

	<b>WORK INSTRUCTION</b>				Effectivity Date:	May 03, 2021	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a	
	Process Name/Title:				Document No.:	WI-ENG-PDE-185A	
	Product Name/Code: <b>480A / A7043E</b>		Customer: <b>TRQSS</b>		Revision No.:	4	Page No.: 1 of 7
Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					

<b>PARTS:</b>	1. Connector 6189-1142 (W)			<b>JIG:</b>	1. Insertion jig with switch cover		
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1  Connector setting to Insertion jig 6189-1142 (W)	<div style="text-align: center;"> </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> </div> <div style="text-align: center;"> </div> <div style="text-align: center;"> </div> <div style="text-align: center;"> </div> <div style="text-align: center;"> </div> <div style="text-align: center;"> </div> </div> <div style="display: flex; justify-content: space-around; margin-top: 10px;"> <div style="text-align: center;"> <p>1. Press the insertion jig lock using left hand.</p> </div> <div style="text-align: center;"> <p>2. Get the connector 6189-1142 (W) using right hand and insert to insertion jig. Release the lock after insertion.</p> </div> <div style="text-align: center;"> <p>3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.</p> </div> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>          Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)       </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Housekeeping</b>          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;"> <b>Alert level</b>          For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.       </div>	<div style="text-align: center; background-color: #e0e0ff; padding: 5px; margin-bottom: 10px;"> <b>CONNECTOR ORIENTATION ILLUSTRATION</b> </div> <div style="text-align: center;"> <p>1 hole is open</p> <div style="display: flex; justify-content: center; align-items: center; gap: 10px;"> </div> </div> <p>1. Use the provided jig per model 2. No wrong orientation of connector</p>

Revision History					Prepared by	Reviewed by	Approved by	Noted by
05/03/21	4	Remove validity date, Put assy parts on pg. 3, 5 and 6 parts section	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes		
10/30/20	3	Transfer process owner from Production (WI-PRO-ASY-11A) to Engineering (WI-ENG-PDE-185A); Apply some improvements; Updated pictures	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes		
07/10/17	0	Initial issue.	J. Monetealto/ L. Briones	O. Merin	T. Sugiyama	n/a	J. Loterte	C. Villanueva
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	July 10, 2017

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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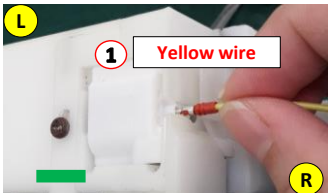
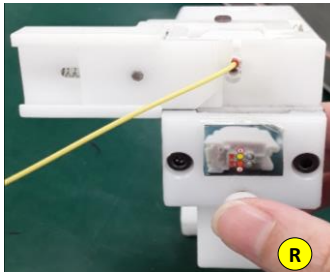
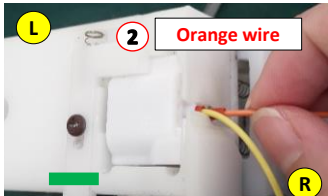
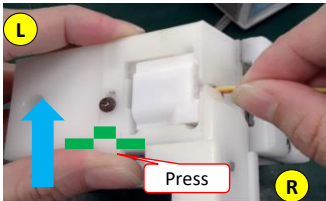
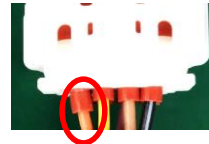
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### PARTS:

1. AVSSf 0.3 wires Y L=473mm, OR L=473mm

### JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Wire Insertion to connector 6189-1142 (W)	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> and insert to terminal slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb. slot for <b>Orange wire</b> will be open.</p></div> <div><p>3. Get the <b>Orange wire</b> and insert to terminal slot 2 using right hand.</p></div> <div><p>4. After insertion, press 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	<div><p>Note: During insertion, hold the wire not <u>rubber seal</u> to prevent sagging.</p></div>  <div><ol style="list-style-type: none"><li>1. No loose insertion</li><li>2. No wrong insertion</li><li>3. One by one insertion</li><li>4. No deformed terminal</li><li>5. No wrong wire facing</li></ol><p>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p></div>

