



## WORK INSTRUCTION

Effectivity Date:

February 22, 2023

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

920B / 7R0116-7021

Customer:

TRMX

Document No.:

WI-ENG-PDE-638A

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

Page No.:


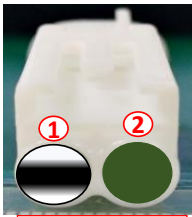

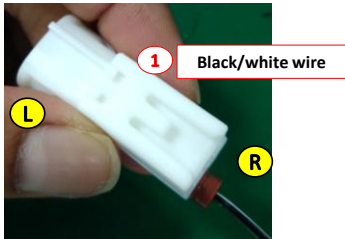
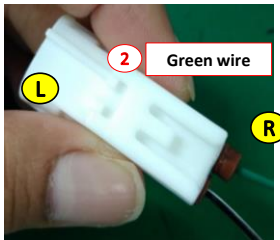
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## PARTS:

1. Connector 6188-0407 (W)
2. TVSSf 0.3 wires G-B/W L=365±2mm

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a Wire Insertion to Connector 6188-0407 (W)	<div><p>CONNECTOR ORIENTATION</p></div> <div><p>VISUAL REFERENCE</p></div> <div><p>WIRE FACING</p></div> <div><p>1. Get the connector <b>6188-0407 (W)</b> then hold the <b>Black/White wire</b> and insert to terminal <b>slot 1</b> of connector using right hand. Conduct <b>2x</b> push pull after wire insertion.</p></div> <div><p>2. Hold the connector <b>6188-0407 (W)</b> then get the <b>Green wire</b> and insert to terminal <b>slot 2</b> of connector using right hand. Conduct <b>2x</b> push pull after wire insertion.</p></div>	<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>	<div>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</div> <div><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</b></div> <div><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></div>

## Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Reviewed	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
02/22/23	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes		M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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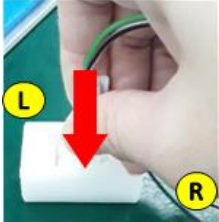

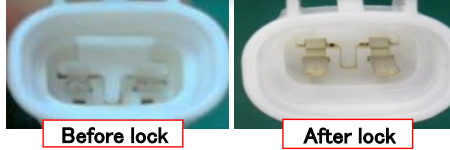



### PARTS:

1. Assy parts
2. Black SV tube (Vinyl) Ø5 L=139±3mm

3. Black VM tube (Sunprene) Ø5 L=123±3mm

JIG

1. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Connector Lock	 <p>1. Put the connector into locking jig using right hand then press <b>2x</b> to lock using both hands. Check the lock if properly locked.</p>  		<p><b>Important reminders/Note/s:</b></p> <p><b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></p> <ol style="list-style-type: none"><li>1. Use the provided locking jig per model</li><li>2. No unlock/half-locked connector</li></ol>
3	Wire Insertion to Black SV tube (Vinyl) Ø5 L=139±3mm	 <p>1. Get the Black SV tube (Vinyl) <b>Ø5 L=139±3mm</b> using right hand then insert the <b>G-B/W wires</b> using left hand.</p>	n/a	<ol style="list-style-type: none"><li>1. No wrong use of parts</li></ol>
4	Wire Insertion to Black VM tube (Sunprene) Ø5 L=123±3mm	 <p>1. Get the Black VM tube (Sunprene) <b>Ø5 L=123±3mm</b> using right hand then insert the <b>G-B/W wires</b> using left hand.</p>	n/a	<ol style="list-style-type: none"><li>1. No wrong use of parts</li></ol>

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PROTOTYPE



PRE-LAUNCH



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### PARTS:

