

	WORK INSTRUCTION				Effectivity Date: July 7, 2021	
	TAPING ASSEMBLY PROCESS				Validity Date: n/a	
	Process Name/Title:		Product Name/Code: 241B / 7L0048-7021		Customer: TRQSS	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-217A		Revision No.: 4	
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PARTS:	1. Black Corrugated tube $\phi 7$, L=314 \pm 3mm (no slit) 2. Black Corrugated tube $\phi 7$, L=61 \pm 3mm (no slit) 3. A7475-7L00480-7040 MRSW CP (TVSSf 0.3 wires GR L=571mm; B/W L=571mm with inserted Black Sunprene tube $\phi 5$, L=106 \pm 3mm)	JIG:	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Wire insertion to Corrugated tube Black Corrugated tube $\phi 7$, L=314 \pm 3mm (no slit) $\phi 7$, L=61 \pm 3mm (no slit)	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> L R </div> <div style="border: 1px solid black; padding: 5px; width: 150px;"> 1. Get the terminal cover jig using right hand then insert to both terminals of GR and B/W wires. </div> </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> L R </div> <div style="border: 1px solid black; padding: 5px; width: 150px;"> 2. Get the corrugated tube $\phi 7$, L=314\pm3mm using right hand then insert the GR and B/W wires using left hand. </div> </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> L R </div> <div style="border: 1px solid black; padding: 5px; width: 150px;"> 3. Get the corrugated tube $\phi 7$, L=61\pm3mm using right hand then insert the GR and B/W wires using left hand. </div> </div> <div style="text-align: center; margin-top: 10px;"> <div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid red; padding: 2px; color: red;">$\phi 7$ L=314\pm3mm</div> <div style="border: 1px solid red; padding: 2px; color: red;">$\phi 7$ L=61\pm3mm</div> </div> </div>		



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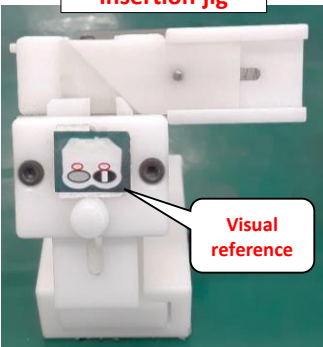
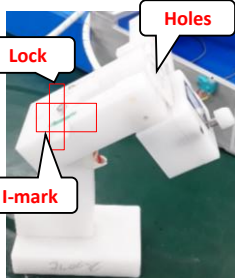

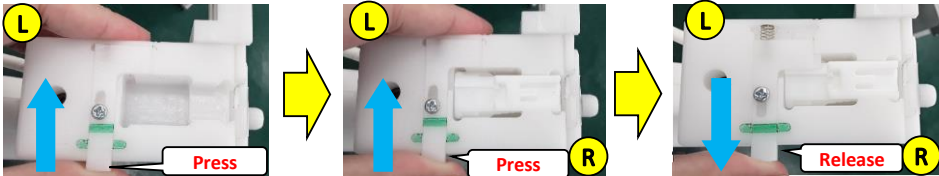


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PARTS:

1. Connector 6188-0407 (W)

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Connector P1	<p>Insertion jig</p>    <p>Visual reference</p> <p>Lock</p> <p>Holes</p> <p>I-mark</p> <p>Connector orientation</p>  <p>Press (L)</p> <p>Press (R)</p> <p>Release (R)</p> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></p> <p>3. Press the lower wire guide using right thumb. Terminal 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 the provided jig per model 2. No wrong orientation of connector</p>

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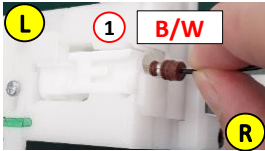
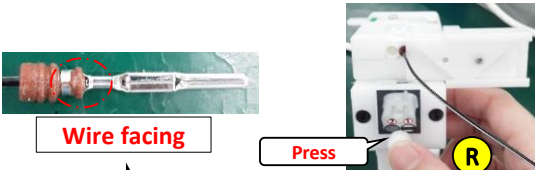
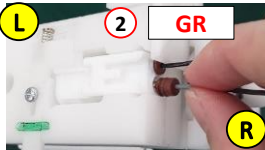





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PARTS:	1. Assy parts 1			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire Insertion to connector 6188-0407 (W)	<div><div></div><div></div><div></div><div></div><div><p>1. Get Black and white wire then insert to terminal slot ① using right hand.</p><p>2. Push the button after insertion. Slot for Gray wire will be open.</p><p>3. Get Gray 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></div></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>
4	Connector	<div></div> <div><p>1. Put the connector into locking jig using right hand then press 2x to lock. Check the condition of lock after pressing.</p></div> <div><div><p>Coupler Cross Sectional View</p><div><div>NG</div><div>NG</div><div>GOOD</div></div><div><div>Unlock Condition</div><div>Half Lock Condition</div><div>Full Lock Condition</div></div></div><div></div><div><div>Before lock</div><div>After lock</div></div></div>		<div>LOCKING JIG</div> 	<div>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK</div> <div>1. Use the provided locking per model 2. No unlock/half-locked connector</div>

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PARTS:

1. Connector 6098-3802 (W)

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Connector P1	<p>Insertion jig</p> <p>Insertion jig Orientation</p> <p>Connector Orientation</p> <p>Connector Orientation Illustration</p> <p>I-mark is align 2 Holes are open GOOD</p> <p>I-mark is not align All holes are open NG</p> <p>1. Use the provided jig per model 2. No wrong orientation of connector</p>	n/a	

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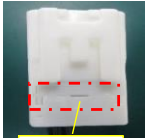




