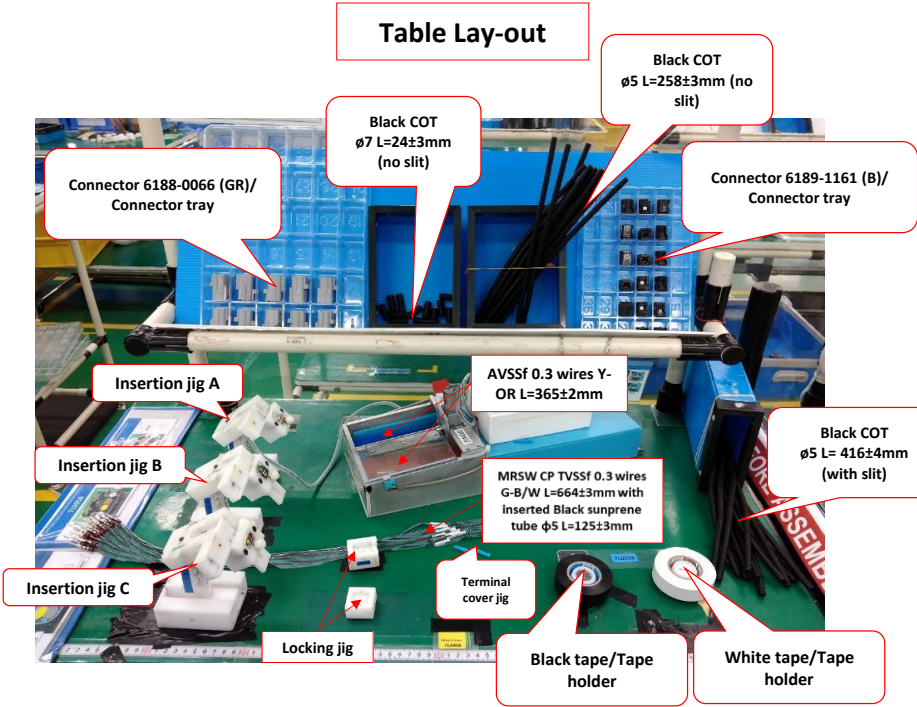



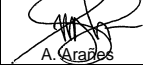
	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date:		March 10, 2023	
	Process Name/Title:				Validity Date:		n/a	
	Model Code/Part Number: <b>150B / 7L0058-7024</b>		Customer: <b>TRQSS</b>		Document No.:		WI-ENG-PDE-400A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 1 of 12

<b>PARTS:</b>		1. All parts: Connector 6188-0066 (GR); Black COT $\phi 7$ L=24 $\pm$ 3mm (no slit); Black COT $\phi 5$ L=258 $\pm$ 3mm (no slit); Connector 6189-1161 (B); AVSSf 0.3 wires Y-OR L=365 $\pm$ 2mm; MRSW CP TVSSf 0.3 wires G-B/W L=664 $\pm$ 3mm with inserted Black VM tube (sunprene) $\phi 5$ L=125 $\pm$ 3mm; Black COT $\phi 5$ L=416 $\pm$ 4mm (with slit); Black tape [1pc.]; White tape [1pc.]		JIG:		1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>1 QUALITY POINTERS</b>			
1	P1	Table Lay-out		<div> <b>Safety Instruction</b>            Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div> <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> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>			
				<b>Document reference/s:</b> 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-PRO-KIT-006 Rev.7 Wire Taping			
				1. No missing parts/tools 2. No excess parts/tools			

Revision History								Prepared by	Reviewed by	Approved by	Noted by
03/10/23	1	Inclusion of quality checkpoints. Improve quality pointers	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	 M. Catapang	 J. Loterte	 C. Villanueva	 A. Arañes	
02/12/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	February 12, 2022

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# WORK INSTRUCTION

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## TAPING ASSEMBLY PROPCESS

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### PARTS:

1. Connector 6188-0066 (GR)

### JIG

1. Insertion jig with switch cover

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

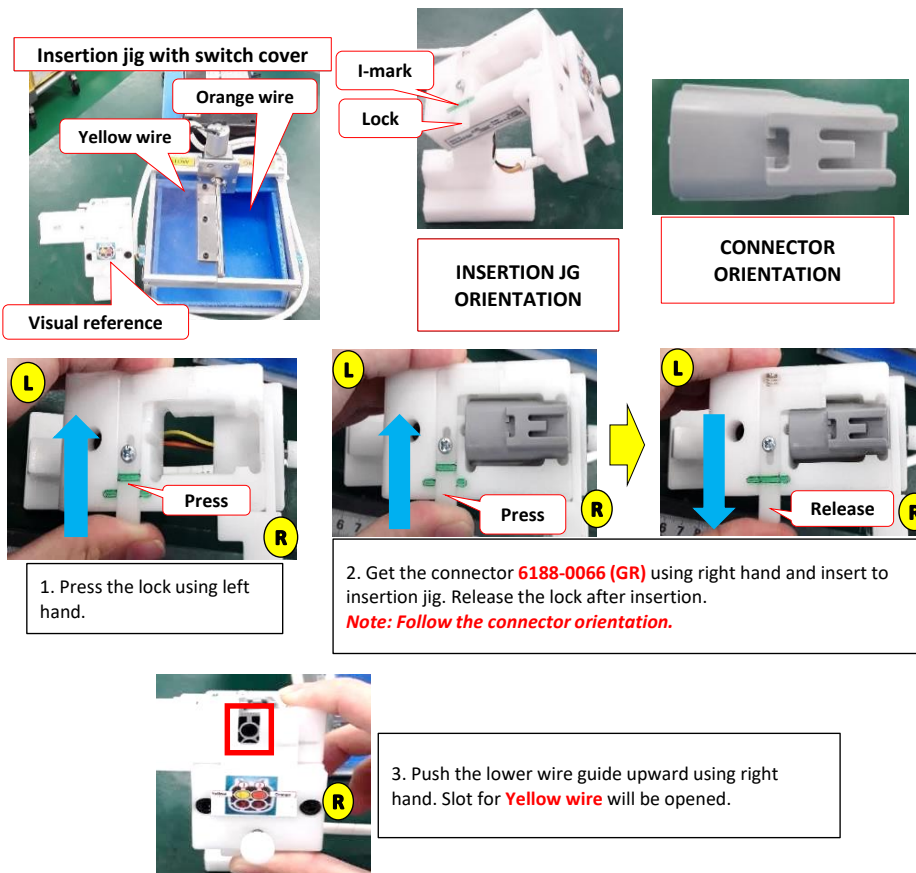
### TOOLS/PPE

### 1 QUALITY POINTERS

2

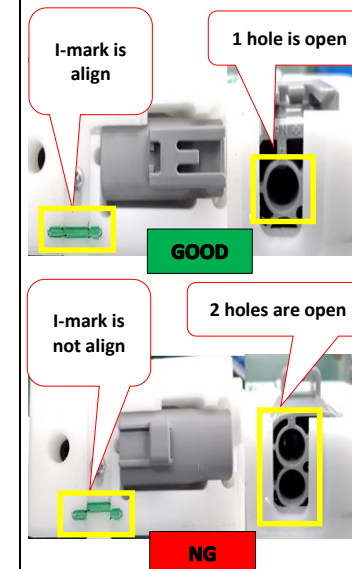
P1

Connector setting to  
insertion jig  
6188-0066 (GR)



n/a

### 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

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### PARTS:

1. AVSSf 0.3 wires Y L=365±2mm; OR L=365±2mm

### JIG

1. Insertion jig with switch cover

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### 1 QUALITY POINTERS

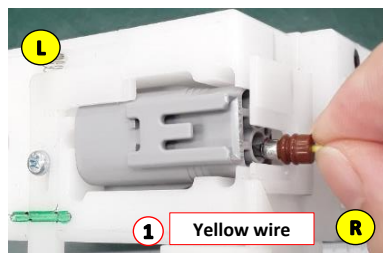
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P1