1. Assy parts
2. White tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

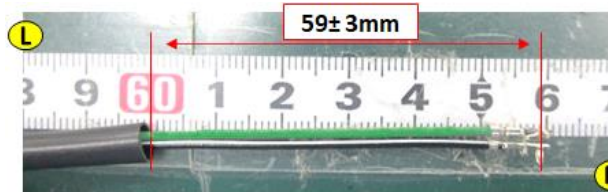
TOOLS/PPE

QUALITY POINTERS

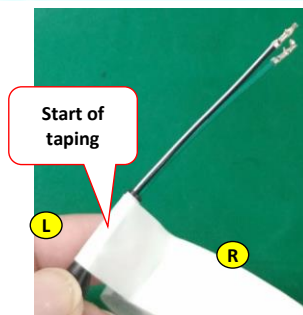
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n/a

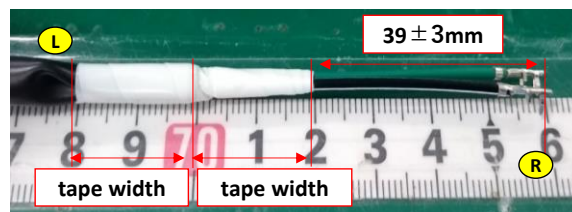
Taping 1  
Black VM tube (Sunprene)  
to wire near terminal



1. Measure from end of sunprene tube up to end of the terminal pointed tip **59±3mm** using both hands.



2. Hold the tube using left hand, get the **White tape** using right hand then start taping process using both hands.



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

### MEASURING TAPE



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

**Important reminders/Note/s:**  
*Please use calibrated/verified measuring tape when getting the measurement.*

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TAPING ASSEMBLY PROCESS

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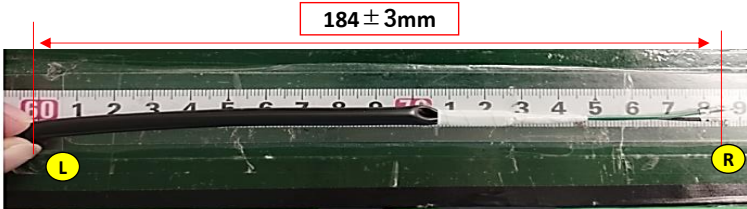

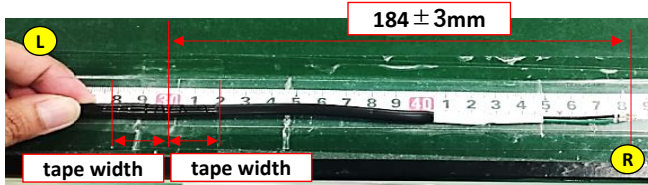

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Purpose:	<input type="checkbox"/> PROTOTYPE	<input checked="" type="checkbox"/> PRE-LAUNCH	<input type="checkbox"/> MASSPRO

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	n/a  Taping 2 Black SV tube (Vinyl) to Black VM tube (Sunprene) near terminal	 <p>184 ± 3mm</p> <p>1. Measure from end of corrugated tube up to terminal pointed tip <b>184±3mm</b> using both hands.</p>  <p>Start of taping</p> <p>2. Hold the corrugated tube and sunprene tube using left hand, get the <b>Black tape</b> then start taping process using both hands.</p>  <p>184 ± 3mm</p> <p>tape width</p> <p>tape width</p> <p>3. After taping, check the taping condition, measurement and wire alignment.</p>	<p><b>MEASURING TAPE</b></p> 	<p><b>Important reminders/Note/s:</b> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></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 use of tape</li><li>6. No wrong dimension</li></ol>

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PARTS:

1. Assy parts

JIG

n/a

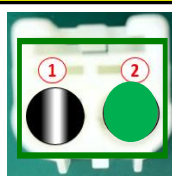
## QUALITY CHECKPOINTS

P1

7R0116-7021



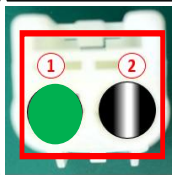
GOOD



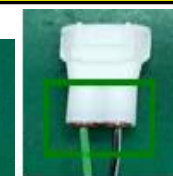
GOOD



NO GOOD



NO GOOD



GOOD



NO GOOD

① No Unlock/ Halflocked Connector

④ No Wrong use of tape (White tape)

② No Wrong Insert

⑤ No Missing tape

③ No Terminal Backing Out

⑥ No Deformed Terminal

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