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PARTS:		1. AVSSf 0.3 wires B L=551mm [2pcs]			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	Wire insertion to connector 6098-3802 (W)	<div><div><p>Wire facing</p></div><div><p>1. Get Black wire then insert to terminal slot ① using right hand. Insertion sequence must be from left to right.</p></div><div><p>3. Get Black wire then insert to terminal slot ② using right hand.</p></div><div><p>3. 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></div>		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.
7		Connector	<div><p>LOCKING JIG</p></div> <div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div> <div><p>Before pressing</p></div> <div><p>After pressing</p></div> <p>1. Put the connector into locking jig using right hand then press to lock 2x. <i>Refer to GL-PRO-ASY-017 for verification of lock.</i></p>		LOCKING JIG 	NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK 1. No unlock/half-locked connector

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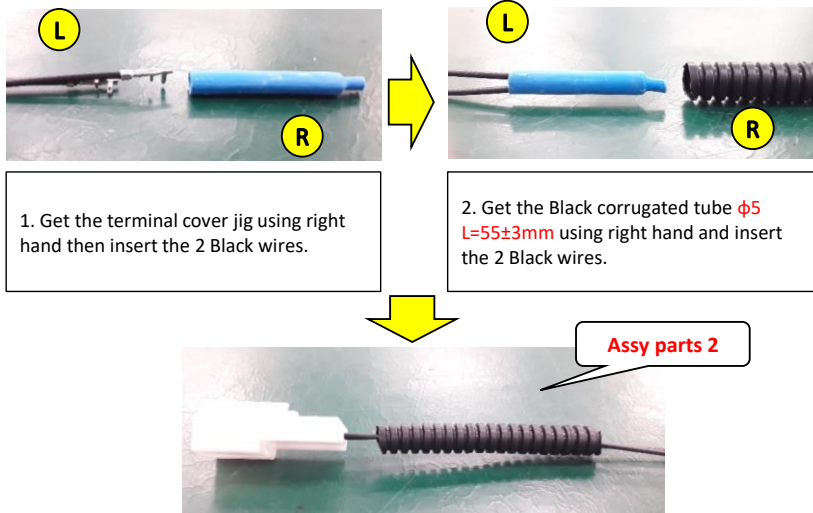

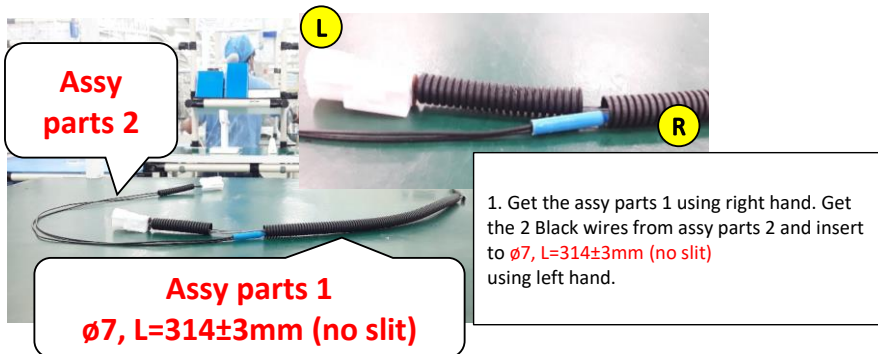

PARTS:

1. Black Corrugated tube $\phi 5$ L=55 \pm 3mm (no slit)
2. Assy parts 1 (GR and B/W wire w/ 2 inserted COT $\phi 7$, L=314 \pm 3mm (no slit) $\phi 7$, L=61 \pm 3mm (no slit) and connector 6188-0407 (W)

3. Assy parts 2 (2 Black wires w/ inserted connector 6098-3802 (W) and COT $\phi 5$ L=55 \pm 3mm (no slit)

JIG

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	Wire insertion to COT $\phi 5$ L=55 \pm 3mm (no slit)	 <p>1. Get the terminal cover jig using right hand then insert the 2 Black wires.</p> <p>2. Get the Black corrugated tube $\phi 5$ L=55\pm3mm using right hand and insert the 2 Black wires.</p> <p>Assy parts 2</p>	<p>TERMINAL COVER JIG</p> 	<p>Use terminal cover jig to avoid deformed terminal</p> <p>1. No wrong use of parts 2. No deformed terminal</p>
9	Wire	 <p>Assy parts 2</p> <p>Assy parts 1 $\phi 7$, L=314\pm3mm (no slit)</p> <p>1. Get the assy parts 1 using right hand. Get the 2 Black wires from assy parts 2 and insert to $\phi 7$, L=314\pm3mm (no slit) using left hand.</p>	<p>TERMINAL COVER JIG</p> 	<p>Use terminal cover jig to avoid deformed terminal</p> <p>1. No wrong insert to assy 2. No deformed terminal</p>

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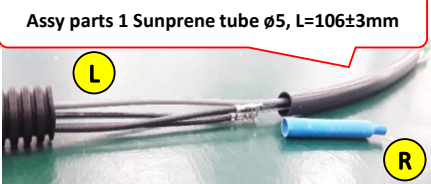

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PARTS:	1. Assy parts 1 and 2				JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	Wire insertion to assy parts 1 (continuation)	<div><div><p>2. Remove the terminal cover jig using right hand after insertion to COT.</p></div><div><p>Assy parts 1 Sunprene tube $\phi 5$, L=106\pm3mm</p><p>3. Hold the 2 Black wires and insert to Sunprene tube of assy parts 1 $\phi 5$, L=106\pm3mm using left hand.</p></div></div> <div></div>			Use terminal cover jig to avoid deformed terminal
					1. No wrong insertion to assy 2. No deformed terminal	

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