

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

March 22, 2021Product Name/Code: **291B / 7L0034-7020**Customer: **TRQSS**

Validity Date:

n/aPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-192A

Revision No.:

2

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1 of 7**PARTS:**

1. Connector 6188-0066 (GR)
2. AVSSf 0.3 wires Y L=842±3mm, OR L=842±3mm

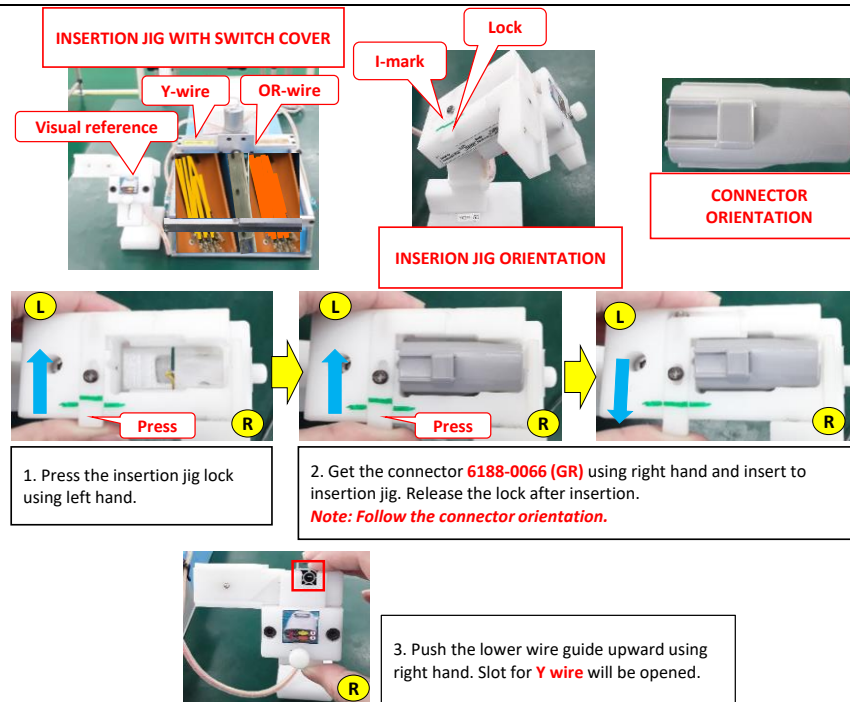
JIG:

1. Insertion jig with switch cover

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

1

P1

Connector setting to
insertion jig
6188-0066 (GR)**Safety Instruction**

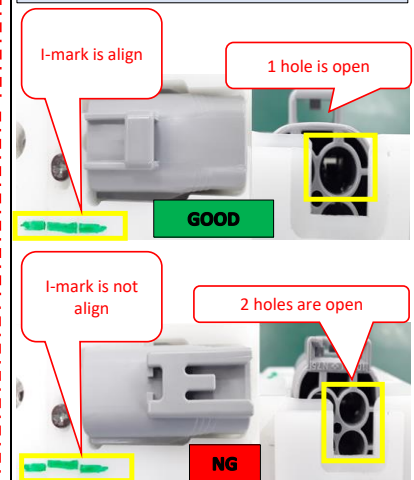
Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

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.

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

03/22/21 2 Apply some improvements.

M. Catapang C. Villanueva A. Shimamura A. Arañes

11/12/20 1 Change process owner from Production (WI-PRO-ASY-046) to Engineering (WI-ENG-PDE-192A), Apply some improvements, include insertion jig, Update pictures.

J. Loterte R. Peñaloza A. Shimamura A. Arañes

Eff. Date Rev. No Details of Change

Revised Checked Approved Noted

Est. Date: July 10, 2017

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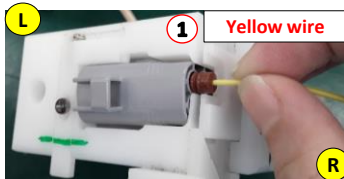
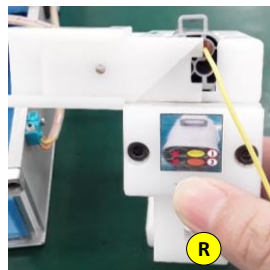
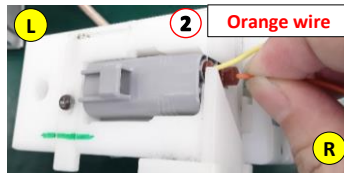

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Product Name/Code:	291B / 7L0034-7020	Customer:	TRQSS
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	n/a			JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to Connector 6188-0066 (GR)	<div><p>WIRE FACING</p></div> <div><p>1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand.</p></div> <div><p>2. Press the button using right thumb. Slot for Orange wire will be opened.</p></div> <div><p>3. Get the Orange wire and insert to connector using right hand.</p></div> <div><p>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.</p></div>	n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div>