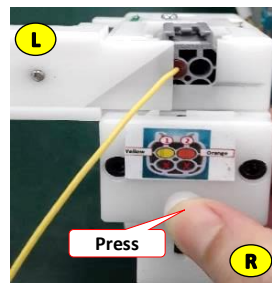
Wire Insertion to connector  
6188-0066 (GR)



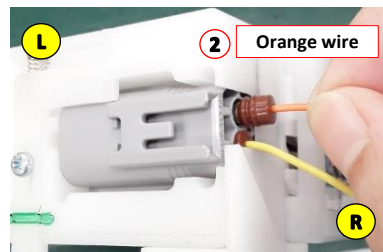
WIRE FACING



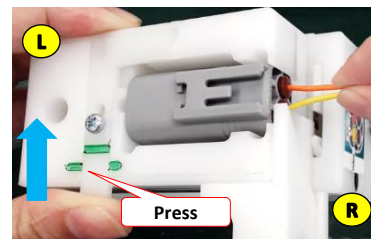
1. Hold the insertion jig using left hand.  
Get the **Yellow wire** then insert to terminal  
slot **1** using right hand.



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



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



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

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deform terminal
5. No wrong wire facing

#### Important reminders/Note/s:

1. Please hold the wire near terminal.
  2. Make sure wires are properly inserted.
- Conduct Pull-Push-Pull-Push after insertion.  
Do not exert extra force.
3. Insertion of wires must be from left to right

#### 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

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**150B / 7L0058-7024**

Customer:

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Document No.:

**WI-ENG-PDE-400A**

Purpose:

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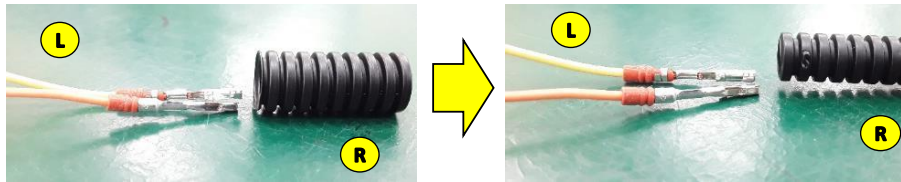
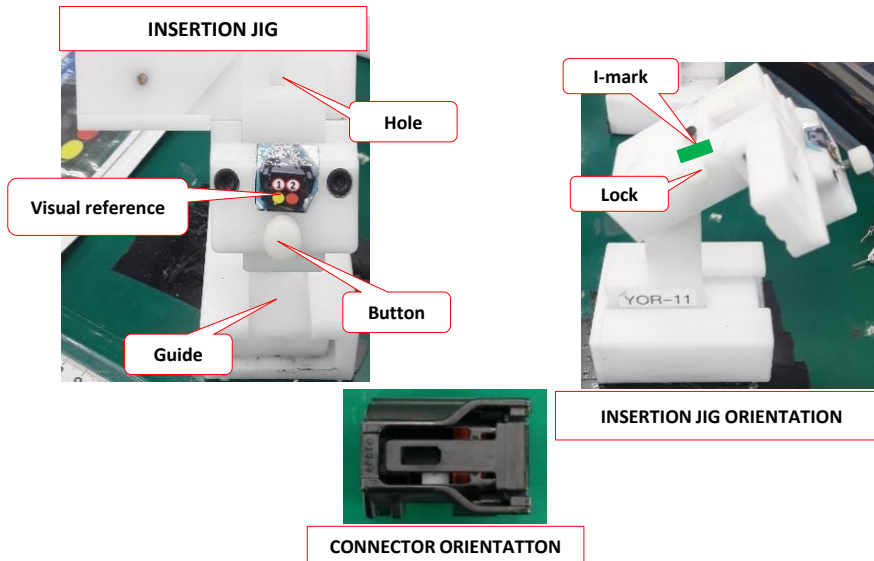
**4 of 12****PARTS:**

1. Black Corrugated tube  $\phi 7$  L= 24 $\pm$ 3mm (no slit)
2. Black Corrugated tube  $\phi 5$  L= 258 $\pm$ 3mm (no slit)

