



	WORK INSTRUCTION		Effectivity Date:	April 29, 2023	
	Process Name/Title: TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Product Name/Code: 920B / 7R0119-7020	Customer: TRMX	Document No.:	WI-ENG-PDE-637A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:

PARTS:		1. All parts: Connector 6188-0407 (W); TVSSf 0.3 wires G-B/W L=562±3mm; Black SV tube (Vinyl) Ø5 L=366±3mm; Black VM tube (Sunprene) Ø5 L=123±3mm; Yellow tape		JIG:	1. Insertion jig with switch cover 2. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 1 Table Lay-out	<div> <div>TABLE LAY-OUT</div> <div> <div>Connector 6188-0407 (W)/ Connector tray</div> <div>Black VM tube (Sunprene) Ø5 L=123±3mm</div> <div>Clamp 82711-1E360 (W)</div> <div>TVSSf 0.3 wires G-B/W L=562±3mm</div> <div>Black SV tube (Vinyl) Ø5 L=366±3mm</div> <div>Insertion jig A</div> <div>Measuring jig</div> <div>Yellow tape</div> </div> </div>		<div> <div> Safety Instruction Be sure to wear required 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>	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
										
04/29/23	1	Document purpose from prelaunch to masspro. Improve table lay-out. Improve work procedure and illustration due to improvement.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
02/22/23	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	February 22, 2023	

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PARTS: 1. Connector 6188-0407 (W)

JIG

Insertion jig with flip cover

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

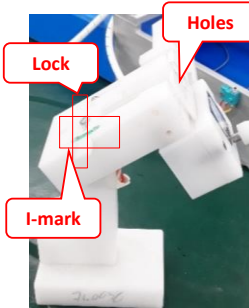
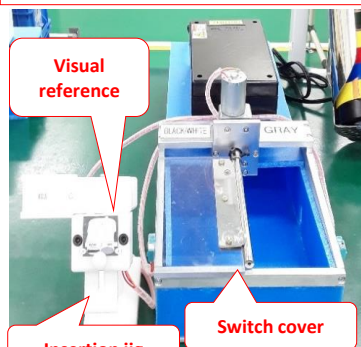
QUALITY POINTERS

2

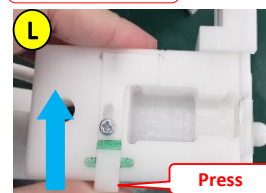
P1

Connector setting to
Insertion jig
6188-0407 (W)

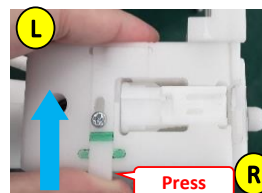
INSERTION JIG WITH FLIP COVER



**CONNECTOR
ORIENTATION**

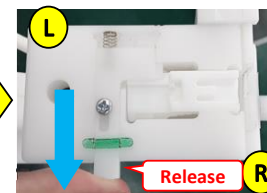


1. Press the lock of insertion jig using left thumb.

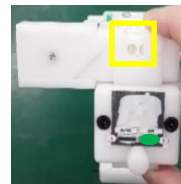


2. Insert the connector **6188-0407 (W)** into jig using right hand and release the lock.

Note: Refer to above illustration for correct setting.

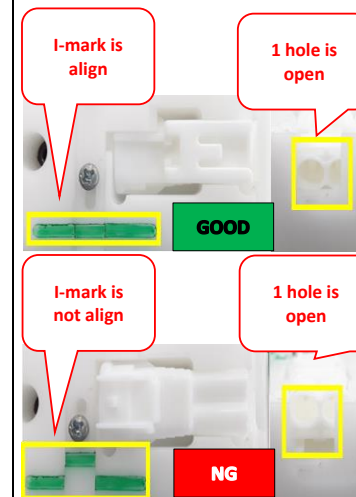


3. Check the holes/terminal slot for **B/W** wire.



n/a

**Connector Orientation
Illustration**



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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PARTS:

1. TVSSf 0.3 wires G-B/W L=562±3mm

JIG

1. Insertion jig with flip cover

NO.

