



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **480B / A7047E**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 30, 2021

Validity Date:

n/a

Document No.:


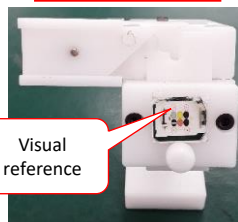
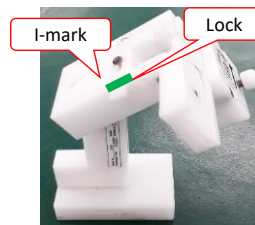


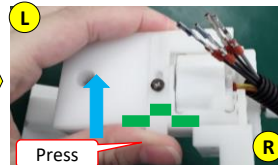
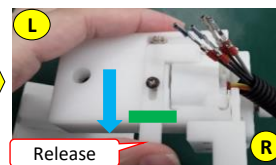
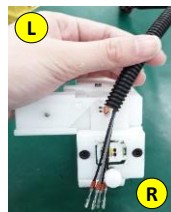




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PARTS:		1. Assy parts					JIG:	1. Insertion jig						
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION					TOOLS/PPE		QUALITY POINTERS			
1		P2		Connector setting to insertion jig 6189-1142 (W)					<div><div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>		<div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div><div>I-mark is align</div><div>1 hole is open</div></div><div></div><div>GOOD</div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector</div></div>			
<div><div><div><p>Visual reference</p></div><div><div><p>Insertion Jig Orientation</p></div><div><p>Connector Orientation</p></div></div><div><div><div><p>Press</p></div><div><p>Press</p></div><div><p>Release</p></div></div><div><div>1. Press the insertion jig lock using left hand.</div><div>2. Get the connector 6189-1142 (W) using right hand and insert to insertion jig. Release the lock after insertion.</div><div><div>3. Push the lower wire guide upward using right hand. Slot for Gray wire will be open.</div></div></div></div></div></div>														
				21					Prepared by		Reviewed by	Approved by	Noted by	
04/30/21	4	Remove validity date					J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
10/30/20	3	Transfer process owner from Production (WI-PRO-ASY-012B) to Engineering (WI-ENG-PDE-126B); Apply some improvements; Updated pictures					J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
07/10/17	0	Initial issue.					J. Montealto / L. Birones	O. Merin	T. Sugiyama	n/a				
Eff. Date	Rev. No	Details of Change					Revised	Checked	Approved	Noted	Est. Date: July 10, 2017			

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION


TOOLS/PPE

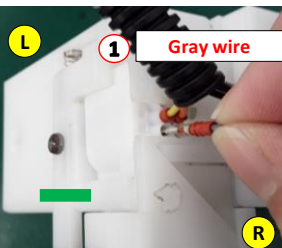
QUALITY POINTERS


2

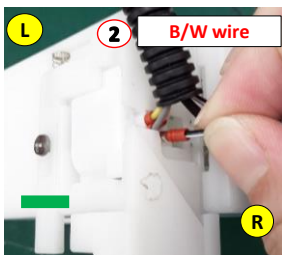
P2

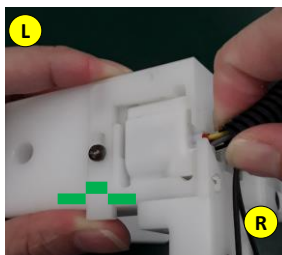
Wire insertion to
connector
6189-1142 (W)

 Wire facing

 **1** Gray wire

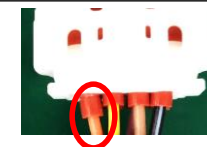
 **2** Press the button using right thumb. Slot for Black white wire will be open.

 **3** B/W wire

 **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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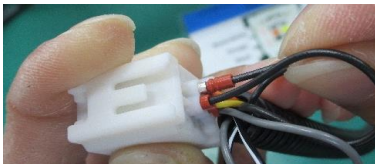
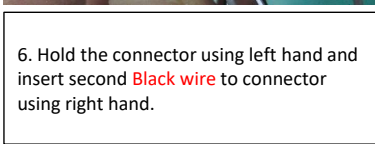
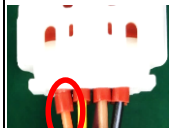

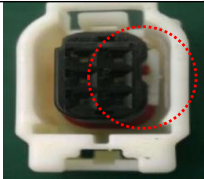
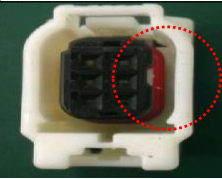

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TAPING ASSEMBLY PROCESS

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Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		4		Page No.: 3 of 5	

