



WORK INSTRUCTION

OFFLINE ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: 177D / 7L0127-7020A

Customer:

TRQSS

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

August 30, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-587

Revision No.:

1

Page No.:

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PARTS:

1. Connector 6188-0066 (GR); AVSSf 0.3 wires Y-OR L=364±2mm; Black Corrugated tube (no slit) Ø7 L=25±3mm; Black Corrugated tube ø5 L=286±3mm (no slit)

JIG:

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

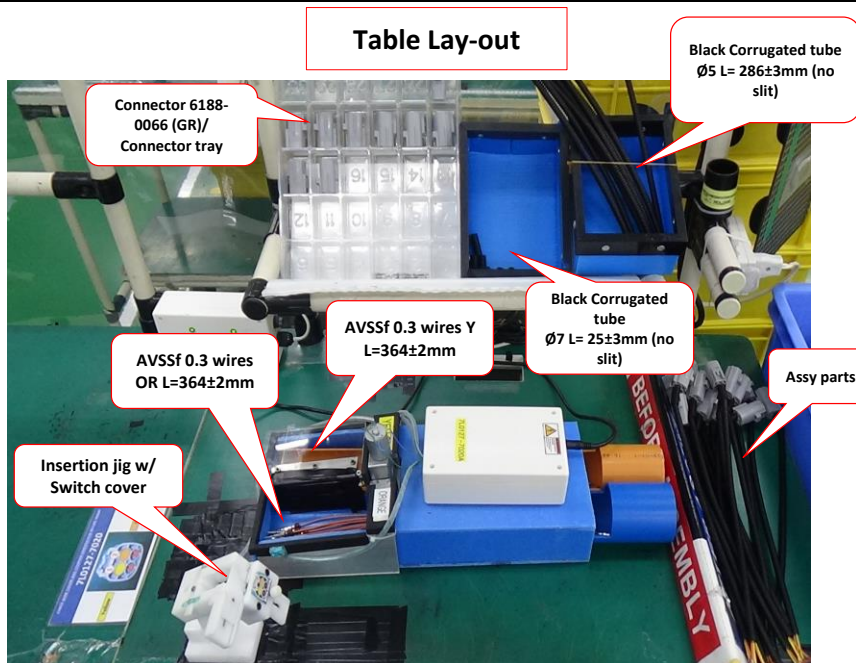
TOOLS/PPE

QUALITY POINTERS

1

n/a

Table Lay-out

**Safety Instruction**

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools

Document references:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

Revision History

Eff. Date	Rev. No	Details of Change	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	Prepared by	Reviewed by	Approved by	Noted by
08/30/22	1	Change from Pre-Launch to Masspro.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
08/26/22	0	Initial Issue. Excluded from WI-ENG-PDE-351A due to process improvement. Additional table lay-out	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	August 26, 2022		

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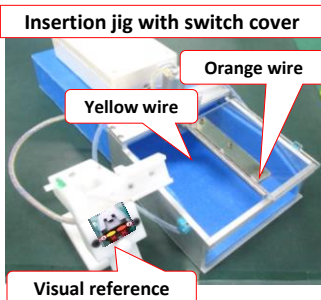
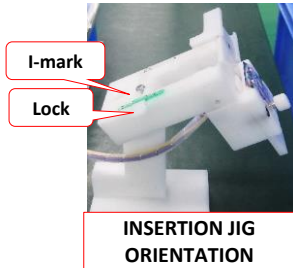

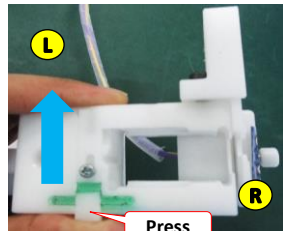
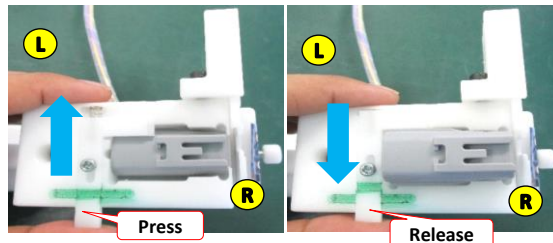
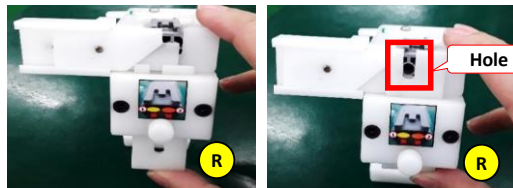
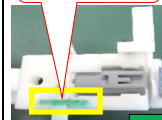

