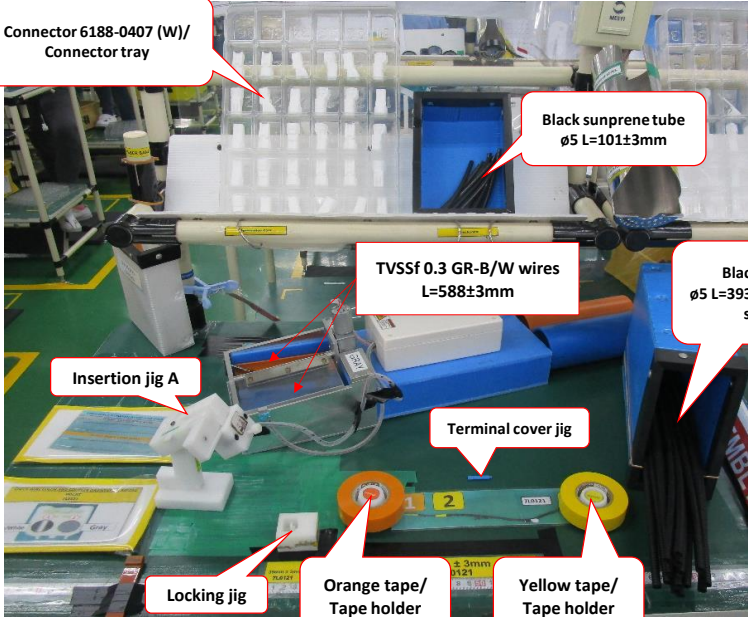




	WORK INSTRUCTION		Effectivity Date:	December 16, 2021	
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	Model Code/Part Number: 102D / 2 7L0121-7023	Customer: TRQSS	Document No.:	WI-ENG-PDE-244A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	2	Page No.:

PARTS: 2 1. All parts: Connector 6188-0407 (W); TVSSf 0.3 GR-B/W wires L=588±3mm; Black sunprene tube ø5 L=101±3mm; Black COT ø5 L=393±3mm (no slit); Yellow tape [1pc.]; Orange tape [1pc.]		JIG: 1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P1 2 Table Lay-out	<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>
		QUALITY POINTERS 2 <i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i> 1. No missing parts/tools 2. No excess parts/tools	

Revision History							Prepared by	Reviewed by	Approved by	Noted by
12/16/21	2	Change part number from 7L0121-7022 to 7L0121-7023 due to additional quantity of clamp (82711-52090 (W)) (Refer to WI-ENG-PDE-244B). Additional table lay-out, checkpoint in checking of wire tolerance (Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance); Additional quality pointers in Pull-push-pull push procedure (Refer to GL-PRO-ASY-029 for Pull-Push procedure)	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
03/31/21	1	Change part number from 7L0121-7021A to 7L0121-7022 due to change of wire insertion sequence.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
03/08/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	March 08, 2021		

