



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

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

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 30, 2021

Validity Date:

n/a

Document No.:

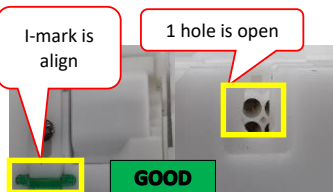

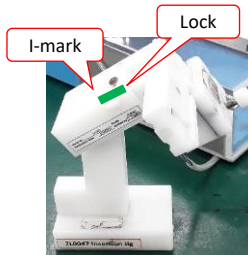
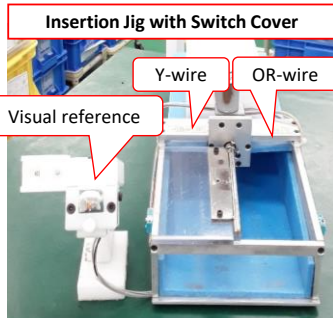
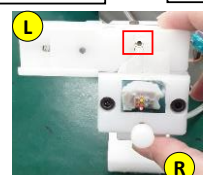

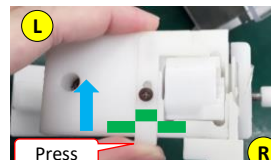





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PARTS:		1. Connector 6189-1142 (W)				JIG:	1. Insertion jig with SW cover							
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS				
1		P1		Connector setting to Insertion jig 6189-1142 (W)				<div><div>Safety Instruction 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>CONNECTOR ORIENTATION ILLUSTRATION </div> <div>1. Use the provided jig per model 2. No wrong orientation of connector</div>				
				<div><div></div><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>3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.</div></div></div>										
Revision History														
04/30/21	4	Remove Validity date				J. Loterte	C. villanueva	A. Shimamura	A. Arañes	Prepared by		Reviewed by	Approved by	Noted by
10/30/20	3	Transfer process owner from Production (WI-PRO-ASY-012A) to Engineering (WI-ENG-PDE-186A); 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	J. Loterte		C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted	Est. Date:		July 10, 2017		

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PARTS:

1. AVSSf 0.3 wires Y L=828mm; OR L=828mm

JIG

1. Insertion jig with SW cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

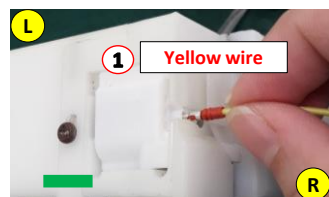
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P1

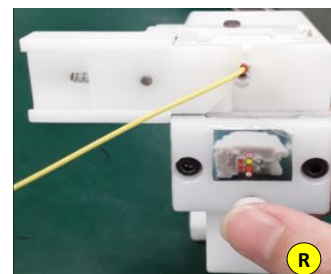
Wire Insertion to
connector
6189-1142 (W)



Wire facing



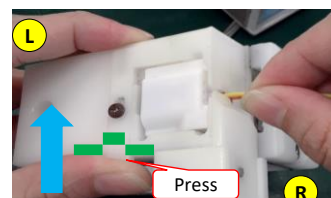
1 Yellow wire



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



2 Orange wire



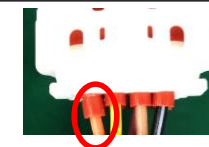
Press

3. Get the Orange wire and insert to
connector 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

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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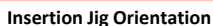

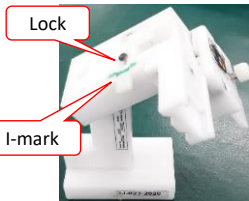
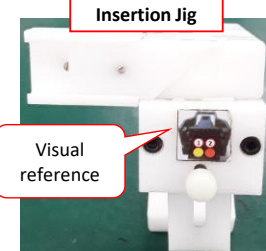
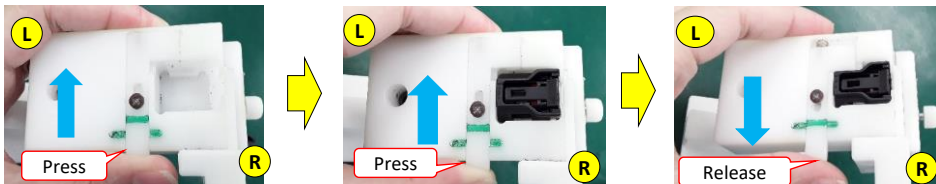
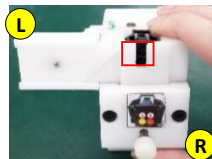


WORK INSTRUCTION TAPING ASSEMBLY PROCESS

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Validity Date:	n/a		
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Process Name/Title: **TAPING ASSEMBLY PROCESS**

Product Name/Code: **480A / A7047E** Customer: **TRQSS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Black Corrugated tube $\phi 7$ L= 730 \pm 3mm (no slit) 2. Black Corrugated tube $\phi 7$ L= 68 \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	P1	Wire insertion to COT $\phi 7$ L= 730 \pm 3mm and $\phi 7$ L= 68 \pm 3mm	<div></div> <div>1. Get the corrugated tube $\phi 7$ L= 730\pm3mm using right hand then insert the yellow wire and orange wire by using left hand.</div> <div>2. Get the corrugated tube $\phi 7$ L= 68\pm3mm using right hand then insert the yellow wire and orange wire by using left hand.</div>			n/a	1. No wrong use of parts 2. No deformed terminal
4		Connector setting to Insertion jig 6189-1161 (B)	<div><div></div><div></div><div>1. Press the insertion jig lock using left hand.</div><div>2. Get the connector 6189-1161 (B) using right hand and insert to insertion jig. Release the lock after insertion.</div></div> <div><div>3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.</div></div>			<div>CONNECTOR ORIENTATION ILLUSTRATION</div> <div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector</div>	

