

**WORK INSTRUCTION**

Effectivity Date:

December 03, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

920B / 7R0116-7020B

Customer:

TRMX

Document No.:

WI-ENG-PDE-586A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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PARTS:

1. Connector 6188-0407 (W);TVSSf 0.3 B/W-G wires L=365±2mm; Black Vinyl Tube Ø5 L=143±3mm; Black Sunprene tube Ø5 L=125±3mm; Black tape; White tape

JIG:

1. Insertion jig with switch cover

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P1

Table Lay-out

Connector 6098-0407(W)/Connector tray

TABLE LAY-OUT

Black Sunprene Tube Ø5 L=125±3mm

Black Vinyl Tube Ø5 L=143±3mm

TVSSf 0.3 B/W-G wires L=365±2mm

Tape holder/White tape

Tape holder/Black tape

Safety Instruction

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools

Important reminders/Note/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.

Revision History

12/03/22	1	Change from Pre-Launch to Maspro.Change SV tube from L=146±3mm to 143±3mm due encountered pulling of wire during assembly. Inclusion of Quality checkpoints.	M. Ariola	J. Loterte	C. Villanueva	A.Arañes	Prepared by	Reviewed by	Approved by	Noted by
08/18/22	0	Initial Issue. Wire length 402mm to 365mm; Vinyl tube (SV) length from 183mm to 146mm.	M. Ariola	J. Loterte	C. Villanueva	A.Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	August 18, 2022		

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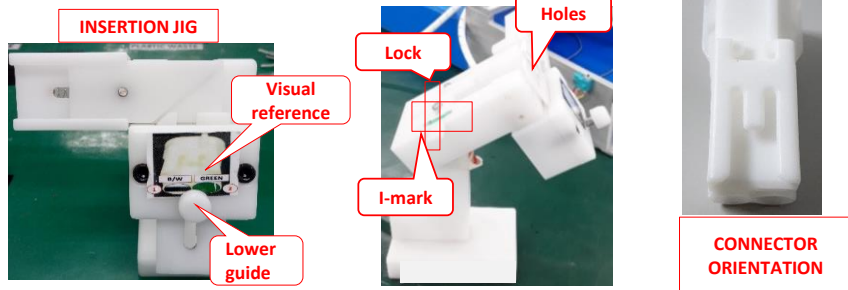
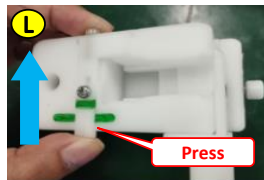
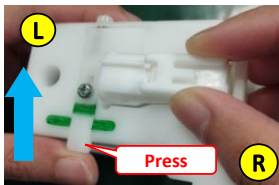

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PARTS:		1. Connector 6188-0407 (W)			JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P1	<div>Connector setting to insertion jig 6188-0407(W)</div> <div>     <div> <p>1. Press the lock 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> </div> </div>			n/a	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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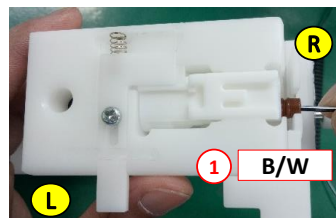
Page No.:

3 of 7**PARTS:**

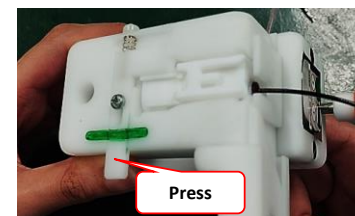
1. TVSSf 0.3 B/W-G wires L=365±2mm

JIG

1. Insertion jig with switch cover

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****3****P1**Wire insertion to connector
6188-0407(W)

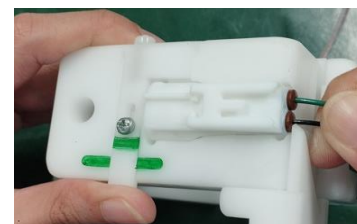
1. Hold the Insertion jig using left hand. Get **Black/White wire** then insert to terminal **slot 1** using right hand.



2. Push the button using right hand. The slot for **Green wire** will be opened.



3. Get **Green 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 deformed terminal
5. No wrong wire facing

Important reminders/ Note/s:

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

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
2. Please Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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PARTS:



1

1. Assy parts
2. Black Vinyl Tube Ø5 L=143±3mm

1. Black Sunprene tube Ø5 L=125±3mm

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black Vinyl Tube Ø5 L=143±3mm	 <p>1. Get the Viny tube Ø5 L=143±3mm using right hand then insert the Green and Black/White wire.</p>	n/a	1. No wrong use of parts 2. No deformed terminal
5	Wire Insertion to Black Sunprene tube Ø5 L=125±3mm	 <p>1. Get the Sunprene tube Ø5 L=125±3mm using right hand then insert the Green and Black/White wire.</p>	n/a	1. No wrong use of parts 2. No deformed terminal

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PARTS:

1. Assy parts
2. White tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

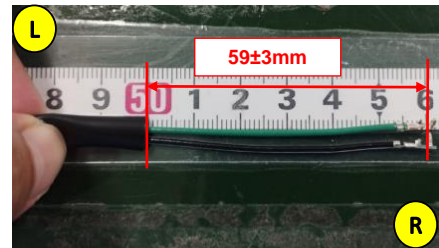
TOOLS/PPE

QUALITY POINTERS

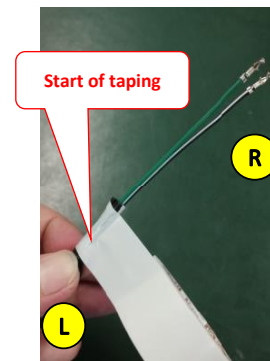
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P1

Taping 1
Black Sunprene tube to Wire
near terminal



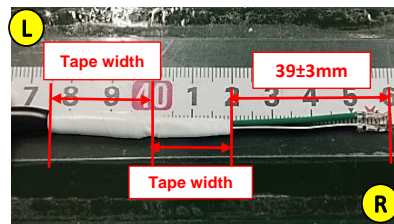
1. Measure the end of the sunprene tube up to the end of the terminal pointed tip 59mm using both hands.