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PROTOTYPE



PRE-LAUNCH



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### PARTS:



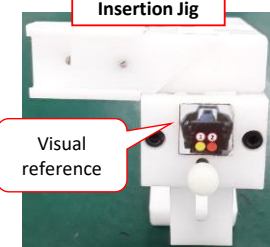
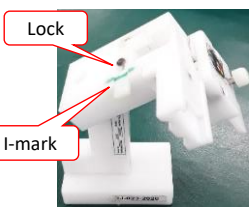

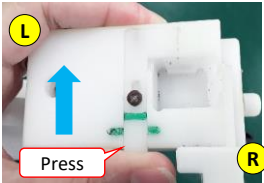
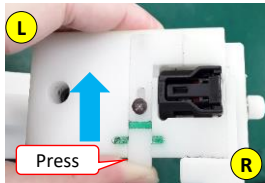

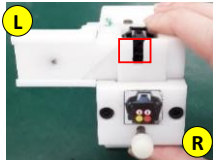


1. Black Corrugated tube  $\phi 7$  L= 48 $\pm$ 3mm (no slit)
2. Black Corrugated tube  $\phi 7$  L= 395 $\pm$ 3mm (no slit)



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 COT $\phi 7$ L= 48 $\pm$ 3mm (no slit) and $\phi 7$ L= 395 $\pm$ 3mm (no slit)	  <ol style="list-style-type: none"><li>1. Get the corrugated tube <math>\phi 7</math> L= 48<math>\pm</math>3mm using right hand then insert the yellow wire and orange wire by using left hand.</li><li>2. Get the corrugated tube <math>\phi 7</math> L= 395<math>\pm</math>3mm using right hand then insert the yellow wire and orange wire by using left hand.</li></ol>	n/a	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No deformed terminal</li></ol>
4	Connector setting to Insertion jig 6189-1161 (B)	      <ol style="list-style-type: none"><li>1. Press the insertion jig lock using left hand.</li><li>2. Get the connector 6189-1161 (B) using right hand and insert to insertion jig. Release the lock after insertion.</li><li>3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.</li></ol>	 <ol style="list-style-type: none"><li>3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.</li></ol>	<h3>CONNECTOR ORIENTATION ILLUSTRATION</h3>   <ol style="list-style-type: none"><li>1. Use the provided jig per model</li><li>2. No wrong orientation of connector</li></ol>

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PROTOTYPE



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### PARTS:

1. Assy parts 1

### JIG

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### QUALITY POINTERS

5

P1

Wire insertion to connector 6189-1161 (B)



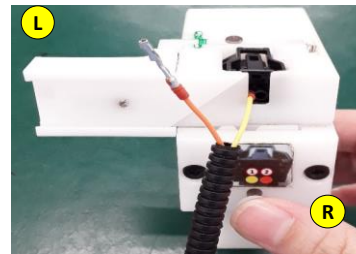
Wire facing



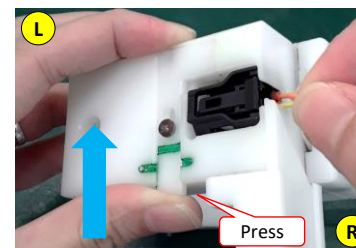
1. Hold the insertion jig using left hand. Get the **Yellow wire** and insert to terminal slot 1 using right hand.



3. Get the **Orange wire** and insert to terminal slot 2 using right hand.



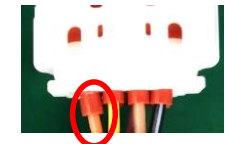
2. Press the button using right thumb. slot for **Orange wire** will be open.



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.

n/a

Note: During insertion, hold the wire not **rubber seal** to prevent sagging.