PARTS:	1. Assy parts				JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P2	Wire insertion to connector 6189-1142 (W) (continuation)	<div><p>Wire facing</p></div> <div><p>Connector Orientation</p></div> <div><p>5. Hold the connector using left hand and insert first Black wire to connector using right hand. <i>Note: Insertion starts from left to right</i></p></div> <div><p>6. Hold the connector using left hand and insert second Black wire to connector using right hand.</p></div>	n/a	 <p><i>Note: During insertion, hold the wire not rubber seal to prevent sagging.</i></p> <ol style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deformed terminal5. No wrong wire facing <p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p>	
3		Connector lock	 <p>1. Put the connector into locking jig and push down using right thumb.</p> <div><p>BEFORE PRESSING</p></div> <div><p>AFTER PRESSING</p></div>	LOCKING JIG 	<ol style="list-style-type: none">1. No unlock/Half-locked connector2. No damaged lock	

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

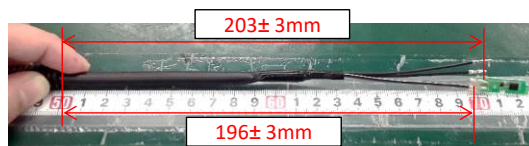
TOOLS/PPE

QUALITY POINTERS

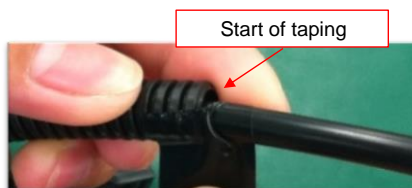
4

P2

Taping 1
Corrugated tube to
Sunprene tube

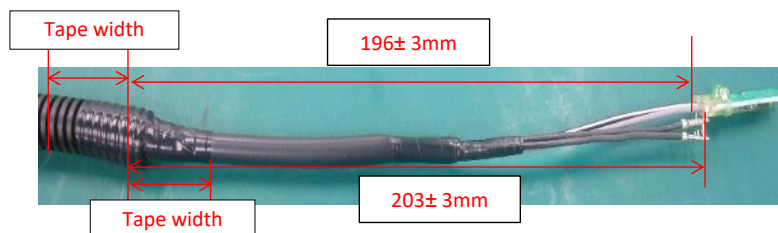


1. Measure the end of the corrugated tube up to the edge of hotmelt 196mm, COT to terminal pointed tip 203mm using both hands.



Start of taping

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



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

MEASURING TAPE



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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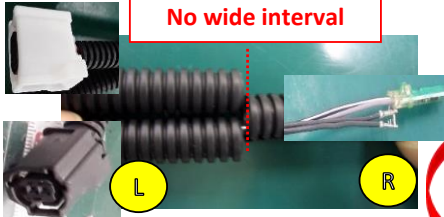
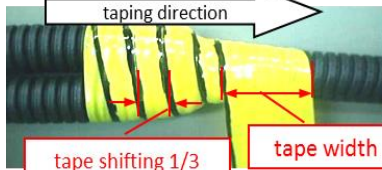

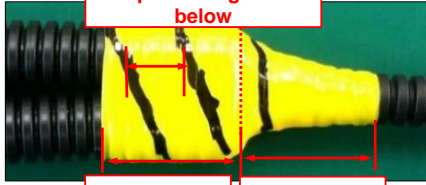
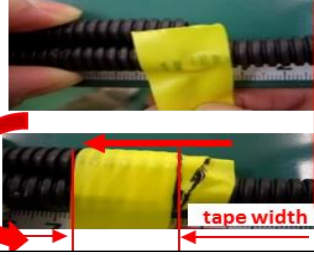

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PARTS:		1. Assy parts 2. Black tape			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	P2	<div><div><div>No wide interval</div><div></div><div>1. Fix the corrugated tube .</div></div><div><div></div><div>taping direction</div><div>tape shifting 1/3 below</div><div>tape width</div><div>2. Start taping at the middle of combined Corrugated tubes, then wind the tape going to 2 corrugated tubes , width must be same with tape (19mm)</div></div><div><div></div><div>taping direction</div><div>tape shifting 1/2</div><div>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)</div></div><div><div></div><div>Tape shifting 9mm below</div><div>Tape width</div><div>Tape width</div><div>4. Wind the tape backward 1/2 shifting.</div></div><div><div></div><div>Note: Do not exert excessive force during pulling & winding of tape</div><div>tape width</div><div>5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</div></div></div>			n/a	<p>NOTE: USED YELLOW TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL SHOULD BE BLACK.</p> <p>1. No peel-off tape 2.No flip out tape 3.No loose tape 4. No wrong dimension</p>  <p>Y-taping Orientation</p>

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