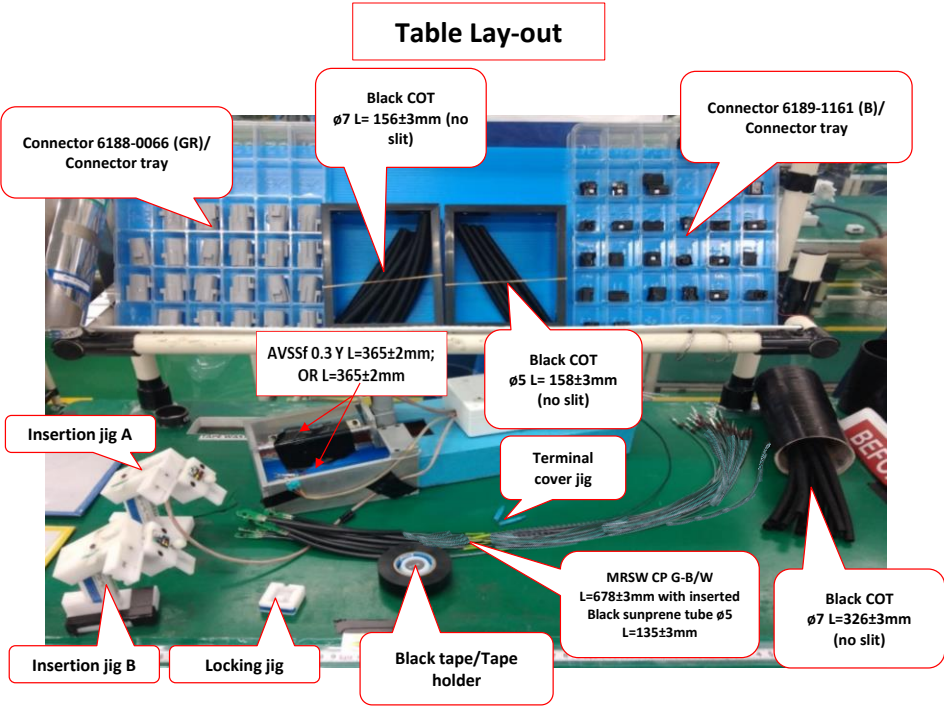




	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date: December 16, 2022	
	Process Name/Title:				Validity Date:	
	Model Code/Part Number: 010B / 7L0031-7024		Customer: TRQSS		Document No.: WI-ENG-PDE-428A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.: 1 Page No.: 1 of 10	

PARTS:		1. All parts: Connector 6188-0066 (GR); Connector 6189-1161 (B); AVSSf 0.3 Y L=365±2mm; OR L=365±2mm; Black COT ø7 L=156±3mm (no slit); Black COT ø5 L=158±3mm (no slit); Black COT ø7 L=326±3mm (no slit); MRSW CP G-B/W L=678±3mm with inserted Black sunprene tube ø5 L=135±3mm		JIG:		1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P1	<div style="text-align: center;"> Table Lay-out  </div>		<div style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-PRO-KIT-006 for Wire Taping with Vinyl Tube 1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by		Reviewed by		Approved by		Noted by					
12/16/22	1	Improve quality pointers: Reminders/notes and references. Inclusion of Quality checkpoints						M. Catapang	J. Loterte	C. Villanueva	A. Arañes								
03/05/22	0	Initial issue						M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang		J. Loterte		C. Villanueva		A. Arañes	
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:		March 5, 2022					

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PARTS:

1. Connector 6188-0066 (GR)

JIG

1. Insertion jig with switch cover

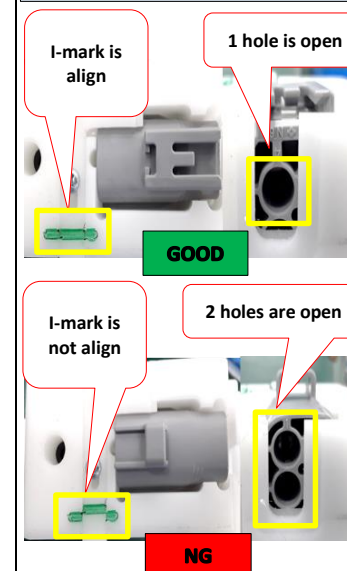
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

2

P1

Connector setting to
insertion jig
6188-0066 (GR)

n/a

**CONNECTOR ORIENTATION
ILLUSTRATION**

1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

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PARTS:

1. AVSSf 0.3 Y-OR L=365±2mm

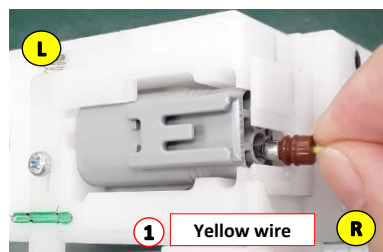
JIG

1. Insertion jig with switch cover

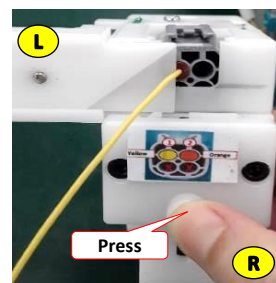
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****1 QUALITY POINTERS**

3

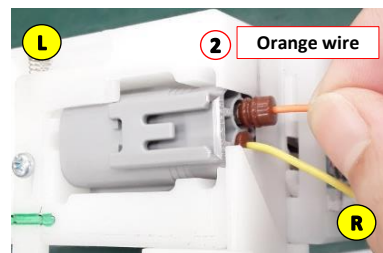
P1

Wire Insertion to
connector
6188-0066 (GR)**WIRE FACING**

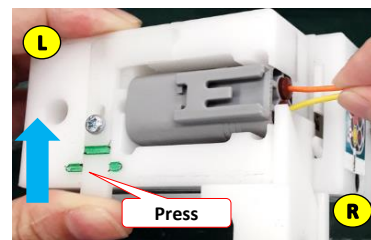
1. Hold the insertion jig using left hand.
Get the **Yellow wire** then insert to terminal
slot **1** using right hand.



2. Press the button using right thumb. The
slot for **Orange wire** will be opened.



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



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.

n/a

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

5.

Important reminders/Note/s:

- 1. Please hold the wire near terminal.**
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.**
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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PARTS:

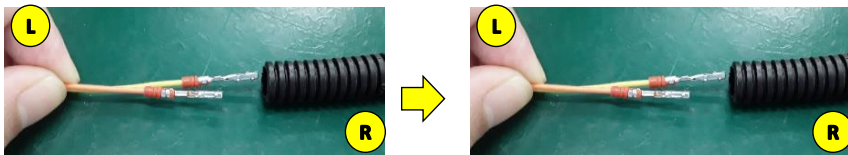
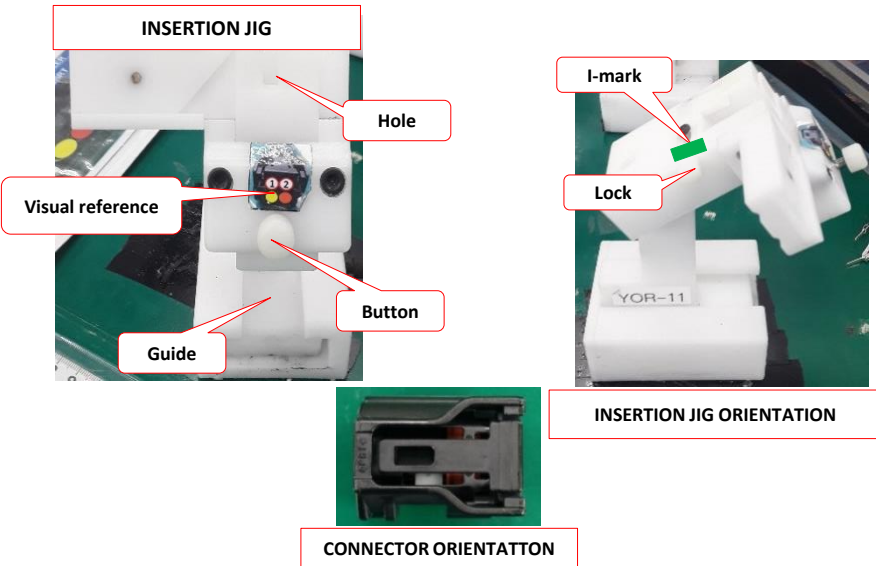
1. Assy parts

2. Black corrugated tube (no slit) $\varnothing 7$ L= 156 \pm 3mm3. Black corrugated tube (no slit) $\varnothing 5$ L= 158 \pm 3mm