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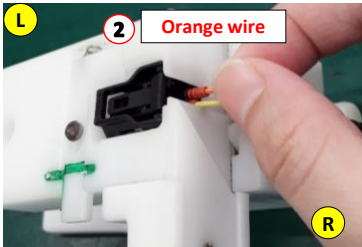
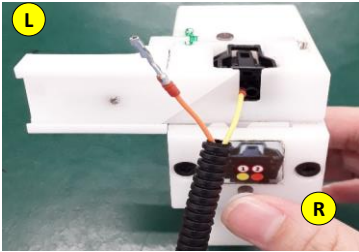
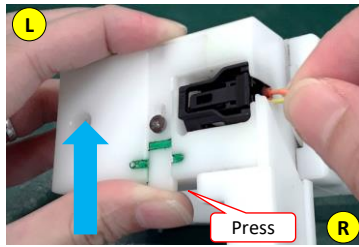
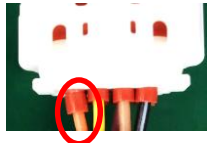
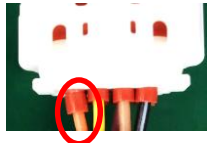
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Product Name/Code:	480A / A7047E	Customer:	TRQSS	Validity Date:	n/a	
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO	Document No.:	WI-ENG-PDE-186A	Revision No.:	4	Page No.: 4 of 7

PARTS:		1. Assy parts		JIG	1. Insertion jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to connector 6189-1161 (B)	<div><div><p>Wire facing</p></div><div><p>1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand.</p></div><div><p>3. Get the Orange wire and insert to connector using right hand.</p></div><div><p>2. Press the button using right thumb. slot for Orange wire will be open.</p></div><div><p>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.</p></div></div> <td>n/a</td> <td><div><div>Note: During insertion, hold the wire not rubber seal to prevent sagging.</div><div></div><div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div><div>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div></div></td>		n/a	<div><div>Note: During insertion, hold the wire not rubber seal to prevent sagging.</div><div></div><div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div><div>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div></div>

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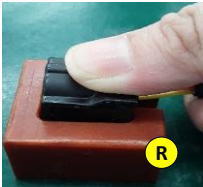
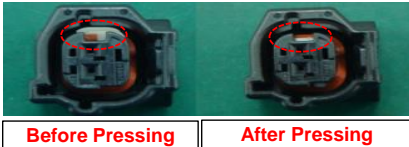



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts 2. Black Vinyl tube $\phi 5$ L= 134 \pm 3mm 3. AVSSf 0.3 wires B L=1072mm [2pcs] 4. MRSW CP A7475-A7047D (AVSSf 0.3 wires GR L=1074mm, B/W L=1074mm)			JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Connector lock	 <div data-bbox="586 657 936 762">1. Put the connector into locking jig and push down using right thumb.</div>  		LOCKING JIG 	1. No unlock/Half-locked connector 2. No damaged lock
7		 <div data-bbox="739 1120 1294 1300">1. Hold the GR, B/W and 2 Black wires using left hand. Get the Vinyl tube $\phi 5$ L= 134\pm3mm using right hand. Insert the wires using left hand. Insertion must be 2 wires at a time.</div>		n/a	1. No wrong use of parts 2. No deformed terminal

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☐ PRE-LAUNCH

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PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

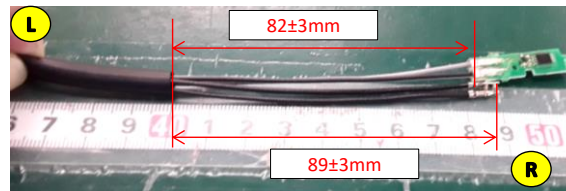
TOOLS/PPE

QUALITY POINTERS

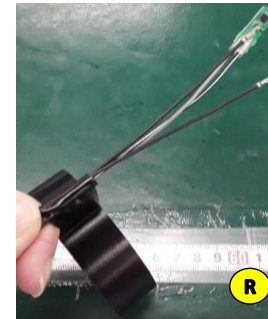
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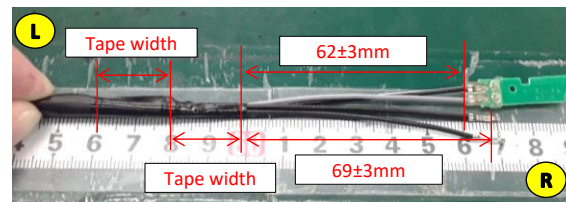
Taping 2
Vinyl tube to wire near
terminal/hotmelted wire



1. Measure the end of the Vinyl tube up to the end of the terminal pointed tip $89\pm 3\text{mm}$, and Vinyl tube to edge of hotmelted wire $82\pm 3\text{mm}$.



2. Hold the vinyl 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, wire alignment & 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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PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Black Corrugated tube $\phi 7$ L= 130 \pm 3mm (no slit)
2. Assy Parts

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	Wire insertion to Corrugated tube $\phi 7$ L=130 \pm 3mm		n/a	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal
10	P1 Wire insertion to Assy parts	 	n/a	<ol style="list-style-type: none">1. No wrong insertion2. No deformed terminal

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