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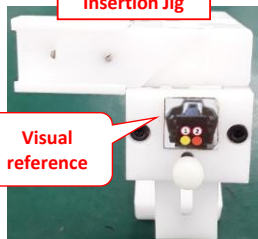
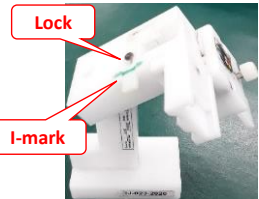


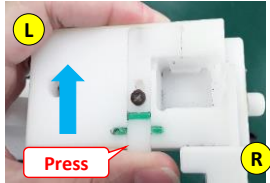
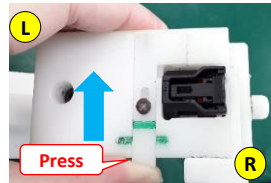
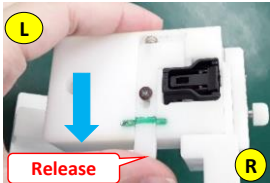


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Process Name/Title: **TAPING ASSEMBLY PROCESS**

Product Name/Code: **291B / 7L0034-7020** Customer: **TRQSS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Black Vinyl tube $\phi 10$ L= 641 \pm 4mm 2. Black Vinyl tube $\phi 5$ L= 166 \pm 3mm 3. Connector 6189-1161 (B) 4. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Black Vinyl tube $\phi 10$ L= 641 \pm 4mm $\phi 5$ L= 166 \pm 3mm	 1. Get the Vinyl tube $\phi 10$ L= 641 \pm 4mm using right hand then insert the Y-OR wires by using left hand.  2. Get the Vinyl tube $\phi 5$ L= 166 \pm 3mm using right hand then insert the Y-OR wires by using left hand.			n/a	1. No wrong use of parts 2. No deformed terminal
4	P1 Connector setting to Insertion jig 6189-1161 (B)	 Visual reference  Lock  INSERTION JIG ORIENTATION  CONNECTOR ORIENTATION  Press 1. Press the insertion jig lock using left hand.  Press 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.  Release			n/a	<div>CONNECTOR ORIENTATION ILLUSTRATION</div>  GOOD  NG 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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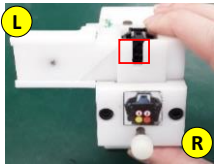
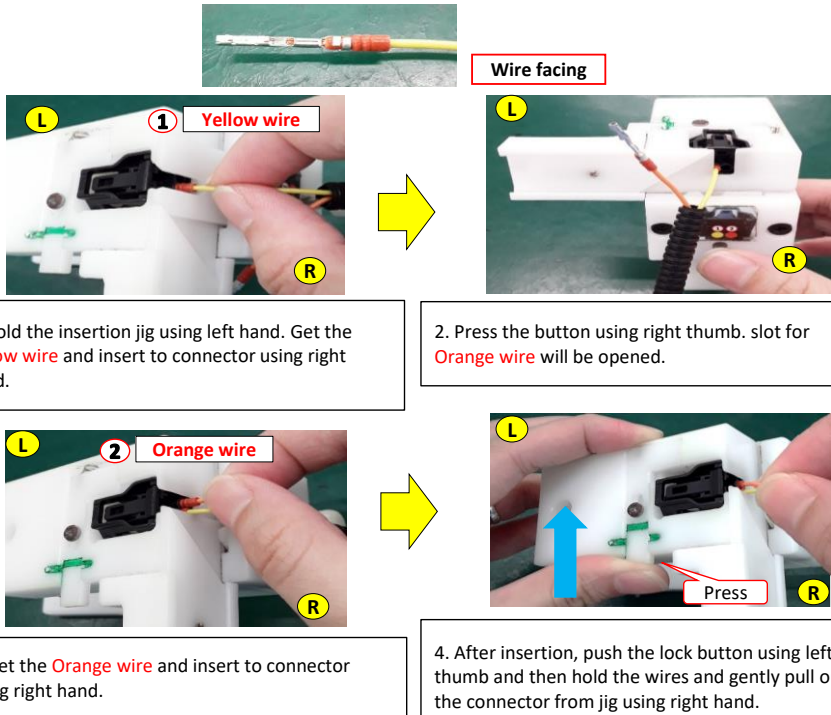
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Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Connector setting to Insertion jig 6189-1161 (B) (continuation)	 <p>3. Push the lower wire guide upward using right hand. Slot for Y wire will be opened.</p>		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
5	Wire insertion to connector 6189-1161 (B)	<p>P1</p>  <p>1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand.</p> <p>2. Press the button using right thumb. slot for Orange wire will be opened.</p> <p>3. Get the Orange wire and insert to connector using right hand.</p> <p>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.</p>		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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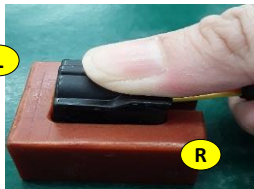







