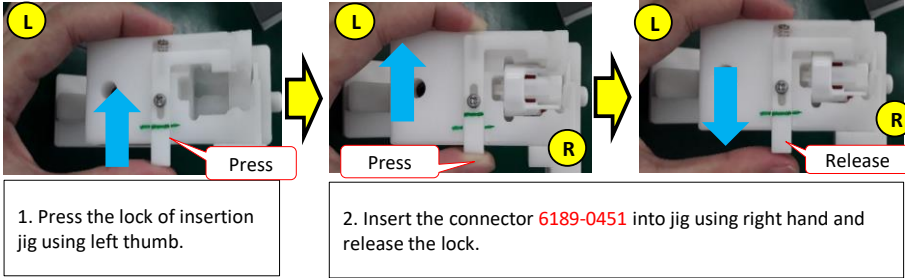
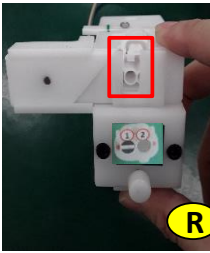


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PARTS:

1. Connector 6189-0451 (W)

JIG

1. Insertion jig with flip cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6189-0451 (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 6189-0451 into jig using right hand and release the lock.</p> <p>3. Push the guide using right hand. The slot for B/W wire will be open.</p> 	n/a	<p>Connector Orientation Illustration</p>  <p>I-mark is align</p> <p>1 hole is open</p> <p>GOOD</p>  <p>I-mark is NOT align</p> <p>1 hole is open</p> <p>NG</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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PARTS:

1. TVSSf 0.3 Wires GR L=539±3mm; B/W L=539±3mm

JIG

1. Insertion jig with flip cover
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Connector 6189-0451 (W)	<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 hand. The slot for GR wire will be open.</p> <p>3. Get the GR wire then insert to terminal slot 2 using right hand.</p> <p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p>	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>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>
4	Connector Lock	<p>Put the connector into locking jig using right hand then press to lock 2x. Check the connector lock to confirm if properly locked.</p> <p>Check the double lock deformation</p>	Locking jig	<ol style="list-style-type: none">1. Must be fully inserted2. No double lock deformation3. No Unlock/Half-locked of connector <p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p>

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PARTS:		1. Black corrugated tube $\phi 7$ L= 474 \pm 3mm (no slit) 2. Assy parts			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	P1	<div><div></div><div><div>1. Get the terminal cover jig using right hand then insert the GR-B/W wires using left hand.</div><div></div><div><div>2. Get the Black Corrugated tube $\phi 7$ L=474\pm3mm (no slit) using right hand and insert to GR-B/W wires using left hand.</div></div></div><div><div></div><div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div></div></div>			<div>Terminal Cover Jig</div> <div></div>	1. No wrong usage of parts 2. No deformed terminal

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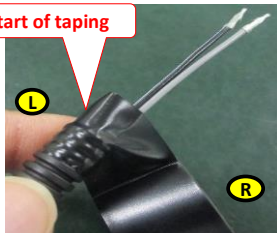
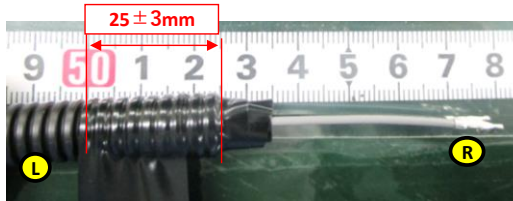

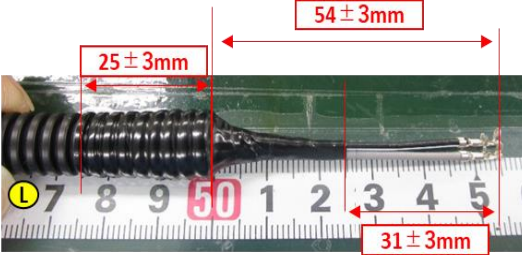

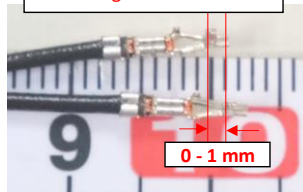
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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 Black COT to wire near terminal	<p>Start of taping</p>  <p>1. Hold the COT using left hand, get the black tape using right hand then start pre-taping using both hands. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure</i></p>  <p>2. Confirm measurement from end of tape up to end of COT 25±3mm then continue the taping process using both hands.</p>  <p>3. Measure from end of COT up to terminal pointed tip 54±3mm then continue the taping process using both hands.</p>  <p>5. After taping, check the measurement, wire alignment and taping condition.</p>	<p>MEASURING TAPE</p> 	<p>Wire alignment tolerance</p>  <p>0 - 1 mm</p> <ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape

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