PROCESS NAME

1

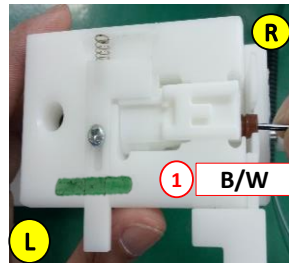
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

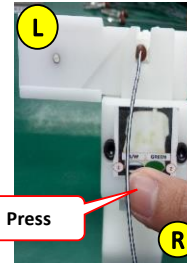
P1

Wire Insetion to
Connector
6188-0407 (W)

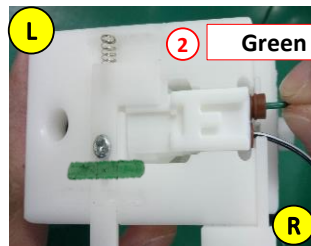
1. Hold the Insertion jig using left hand. Get **Black /White wire** then insert to terminal **slot 1** using right hand.



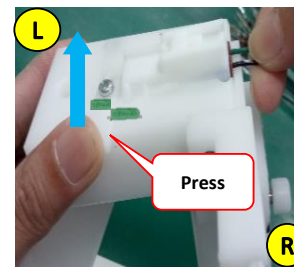
Wire facing



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.
 2. Make sure wires are properly inserted.
- Conduct Pull-Push-Pull-Push after insertion.**
Do not exert extra force.
3. Insertion of wires must be from left to right

Document references:

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

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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=366±3mm 3. Black VM tube (Sunprene) Ø5 L=123±3mm			JIG	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
4	P1	Wire Insertion to Black SV tube (Vinyl) Ø5 L=366±3mm	 <div>1. Get the Black SV tube (Vinyl) Ø5 L=366±3mm using right hand then insert the G-B/W wires using left hand.</div>	n/a	1. No wrong use of parts	
5		Wire Insertion to Black VM tube (Sunprene) Ø5 L=123±3mm	 <div>1. Get the Black VM tube (Sunprene) Ø5 L=123±3mm using right hand then insert the G-B/W wires using left hand.</div>	n/a	1. No wrong use of parts	

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PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts
2. Yellow tape

JIG

1. Measuring jig

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

6

P1

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

60mm

1. Conduct measurement of **60mm** from end of sunprene tube up to end of the terminal pointed tip using both hands.

Start of taping

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

39 ± 3mm

tape width

tape width

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

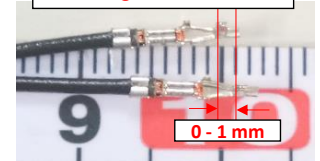
MEASURING TAPE



MEASURING JIG



Wire alignment tolerance



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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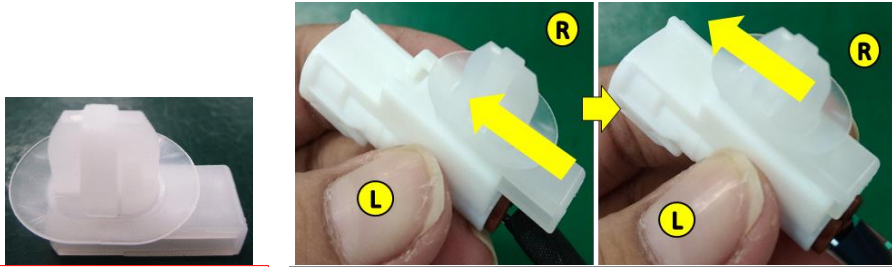
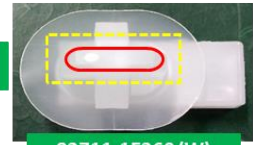
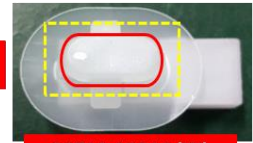
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PARTS:	1. Assy parts			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	Clip attachment 82711-1E360 (W)	 <p>CLAMP ORIENTATION</p> <p>1. Hold the connector using left hand, get the Clamp 82711-1E360 (W) then insert using right hand.</p>		n/a	<div>CLIP CLAMP ILLUSTRATION</div> <div>GOOD  82711-1E360 (W)</div> <div>NG  82711-12B10 (W)</div> <p>1. No wrong use of parts 2. No loose attachment</p>
	P1				

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1. Assy parts

JIG**n/a****QUALITY CHECKPOINTS****P1****7R0119-7020****① No Wrong Insert****③ No Wrong use of tape (Yellow tape)****② No Terminal Backing Out****④ No Missing clip clamp (1pc.)****⑤ No Deformed Terminal**

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