

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 01, 2021

Product Name/Code:

890B / 7L0100-7020

Customer:

TRQSS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

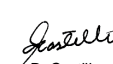

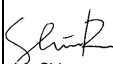

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PARTS:		1. Connector 6189-0451 (W) 2. TVSSf 0.3 GR L=565±3mm				3. TVSSf 0.3 B/W L=565±3mm		JIG:	1. Insertion jig with switch cover				
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS			
1		P1 Connector setting to insertion jig 6189-0451 (W)		<div><div>INSERTION JIG WITH SWITCH COVER</div><div><div><div>Insertion jig</div><div>B/W wire</div><div>Switch cover</div><div>Wire guide</div><div>Holes</div><div>Wire guide</div><div>Button</div><div>GR wire</div></div><div>Connector orientation</div><div>Wire facing</div></div><div><div>L</div><div>Press</div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div>L</div><div>Press</div><div>2. Insert the connector 6189-0451 (W) into jig using right hand and release the lock.</div></div><div><div>L</div><div>Release</div></div><div><div>R</div><div>3. Push the guide using right hand. The slot for B/W wire will be opened.</div></div></div>				<div><div>Safety Instruction</div><div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>		<div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div><div><div>I-mark is NOT align</div><div>1 hole is open</div><div>NG</div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector</div></div>			
Revision History													
07/01/21	2	Remove validity date and add tape quantity.				D. Castillo	C. Villanueva	A. Shimamura	A. Arañes	Prepared by:	Reviewed by:	Approved by:	Noted by:
11/27/20	1	Change connector color in accordance with color standardization for plastic parts. Change from 2x pulling to Pull-Push-Pull-Push insertion quality pointers. Remove cycle time.				D. Castillo	R. Peñaloza	A. Shimamura	A. Arañes	 D. Castillo	 C. Villanueva	 A. Shimamura	 A. Arañes
08/24/20	0	Initial issue.				D. Castillo	R. Peñaloza	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted	Established Date:		August 24, 2020	

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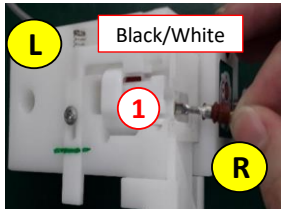
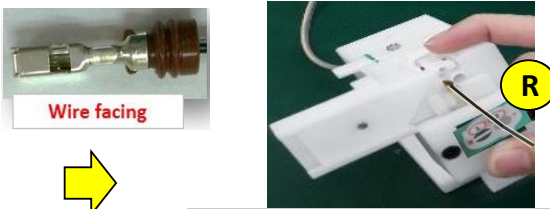
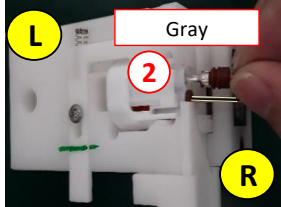

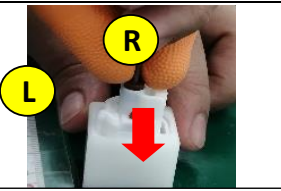
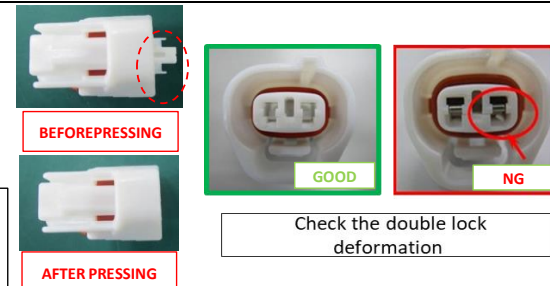

WORK INSTRUCTION TAPING ASSEMBLY PROCESS

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Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	N/A			JIG	1. Insertion jig with switch cover 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div>   </div> <div>   </div>		N/A	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
3		<div>   </div>		<div> LOCKING JIG  </div>	<div> NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK. </div> 1. No half-locked and unlock 2. No lock deformation 3. Use provided jig tool to lock the connector