3. Assy parts

**JIG**

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to COT (no slit) $\phi 7$ L= 24 $\pm$ 3mm (1ST) $\phi 5$ L= 258 $\pm$ 3mm (2ND)	 <div>1. Hold the wires using left hand. Get the <b>Corrugated tube (no slit) <math>\phi 7</math> L=24<math>\pm</math>3mm</b> using right hand then insert then <b>Y-OR wires</b> using left hand.</div> <div>2. Hold the wires using left hand. Get the <b>Corrugated tube (no slit) <math>\phi 5</math> L=258<math>\pm</math>3mm</b> using right hand then insert then <b>Y-OR wires</b> using left hand.</div>	n/a	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No deformed terminal</li></ol>
5	P1 Connector setting to insertion jig 6189-1161 (B)		n/a	<ol style="list-style-type: none"><li>1. Use the provided jig per model</li><li>2. No wrong orientation of connector</li><li>3. No wrong use of connector</li><li>4. No damaged connector</li></ol>

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Purpose: ☐ PROTOTYPE

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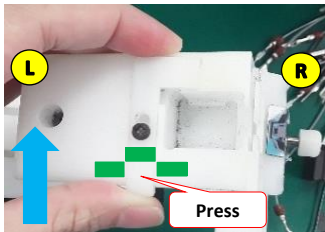
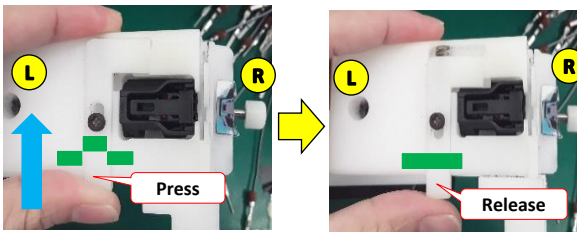


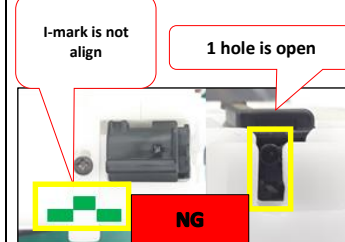
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### PARTS:

1. Connector 6189-1161 (B)

### JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 Connector setting to insertion jig 6189-1161 (B) (Continuation)	<div><p>1. Press the lock using left thumb.</p></div> <div><p>2. Get the connector <b>6189-1161 (B)</b> using right hand and insert to insertion jig. Release the lock after insertion. <i>Note: Follow the connector orientation.</i></p></div> <div><p>3. Push the lower wire guide upward using right hand. Slot for <b>Yellow wire</b> will be opened.</p></div>	n/a	<div><b>CONNECTOR ORIENTATION ILLUSTRATION</b></div> <div><p>I-mark is align 1 hole is open <b>GOOD</b></p></div> <div><p>I-mark is not align 1 hole is open <b>NG</b></p></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>

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### PARTS:

1. Assy parts

### JIG

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

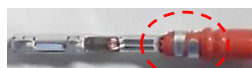
### TOOLS/PPE

### 1 QUALITY POINTERS

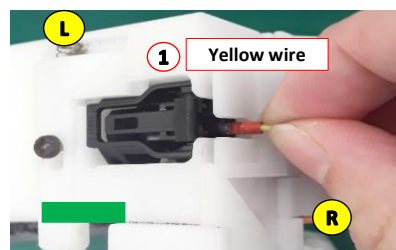
6

P1

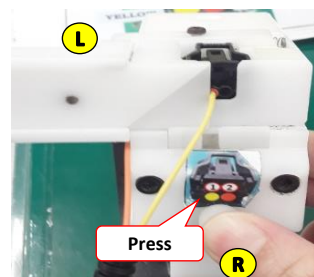
Wire insertion to connector  
6189-1161 (B)



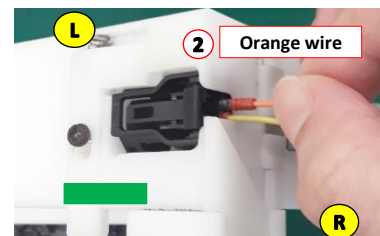
WIRE FACING



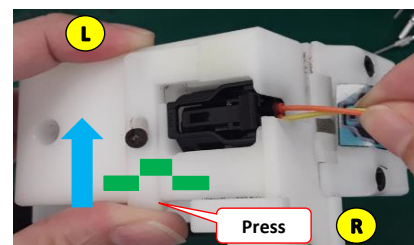
1. Hold the insertion jig using left hand.  
Get the **Yellow wire** then insert to terminal  
slot **1** using right hand.



