

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

March 5, 2021

Product Name/Code: **780B / 7R0106-7020A**Customer: **TRMX**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

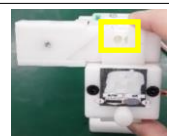
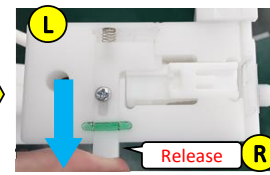
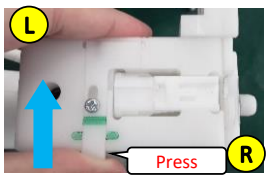


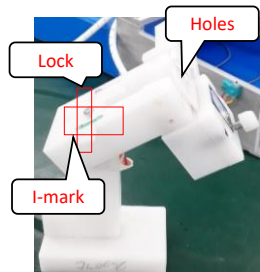
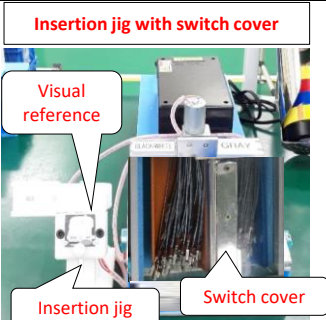
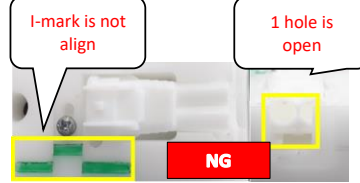
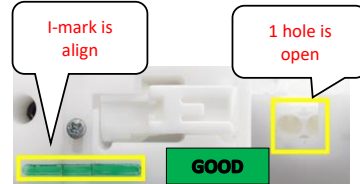


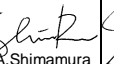

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PARTS:		1. Connector 6188-0407 (W)			JIG:	1. Insertion jig with switch cover		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
1	P1	<div>Connector setting to Insertion jig 6188-0407 (W)</div> <div></div> <div>1. Press the lock of insertion jig using left thumb.</div> <div>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></div> <div>3. Check the holes/terminal slot for B/W wire.</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 work place 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>Connector Orientation Illustration</div> <div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector</div>		
Revision History					Prepared by:	Checked by:	Approved by:	Noted by:
								
3/5/21	1	Change from pre-launch to masspro.			D.Castillo	C.Villanueva	A.Shimamura	A.Arañes
Eff. Date	Rev. No	Details of Change			Revise	Check	Approve	Noted
					Est. Date:	November 27, 2020		

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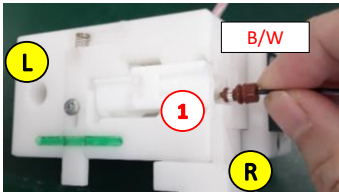
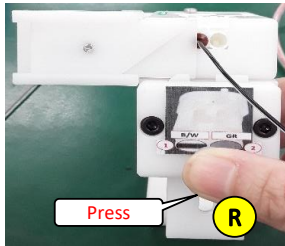
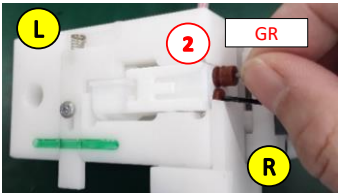
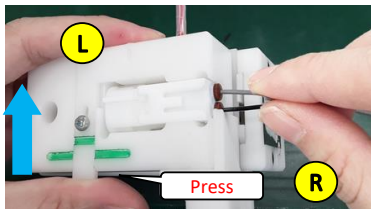
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PARTS:

1. TVSSf 0.3 wire B/W L=398mm
2. TVSSf 0.3 wire GR L=398mm

JIG

1. Insertion jig with switch cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Wire Insertion to connector 6188-0407 (W)	<div><p>Wire facing</p><p>1. Hold the insertion jig using left hand. Get the Black/White wire and insert to terminal slot ① using right hand.</p><p>2. Press the button using right thumb. Slot for Gray wire will be open.</p><p>3. Get the Gray wire then insert to terminal slot ② using right hand.</p><p>4. After insertion, push the lock button using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>	N/A	<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>

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PARTS:

1. Assy parts
2. Clip type clamp 82711-60270 (L)

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

Connector lock

P1



Before lock



After lock



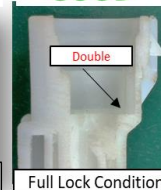
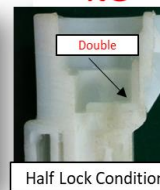
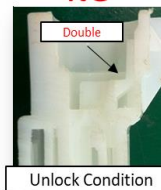
Put the connector into locking jig using right hand then press **2x**. Check the connector if properly lock.