4. Connector 6189-1161 (B)

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black corrugated tube (no slit) $\varnothing 7$ L= 156 \pm 3mm (1ST) $\varnothing 5$ L= 158 \pm 3mm (2ND)	 <div>1. Hold the wires using left hand. Get the Corrugated tube (no slit) $\varnothing 7$ L=156\pm3mm using right hand then insert then Y-OR wires using left hand.</div> <div>2. Hold the wires using left hand. Get the Corrugated tube (no slit) $\varnothing 5$ L=158\pm3mm using right hand then insert then Y-OR wires using left hand.</div>	n/a	1. No wrong use of parts 2. No deformed terminal
5	P1 Connector setting to insertion jig 6189-1161 (B)		n/a	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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☐ PRE-LAUNCH

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PARTS:

n/a

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

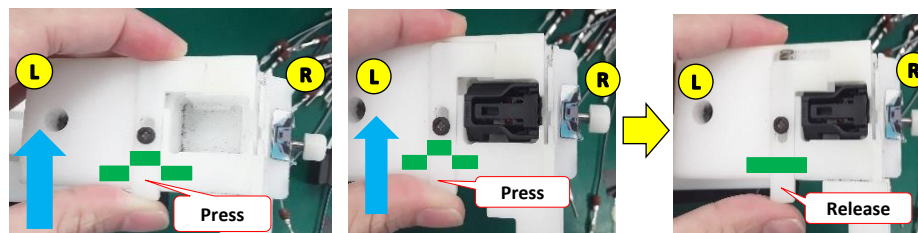
TOOLS/PPE

QUALITY POINTERS

5

P1

Connector setting to
insertion jig
6189-1161 (B)
(Continuation)



1. Press the lock using left thumb.

2. Get the connector **6189-1161 (B)** using right hand and insert to insertion jig. Release the lock after insertion.
Note: Follow the connector orientation.



3. Push the lower wire guide upward using right hand. Slot for **Yellow wire** will be opened.

n/a

CONNECTOR ORIENTATION ILLUSTRATION



1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

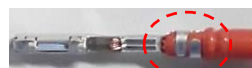
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

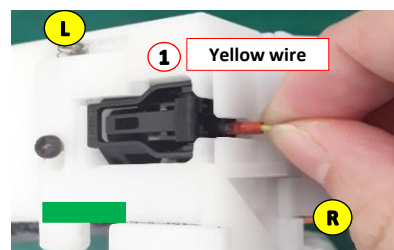
1 QUALITY POINTERS

6

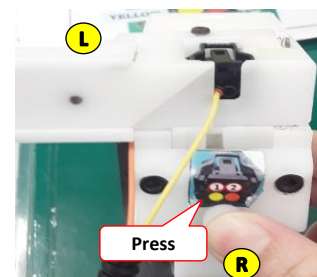
P1

Wire insertion to
connector
6189-1161 (B)

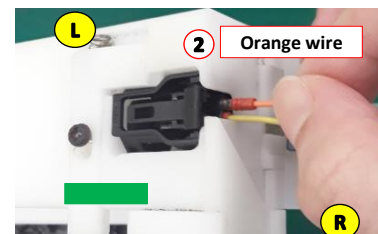
WIRE FACING



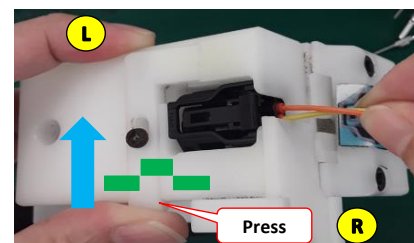
1. Hold the insertion jig using left hand.
Get the **Yellow wire** then insert to terminal
slot **1** using right hand.



2. Press the button using right thumb. The
slot for **Orange wire** will be opened.



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



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.

n/a

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

5.

Important reminders/Note/s:

- 1. Please hold the wire near terminal.**
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.**

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Locking jig

NO.

PROCESS NAME

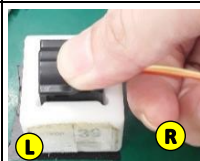
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

1 QUALITY POINTERS

7

Connector lock



1. Put the connector into locking jig and push down **2x** using both hands. Check the connector lock if properly locked.