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



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



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

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deform terminal
5. No wrong wire facing

#### Important reminders/Note/s:

1. Please hold the wire near terminal.
  2. Make sure wires are properly inserted.
- Conduct Pull-Push-Pull-Push after insertion.  
Do not exert extra force.
3. Insertion of wires must be from left to right

#### Document references:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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Customer: **TRQSS**

Document No.:

**WI-ENG-PDE-400A**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

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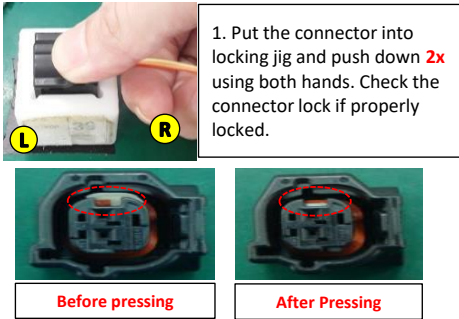


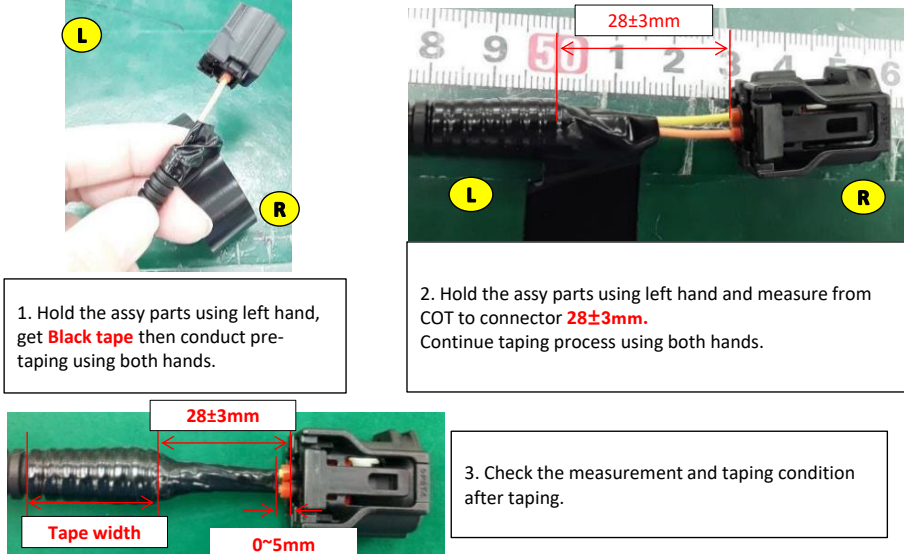

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### PARTS:

1. Assy parts
2. Black tape

### JIG

1. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	1 QUALITY POINTERS
7	Connector lock	 		<b>Important reminders/Note/s:</b> <b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b>  1. No unlock/half-locked connector 2. No damaged lock
8	Taping 1 COT to wire near connector	 <p>1. Hold the assy parts using left hand, get <b>Black tape</b> then conduct pre-taping using both hands.</p> <p>2. Hold the assy parts using left hand and measure from COT to connector <b>28±3mm</b>. Continue taping process using both hands.</p> <p>3. Check the measurement and taping condition after taping.</p>		<b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b>  1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape

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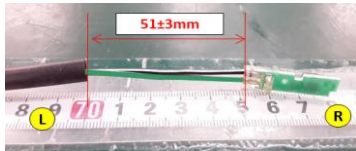
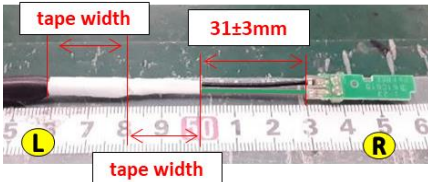