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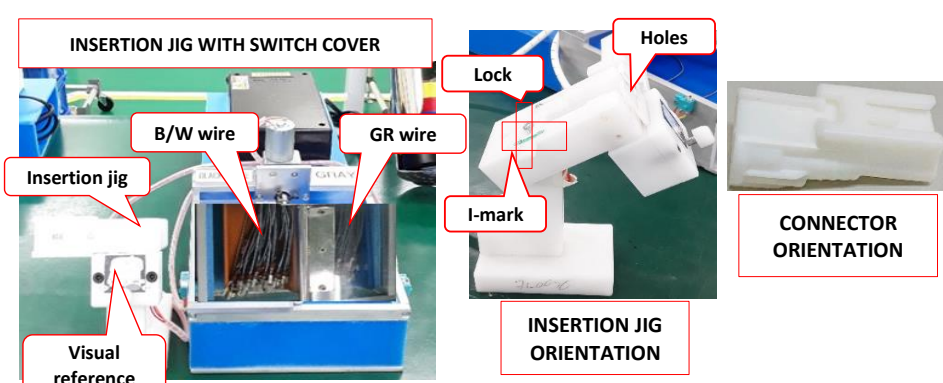
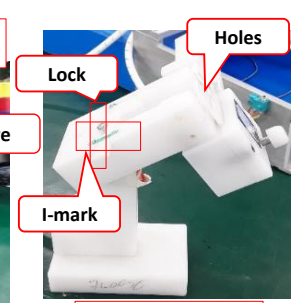
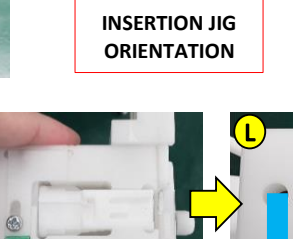
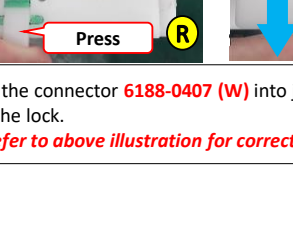
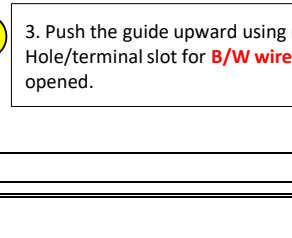
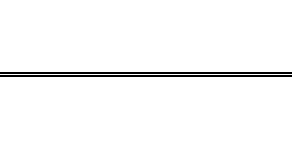
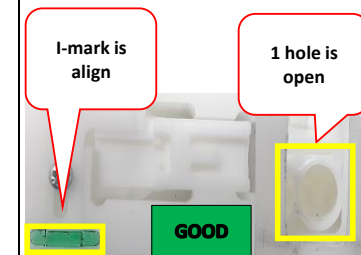
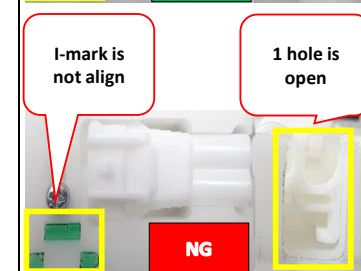
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PARTS:		1. Connector 6188-0407 (W)		JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<p>Connector setting to insertion jig 6188-0407 (W)</p>  <p>Visual reference</p>  <p>CONNECTOR ORIENTATION</p>  <p>INSERTION JIG ORIENTATION</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.</p> <p><i>Note: Refer to above illustration for correct setting.</i></p>  <p>3. Push the guide upward using right hand. Hole/terminal slot for B/W wire will be opened.</p> <p>Guide lock</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 3. No wrong use of connector 4. No damaged connector</p>

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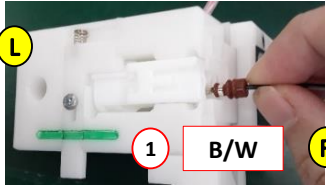

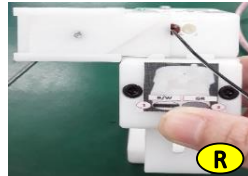
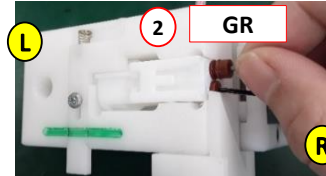
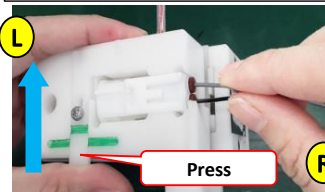
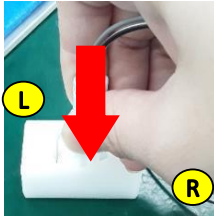




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PARTS:	2. TVSSf 0.3 GR-B/W wires L=588±3mm			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to connector 6188-0407 (W) P1	<div><p>1. Get the B/W wire then insert to terminal slot 1 using right hand.</p></div> <div><p>WIRE FACING</p></div> <div><p>2. Push the button after insertion. Hole for GR wire will be opened.</p></div> <div><p>3. Get the GR wire then insert to terminal slot 2 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	<p>2 <i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p> <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>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>2 <i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p>
4	Connector lock	<div><p>1. Put the connector into locking jig using right hand then press 2x to lock using both hands. Check the lock if properly locked.</p></div> <div><p>Coupler Cross Sectional View</p><p>NG NG GOOD</p><p>Unlock Condition Half Lock Condition Full Lock Condition</p></div> <div><p>Before lock</p></div> <div><p>After lock</p></div>		<p>LOCKING JIG</p> 	<p>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damaged lock</p>

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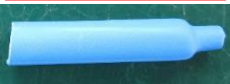

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PARTS:	1. Assy parts 2. Black corrugated tube (no slit) Ø5 L=393±3mm (no slit) 3. Black sunprene tube Ø5 L=101±3mm			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Wire Insertion to Black Corrugated tube Ø5 L=393±3mm (no slit)	<div>  <p>1. Get the terminal cover jig using right hand then insert the B/W-GR wires using left hand.</p> </div> <div>  <p>2. Get the corrugated tube (no slit) Ø5 L=393±3mm using right hand and then insert the B/W-GR wires using left hand.</p> </div> <div>  <p>3. After insertion, remove the terminal cover jig using right hand.</p> </div>		<div> TERMINAL COVER JIG  </div>	1. No wrong use of parts 2. No deformed terminal
6	Wire insertion to Black sunprene tube Ø5 L=101±3mm	<div>  <p>1. Get the sunprene tube Ø5 L=101±3mm using right hand then insert the B/W-GR wires using left hand.</p> </div>		n/a	1. No wrong use of parts 2. No deformed terminal