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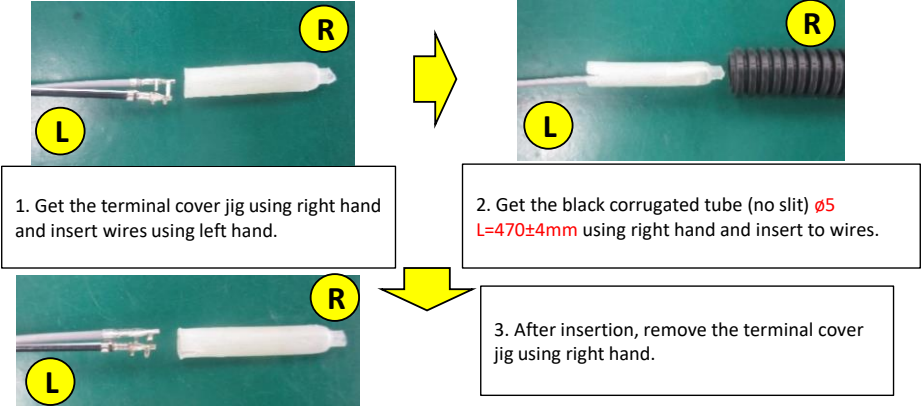

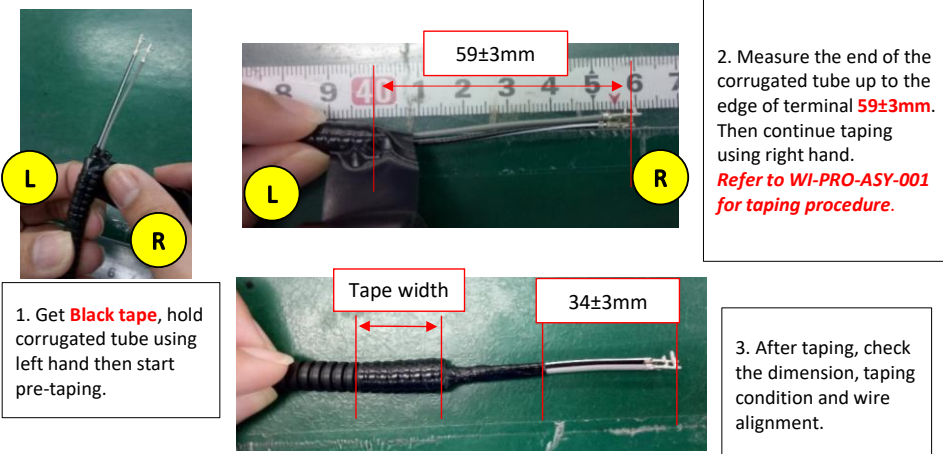

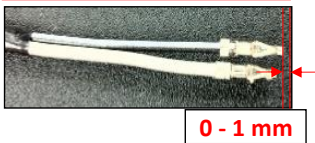
PARTS:

2

1. Black Corrugated tube (No slit) $\phi 5$ L=470 \pm 4mm
2. Black tape [1pc]

JIG

Cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black Corrugated tube (No slit) $\phi 5$ L=470 \pm 4mm	 <p>1. Get the terminal cover jig using right hand and insert wires using left hand.</p> <p>2. Get the black corrugated tube (no slit) $\phi 5$ L=470\pm4mm using right hand and insert to wires.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>		1. No wrong use of parts
5	Taping 1 COT to wire near terminal	 <p>1. Get Black tape, hold corrugated tube using left hand then start pre-taping.</p> <p>2. Measure the end of the corrugated tube up to the edge of terminal 59\pm3mm. Then continue taping using right hand. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>3. After taping, check the dimension, taping condition and wire alignment.</p>	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> 	<ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong dimension5. No missing tape6. No wrong use of tape <p>Wire alignment tolerance</p>  <p>0 - 1 mm</p>

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