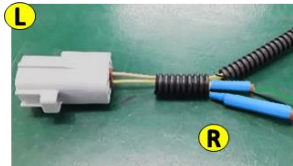


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### PARTS:

1. White tape
2. MRSW CP TVSSf 0.3 wires G-B/W L=664±3mm with inserted Black VM tube (sunprene) ø5 L=125±3mm
3. Assy parts

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	1 QUALITY POINTERS
9	P1 Taping 2 Black VM tube (sunprene) to wire near hotmelted wires	 <p>1. Get the hotmelted <b>G-B/W wires</b> with Black VM tube (sunprene) then measure from end of the sunprene tube up to the edge of hotmelt <b>51±3mm</b> using both hands.</p>  <p>2. Hold the sunprene tube using left hand, get the <b>White tape</b> using right hand and begin taping process using both hands.</p> <p>3. After taping, check the measurement and taping condition.</p>	 <p>MEASURING JIG</p>	<ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ol> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Use <b>WHITE TAPE</b> only</li><li>2. Please use calibrated/verified measuring tape when getting the measurement.</li></ol>
10	Wire insertion to assy parts	 <p>1. Get the terminal cover jig using right hand then insert to both terminals (<b>G-B/W wires</b>) using right hand.</p>  <p>2. Hold the corrugated tube <b>ø7 L=24±3mm</b> using left hand then insert the <b>G-B/W wires</b> using right hand.</p>  <p>3. After insertion, remove the cover jig using right hand.</p>	 <p>TERMINAL COVER JIG</p>	<ol style="list-style-type: none"><li>1. No wrong usage of parts</li><li>2. No damaged rubber seal</li></ol>

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### PARTS:

1. Assy parts

### JIG

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

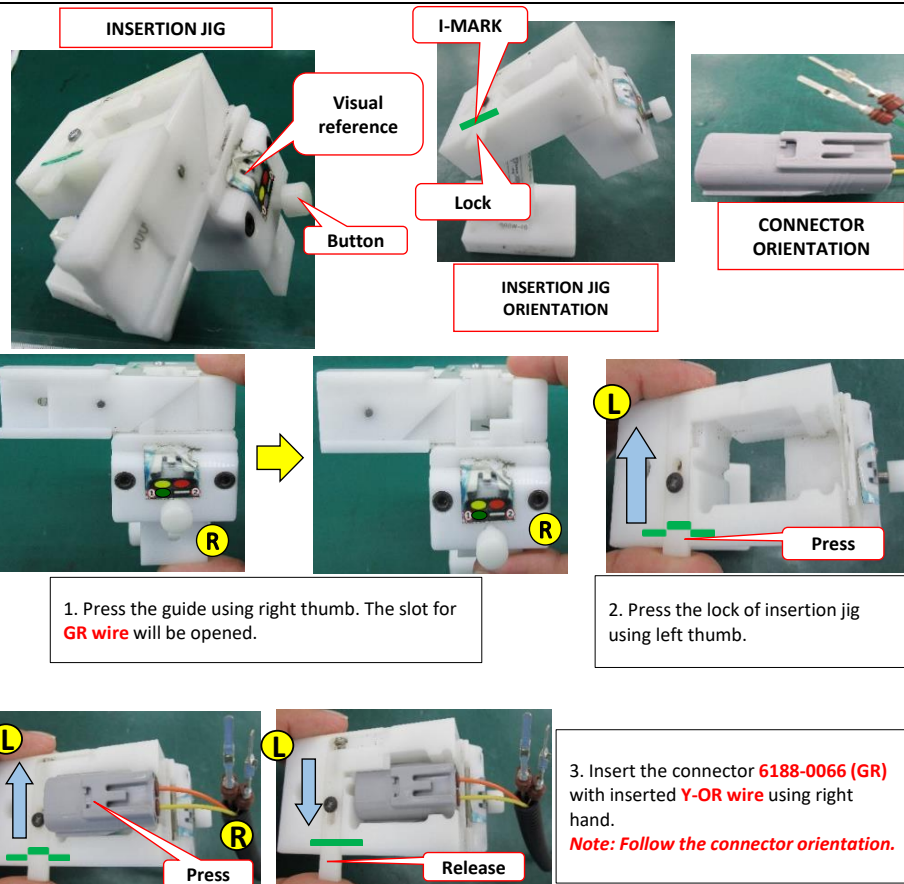
### TOOLS/PPE

### QUALITY POINTERS

11

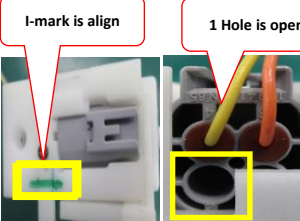
P2

Connector setting to  
insertion jig  
6188-0066 (GR)  
(Assy parts)