CONNECTOR CROSS SECTIONAL VIEW

NG

NG

GOOD



Locking jig

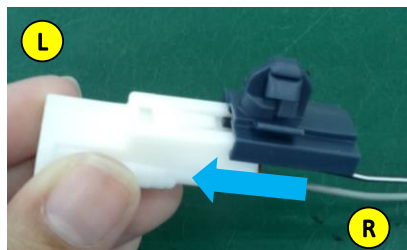


NOTE:
MANUAL LOCKING MAY CAUSED
DAMAGED LOCK

1. Use the provided locking per model
2. No unlock/half-locked connector

4

Clamp attachment
(Clip type Clamp)



Hold the connector using left hand, get the clip type clamp 82711-60270 (L) then insert the clamp using right hand. **Note: Sound will be heard if properly inserted.**

N/A

1. No damaged clamp
2. No wrong use of clamp

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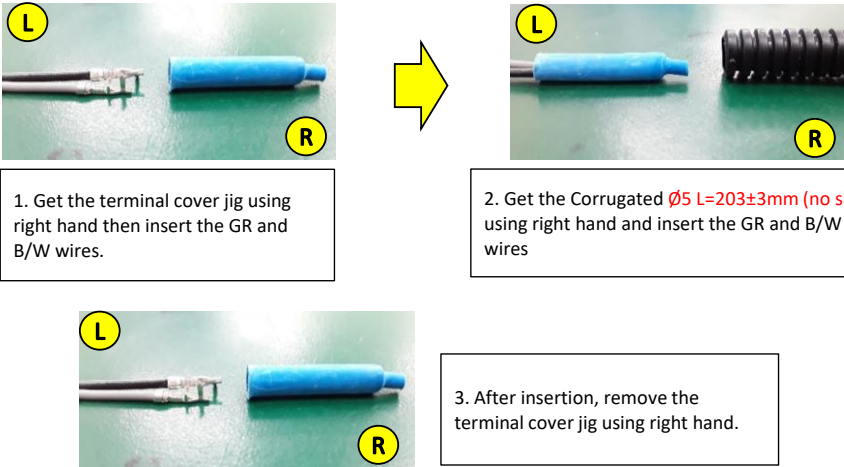


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PARTS:

1. Black Corrugated tube Ø5 L=203±3mm (no slit)
2. Black Sunprene tube Ø5 L=125±3mm

JIG

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to Corrugated tube Ø5 L=203±3mm (no slit)	 <ol style="list-style-type: none">1. Get the terminal cover jig using right hand then insert the GR and B/W wires.2. Get the Corrugated Ø5 L=203±3mm (no slit) using right hand and insert the GR and B/W wires3. After insertion, remove the terminal cover jig using right hand.	Terminal Cover jig 	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal
6	Wire insertion to Sunprene tube Ø5 L=125±3mm	 <ol style="list-style-type: none">1. Get the Black Sunprene tube Ø5 L=125±3mm using right hand and insert the GR and B/W wires	n/a	<ol style="list-style-type: none">1. No wrong use of parts2. 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

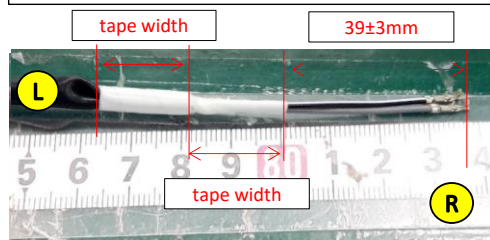
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P1

Taping
Sunprene to wire near
terminal



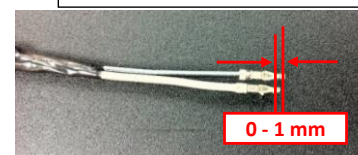
1. Hold the Sunprene tube using left hand. Measure from end of Sunprene up to the terminal pointed tip **59±3mm**.



2. Hold the Sunprene tube using left hand. Get **White tape** using right hand and start taping using both hands. *Refer to WI-PRO-ASY-001 for taping procedure.*

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

Wire alignment tolerance



Measuring tape



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

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

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