2. Hold the sunprene tube using left hand then start taping using right hand.

Note: Refer to WI-PRO-ASY-001 for taping procedure.

MEASURING TAPE



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

Important reminders/Notes/:

1. Please use calibrated/ verified measuring tape when getting the measurement.

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

Wire alignment tolerance



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PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

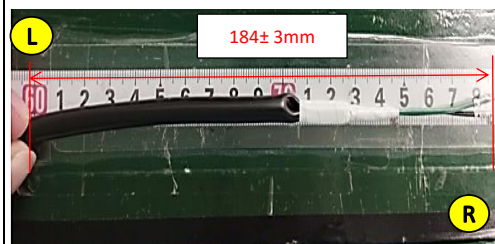
TOOLS/PPE

QUALITY POINTERS

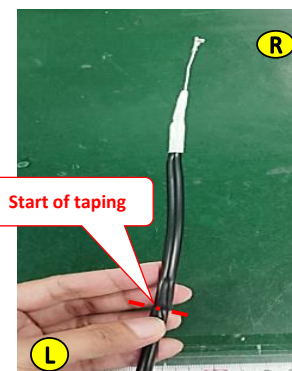
7

P1

Taping 2
Vinyl tube to Sunprene tube

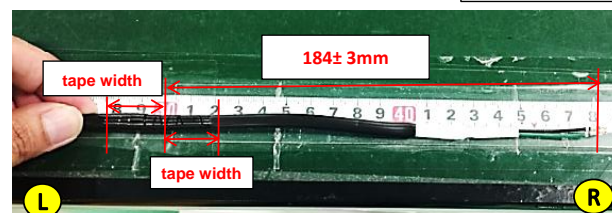


1. Measure the end of the Vinyl tube up to the end of the terminal pointed tip **184mm**.



2. Fix the Sunprene tube and the Vinyl tube using both hands make sure no gap between the tubes. Start taping process using right hand.
Note: Refer to WI-PRO-ASY-001 for taping procedure

MEASURING TAPE



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

Important reminders/Notes/:

1. Please use calibrated/ verified measuring tape when getting the measurement.

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

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PARTS:

n/a

JIG

n/a

NO.

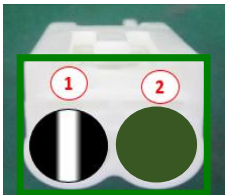
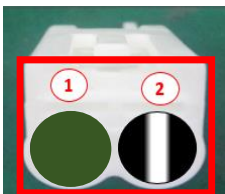
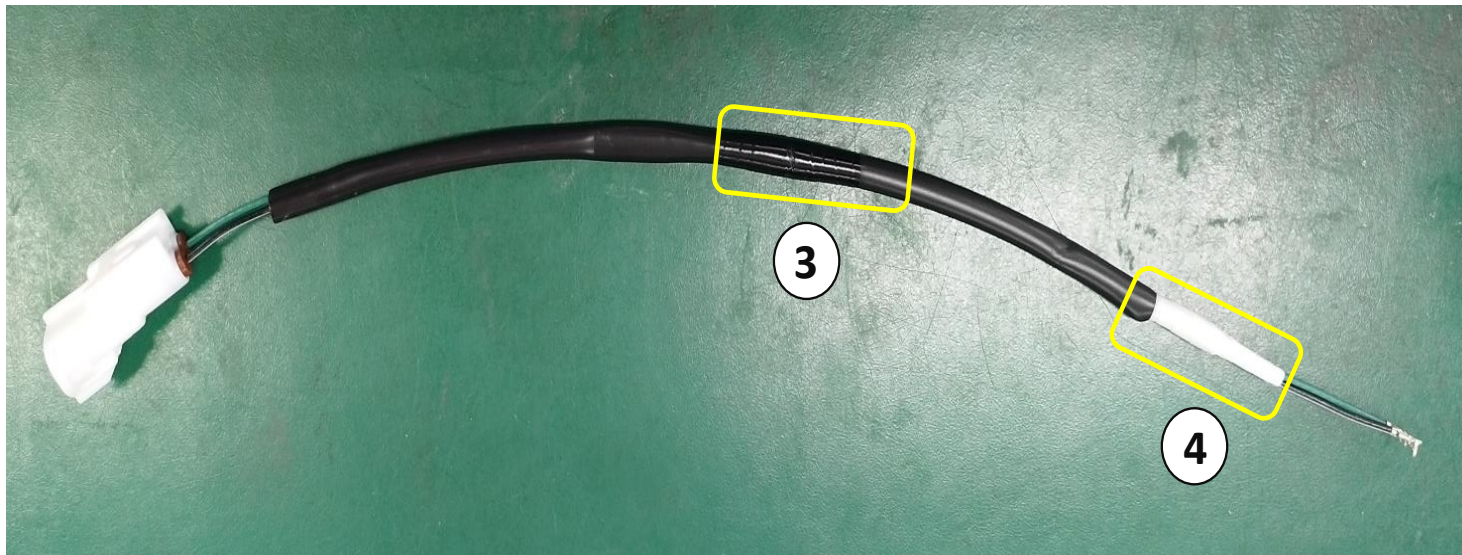
PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

P1**7R0116-7020B****GOOD****NO GOOD****GOOD****NO GOOD**

① No Wrong Insert ② ③ No Missing/Wrong Used of Tape ④ No Terminal Backing Out

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