PARTS:

1. MRSW CP A7475-7L00340 (Hot melted wires AVSSf 0.3 GR L=1016mm, B/W L=1016mm)

2. Black Vinyl tube $\phi 10$ L= 300 \pm 3mm

JIG

1. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Connector lock	<div><div>1. Put the connector into locking jig using right hand then press 2x using both hands. Check the connector lock if properly locked.</div><div><div>Before Pressing After Pressing</div><div><div>Unlock Condition Half lock Condition Full lock Condition</div></div></div></div>	<div>Locking Jig</div> 	<div>Note: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK.</div> <div>1. No unlock/Half-locked connector 2. No damaged lock</div>
7	PCB insertion to Vinyl tube $\phi 10$ L= 300 \pm 3mm	<div><div>1. Get the hotmelted wires MRSW CP A7475-7L00340 (GR and B/W) using left hand then get the Vinyl tube $\phi 10$ L= 300\pm3mm using right hand and insert the PCB using left hand.</div></div>	n/a	1. No wrong use of parts

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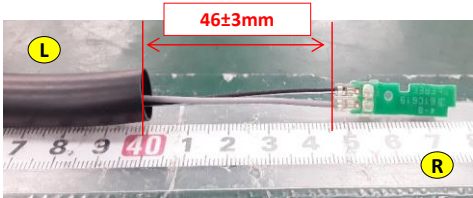
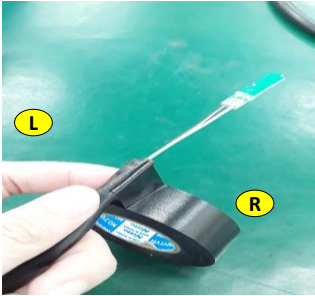
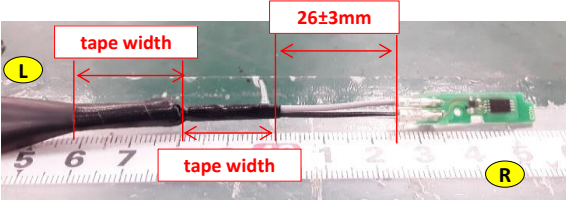

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Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Assy parts 2. Black tape			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
8	P1 2 Taping Vinyl tube to wire near PCB	 <p>1. Measure from Vinyl tube to edge of PCB 46±3mm using both hands.</p>  <p>2. Hold the Vinyl tube using left hand, get Black tape using right hand and start taping process using both hands. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>3. After taping, check the measurement and taping condition.</p>			<p>Measuring tape</p>  <p>2</p>	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape

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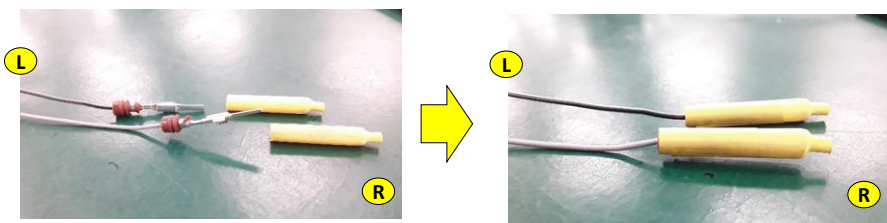
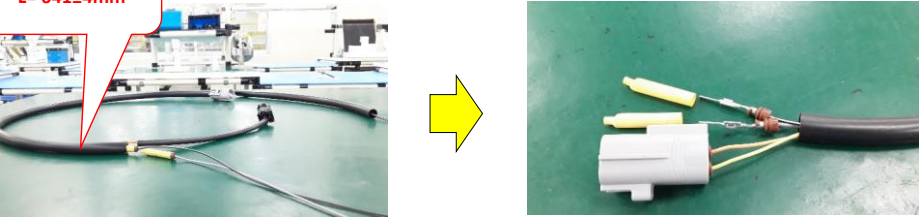


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Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Assy parts		JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Wire insertion to assy parts	<div><p>1. Get the terminal cover jig using right hand then insert the GR-B/W wires using left hand.</p></div> <div><p>Vinyl tube $\phi 10$ L= 641\pm4mm</p><p>2. Get the assy parts using left hand. Insert the wires on Vinyl tube $\phi 10$ L= 641\pm4mm using right hand. Remove the terminal cover jig after insertion.</p></div> <div></div>		Terminal cover jig 	1. No wrong insertion 2. No damaged rubber seal 3. No deformed terminal 4. No exposed rubber seal

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