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. Black Vinyl tube  $\phi 5$  L= 179 $\pm$ 3mm
2. A7475-A7043D1-7040 (GR and B/W wires)

 3. Assy parts**JIG**

1. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Connector lock	      <div>1. Put the connector into locking jig and push down to lock using right thumb.</div>	<b>LOCKING JIG</b> 	<ol style="list-style-type: none"><li>1. No unlock/Half-locked connector</li><li>2. No damaged lock</li></ol>
7	Wire insertion to Vinyl tube $\phi 5$ L= 179 $\pm$ 3mm	 <div>1. Hold the Vinyl tube <math>\phi 5</math> L= 179<math>\pm</math>3mm using left hand. Get the wire A7475-A7043D1-7040 (GR and B/W) and insert to Vinyl tube using right hand.</div>	n/a	<ol style="list-style-type: none"><li>1. No wrong use of parts</li></ol>

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PARTS:

4

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

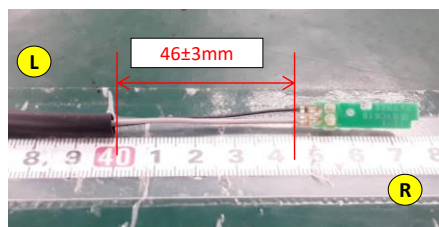
TOOLS/PPE

QUALITY POINTERS

8

P1

Taping  
Vinyl tube to wire near  
PCB



1. Hold the Vinyl tube using left hand. Measure the end of the Vinyl tube up to the edge of Hotmelt 46±3mm using right hand.



2. Hold the vinyl tube using left hand then start taping using right hand.  
*Refer to WI-PRO-ASY-001 for taping procedure.*

MEASURING TAPE



3. After taping, check the measurement and tape condition.

1. No peel-off tape
- 2.No flip out tape
- 3.No loose tape
4. No wrong dimension

*Note:  
Please use calibrated/verified  
measuring tape when getting the  
measurement.*

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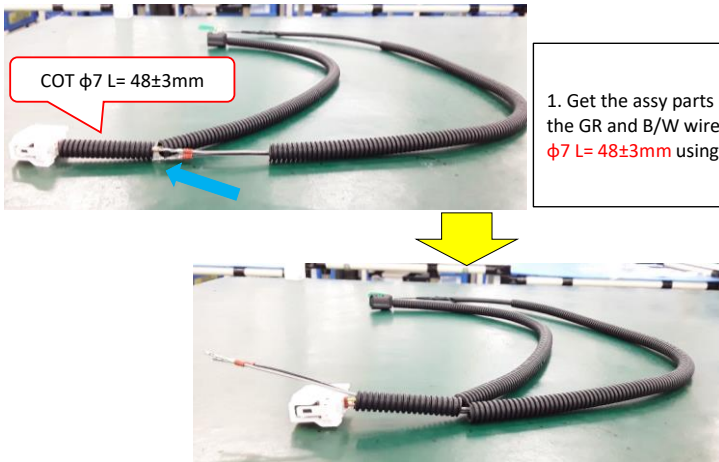
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**PARTS:**

1. Black Corrugated tube  $\phi 7$  L= 427 $\pm$ 3mm (no slit)
2. Assy parts

**JIG**

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	Wire insertion to Black Corrugated tube $\phi 7$ L= 427 $\pm$ 3mm (no slit)	 <div>1. Get the corrugated tube <math>\phi 7</math> L= 427<math>\pm</math>3mm using left hand then insert the wire A7475-A7043D1-7040 (GR and B/W) using right hand.</div>	n/a	1. No wrong use of parts
10	Wire insertion to assy parts	 <div>1. Get the assy parts 1 using left hand. Insert the GR and B/W wire from assy parts 2 in COT <math>\phi 7</math> L= 48<math>\pm</math>3mm using right hand.</div>	n/a	1. No wrong insertion to COT

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