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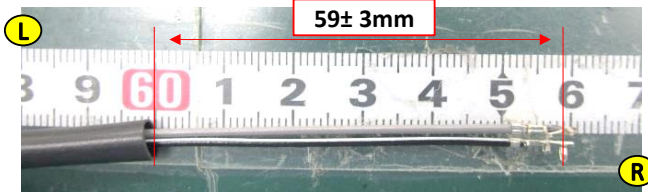
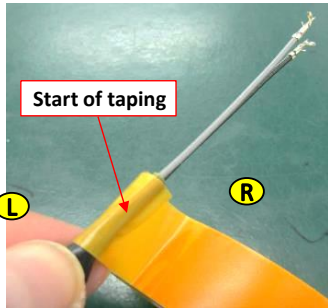
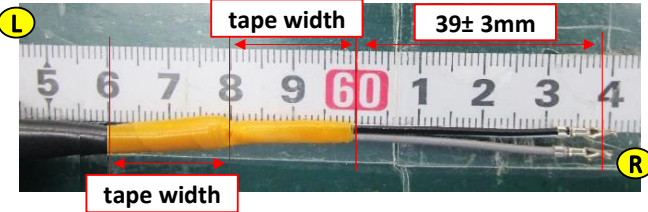

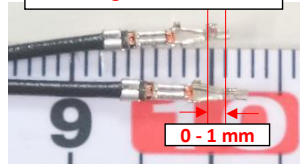
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PARTS:		1. Assy parts 2. Orange tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 Taping 1 Black sunprene tube to wire near terminal	 <p>1. Measure from end of sunprene tube up to end of the terminal pointed tip 59mm using both hands.</p>  <p>Start of taping</p> <p>2. Hold the sunprene tube using left hand, get the Orange tape then start taping process using both hands. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>tape width 39 ± 3mm</p> <p>tape width</p> <p>3. After taping, check the taping condition, measurement and wire alignment.</p>	 <p>MEASURING TAPE</p>	<p>NOTE: USE ORANGE TAPE ONLY.</p>  <p>Wire alignment tolerance</p> <p>0 - 1mm</p> <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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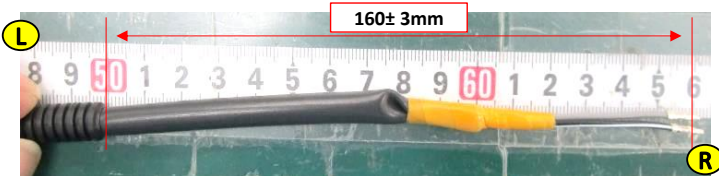
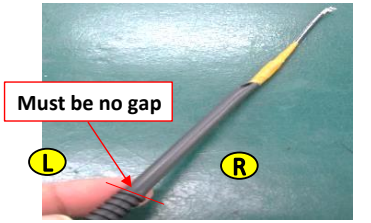
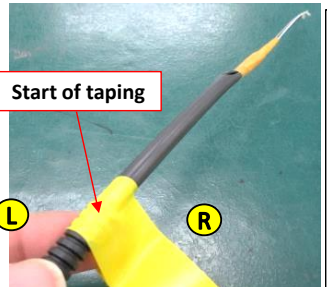
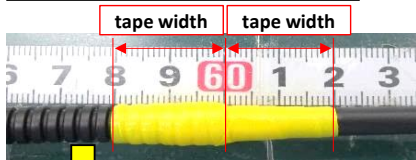


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PARTS:		1. Assy parts 2. Yellow tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1 Taping 2 Black corrugated tube to Black sunprene tube near terminal	 <p>1. Measure from end of corrugated tube up to terminal pointed tip 160mm using both hands.</p>  <p>2. Fix the corrugated tube and sunprene tube using both hands.</p>  <p>3. Hold the corrugated tube and sunprene tube using left hand, get the Yellow tape then start taping process using both hands. Note: Refer to WI-PRO-ASY-001 for taping procedure</p>  <p>4. After taping, check the measurement and taping condition.</p> 		NOTE: USE YELLOW TAPE ONLY. 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension Note: Please use calibrated/verified measuring tape when getting the measurement.

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