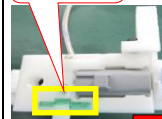
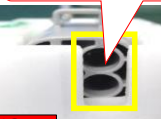
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PARTS:		1. Connector 6188-0066 (GR)		JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a	Connector setting to insertion jig 6188-0066 (GR)	<div><div><p>Insertion jig with switch cover</p></div><div><p>I-mark</p><p>Lock</p></div><div></div><div></div><div><p>1. Press the lock of insertion jig using left thumb.</p></div><div></div><div><p>2. Get the connector 6188-0066 (GR) using right hand and insert to insertion jig. Release the lock after insertion.</p></div><div></div><div><p>3. Push the lower wire guide upward using right thumb. Slot for Yellow wire will be opened.</p></div></div> <div>n/a</div> <div><div><p>CONNECTOR ORIENTATION</p><div><p>I-mark is align</p></div><p>GOOD</p><div><p>1 hole is open</p></div><div><p>I-mark is not align</p></div><p>NG</p><div><p>2 holes are open</p></div></div><p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p><p>Important reminders/Note/s: 1. Follow the connector orientation.</p></div>		

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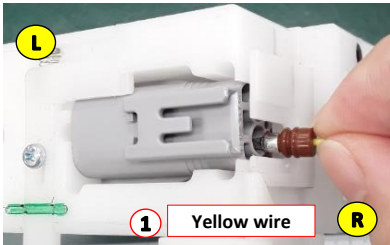
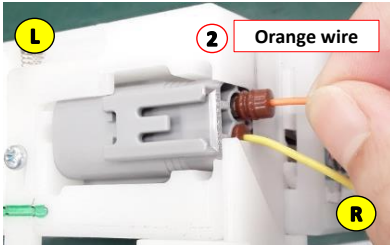
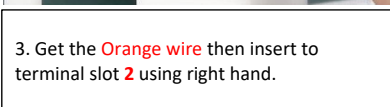
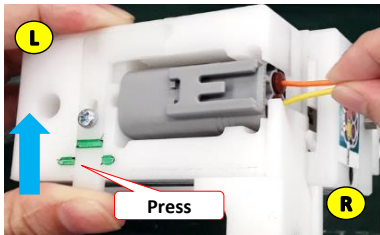
☒ MASSPRO

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PARTS:		1. AVSSf 0.3 wires Y L=364±2mm; OR L=364±2mm		JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	<div><p>WIRE FACING</p></div> <div><p>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for Orange wire will be opened.</p></div> <div><p>3. Get the Orange wire then insert to terminal slot 2 using right hand.</p></div> <div><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></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s 1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</p> <p>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</p>

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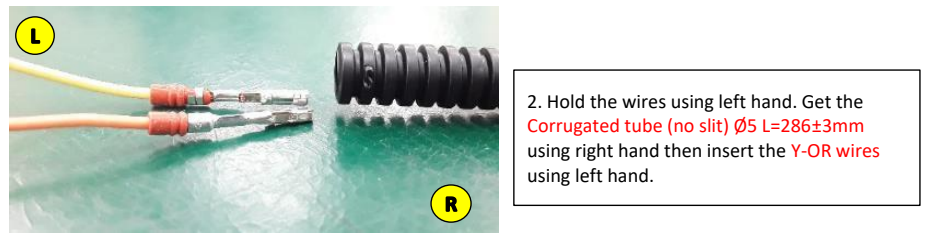
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Black Corrugated tube Ø7 L=25±3mm (no slit) 2. Black Corrugated tube Ø5 L=286±3mm (no slit)		3. Assy parts	JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	Wire insertion to COT (no slit) Ø7 L=25±3mm (1ST) Ø5 L=286±3mm (2ND)	<div></div> <div></div>		n/a	1. No wrong use of parts 2. No deformed terminal

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