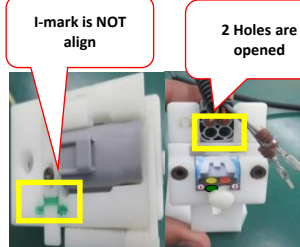


n/a

### Connector Orientation Illustration



**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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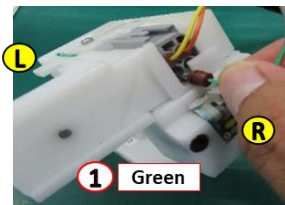

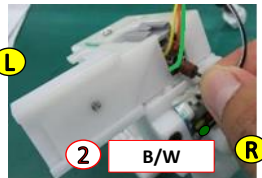
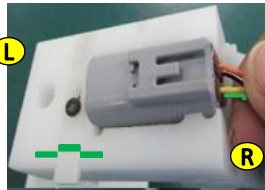
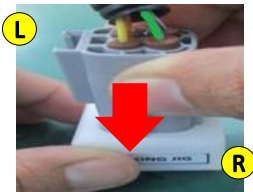

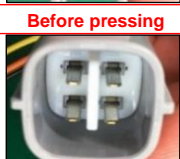
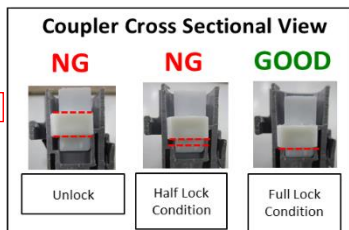

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PARTS:		1. Assy parts			JIG	1. Insertion jig 2. Locking jig									
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1. QUALITY POINTERS									
12	P2	Wire insertion to connector 6188-0066 (GR) (Assy parts)	<div><div><p>1 Hold the <b>G wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div><div><p>2. Press the button using right thumb. The slot for <b>B/W wire</b> will be opened.</p></div><div><p>3. Hold the <b>B/W wire</b> then insert to terminal slot <b>2</b> using right hand.</p></div><div><p>4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div></div>		n/a	<div><div><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p></div><div><p><b>Important reminders/Note/s:</b></p><p>1. Please hold the wire near terminal.</p><p>2. Make sure wires are properly inserted.</p><p>Conduct Pull-Push-Pull-Push after insertion.</p><p>Do not exert extra force.</p><p>3. Insertion of wires must be from left to right</p></div><div><p><b>Document references:</b></p><p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p></div></div>									
13		Connector Lock	<div><div><p>1. Put the connector into locking jig using both hands and then conduct <b>2x</b> pressing. Check the connector if properly locked.</p></div><div><p>Before pressing</p></div><div><p>After pressing</p></div><div><p>Coupler Cross Sectional View</p><table><tr><td>NG</td><td>NG</td><td>GOOD</td></tr><tr><td></td><td></td><td></td></tr><tr><td>Unlock</td><td>Half Lock Condition</td><td>Full Lock Condition</td></tr></table></div></div>		NG	NG	GOOD				Unlock	Half Lock Condition	Full Lock Condition	Locking jig	<div><div><p><b>Important reminders/Note/s:</b></p><p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p></div><div></div><div><p>1. Use the provided locking jig per model</p><p>2. No unlock/half-locked connector</p></div></div>
NG	NG	GOOD													
Unlock	Half Lock Condition	Full Lock Condition													

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**WORK INSTRUCTION**

Effectivity Date:

**March 10, 2023**

Process Name/Title:

**TAPING ASSEMBLY PROPCESS**

Validity Date:

**n/a**Model Code/Part Number: **150B / 7L0058-7024**

Customer:

**TRQSS**

Document No.:

**WI-ENG-PDE-400A**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

**1**

Page No.:

**11 of 12****PARTS:**

1. Black Corrugated tube  $\phi 5$  L=416 $\pm$ 4mm (with slit)
2. Assy parts

**JIG**

1. COT Adaptor jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
14	P1  Wire insertion to Black Corrugated tube $\phi 5$ L=416 $\pm$ 4mm (with slit)	   <div>1. Hold the COT adaptor using left hand. Insert the wires using right hand.</div> <div>2. Hold the COT adaptor with wires using left hand, get the <b>Black Corrugated tube (w/slit) <math>\phi 5</math> L=416<math>\pm</math>4mm</b> using right hand and insert to COT adaptor. Pull the adaptor and push the COT (<b>same timing</b>) using both hands. Make sure all wires are inserted.</div>	<div>COT Adaptor</div>	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No wires left in between the COT with slit</li></ol>

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROPCESS

Effectivity Date:

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

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PARTS:

1. Assy parts

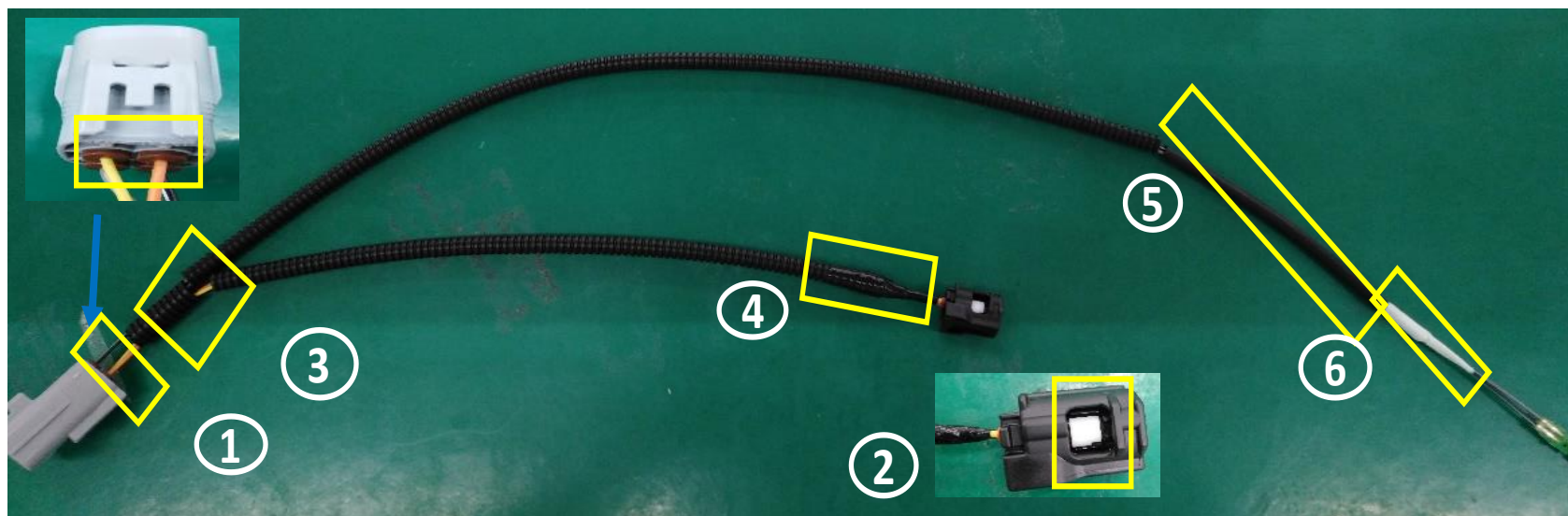
JIG

n/a

### 1 QUALITY CHECKPOINTS

# P1

# 7L0058-7024



**NO GOOD**



**GOOD**

① No **WRONG INSERT** ② NO **UNLOCKED Coupler**

④ ⑥ No **MISSING TAPE**

③ No **MISSING COT**

⑤ No **MISSING VINYL**

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