Before pressing



After Pressing



LOCKING JIG



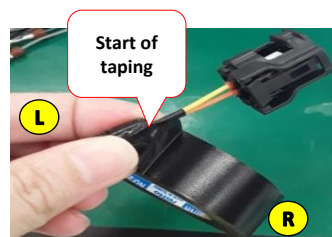
Important reminders/Note/s:
1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR

1. No unlock/half-locked connector
2. No damaged lock

8

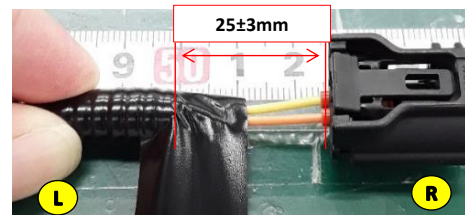
P1

Taping 1
COT to wire near
connector



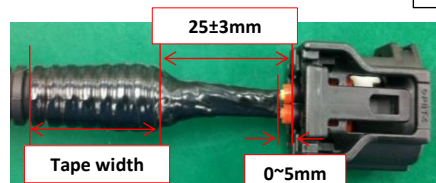
Start of
taping

1. Hold the assy parts using left hand, get **Black tape** then conduct pre-taping using both hands.



25±3mm

2. Hold the assy parts using left hand and measure from COT to connector **25±3mm** using both hands. Continue taping process using both hands.



25±3mm

Tape width

0~5mm

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

MEASURING TAPE



Important reminders/Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

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

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PARTS:

1. Assy parts
2. Black tape

3. MRSW CP TVSSf 0.3 wires G-B/W L=678±3mm with inserted Black sunprene tube ø5 L=135±3mm

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

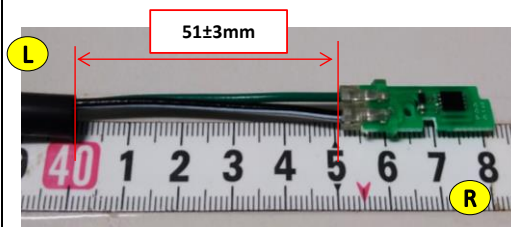
TOOLS/PPE

1 QUALITY POINTERS

9

P1

Taping 2
Black sunprene tube to
wire near hotmelted wires



1. Get the assy parts **G-B/W wires** with sunprene tube then measure from end of the sunprene tube up to the edge of hotmelt **51±3mm** using both hands.

Start of taping

L

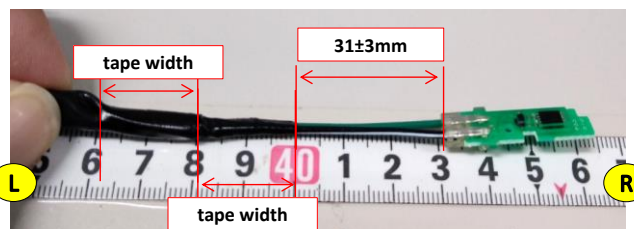
R

2. Hold the sunprene tube using left hand, get the **Black tape** using right hand and begin taping process using both hands.

MEASURING TAPE



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



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

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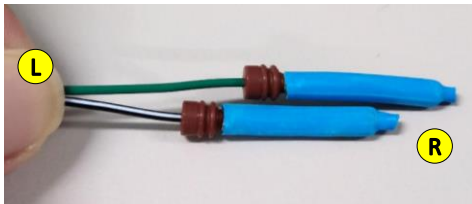

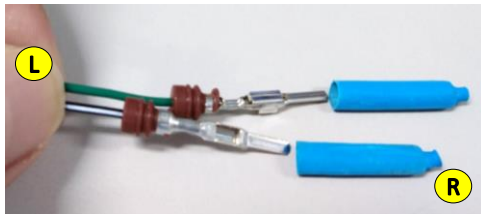

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PARTS:

1. Assy parts
2. Black Corrugated tube (no slit) $\phi 7$ L=326 \pm 3mm

JIG

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1 Wire insertion to Black Corrugated tube (no slit) $\phi 7$ L=326 \pm 3mm	 <p>1. Get the terminal cover jig using right hand then insert to both terminals (G-B/W wires) using right hand.</p>  <p>2. Get the corrugated tube $\phi 7$ L=326\pm3mm using right hand then insert the G-B/W wires using left hand.</p>  <p>3. After insertion, remove the cover jig using right hand.</p>	 <p>TERMINAL COVER JIG</p>	<ol style="list-style-type: none">1. No wrong usage of parts2. No damaged rubber seal

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PARTS:

1. Assy parts

JIG

n/a



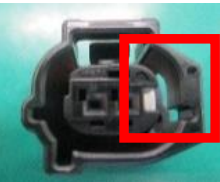
QUALITY CHECKPOINTS

P1

7L0031-7024



GOOD



NO GOOD



TAPE WIDTH * 31±3 mm
VT TO PCB

① No **WRONG INSERT**
No **UNLOCKED/HALFLOCKED**
NO **TBO**

② No **Missing tape**

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