



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

April 12, 2021

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Product Name/Code:

780B



7R0104-7021

Customer:

TRMX

Document No.:

WI-ENG-PDE-204A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

- Connector 6189-1142 (W)
- AVSSf 0.3 Y L=490±3mm; OR wire L=490±3mm

JIG:

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

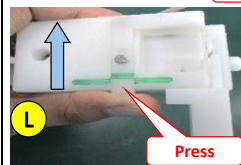
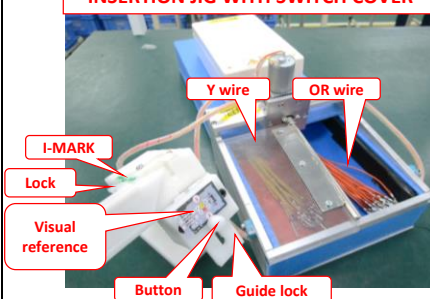
QUALITY POINTERS

1

P1

Connector setting to
insertion jig
6189-1142 (W)

INSERTION JIG WITH SWITCH COVER



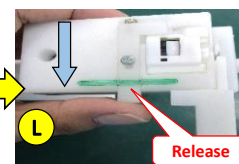
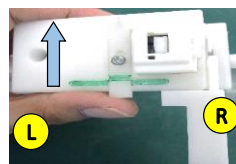
1. Press the lock of
insertion jig using
left thumb.



3. Press the guide using left
thumb. The slot for **Y wire** will
be opened.



INSERTION JIG ORIENTATION



2. Insert the connector **6189-1142 (W)** into jig using right hand
and release the lock.



CONNECTOR ORIENTATION

Safety Instruction

Be sure to wear
prescribed 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.

CONNECTOR ORIENTATION
ILLUSTRATION

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

Prepared by

Reviewed by

Approved by

Noted by

04/12/21

1

Change part number from 7R0104-7020B to 7R0104-7021 due to change of tape color from Black to Yellow tape in
process taping of vinyl tube to wire near connector. Change status from pre-launch to masspro. Removal of cover jig during
insertion of wires to COT. Transferring of process from P2 to P1.

M. Catapang

C. Villanueva

A. Shimamura

A. Arañes

12/04/20

0

Initial issue

M. Catapang

R. Peñaloza

A. Shimamura

A. Arañes

Eff. Date

Rev. No

Details of Change

Revised

Checked

Approved

Noted

Est. Date:

December 04, 2020

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PARTS:

n/a

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

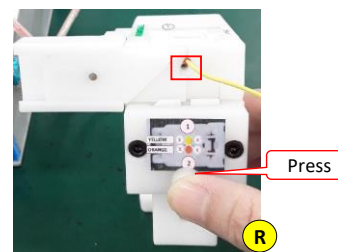
P1

Wire insertion to
connector
6189-1142 (W)

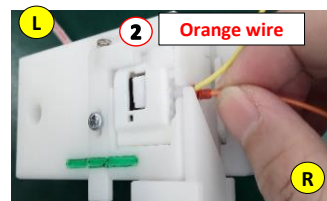
WIRE FACING



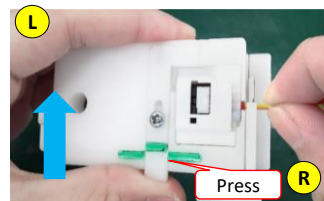
1. Hold the insertion jig using left hand. Get the **Y wire** and insert to connector using right hand.



2. Press the button using right thumb. The slot for **OR wire** will be opened.



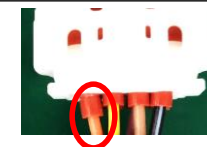
3. Get the **OR wire** and insert to connector using right hand.



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.

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

Note: Make sure wires are properly inserted.
Conduct **Pull-Push-Pull-Push** after insertion.
Do not exert extra force.

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PROTOTYPE



PRE-LAUNCH



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3 of 8**PARTS:**

1. Black corrugated tube (no slit) $\phi 7$ L=208 \pm 3mm
2. Black vinyl tube $\phi 5$ L=233 \pm 3mm
3. Assy parts

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Black corrugated tube (no slit) $\phi 7$ L= 208 \pm 3mm	 <div>1. Get the corrugated tube (no slit) $\phi 7$ L= 208\pm3mm using right hand then insert the Y-OR wires using left hand.</div>	n/a	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal
4	Wire insertion to Black vinyl tube $\phi 5$ L= 233 \pm 3mm	 <div>1. Get the vinyl tube $\phi 5$ L= 233\pm3mm using right hand then insert the Y-OR wires using left hand.</div>	n/a	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal

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PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Connector 6189-1161 (B)

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

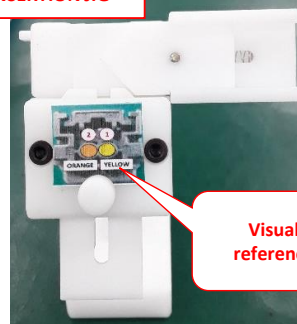
QUALITY POINTERS

5

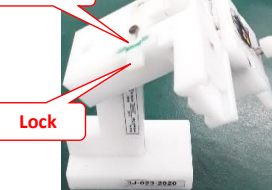
P1

Connector setting to
insertion jig
6189-1161 (B)

INSERTION JIG

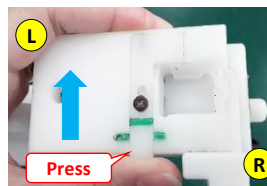
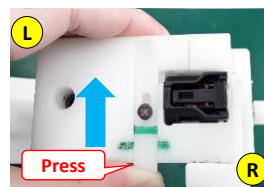
Visual
reference

I-MARK

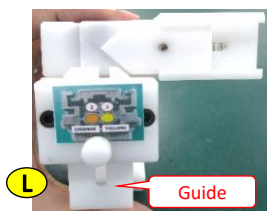


Lock

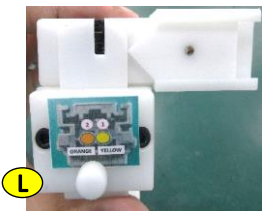
INSERTION JIG ORIENTATION

CONNECTOR
ORIENTATION1. Press the insertion jig
lock using left thumb.2. Get the connector 6189-1161 (B) using right hand and insert to
insertion jig. Release the lock after insertion.

Release



Guide

3. Press the guide using left
thumb. The slot for Y wire will
be opened.

n/a

CONNECTOR ORIENTATION
ILLUSTRATION

I-mark is align

1 hole is open



GOOD

I-mark is not
align

1 hole is open



NG

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION


TOOLS/PPE

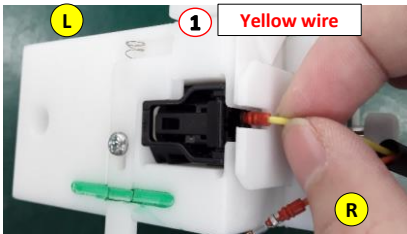
QUALITY POINTERS

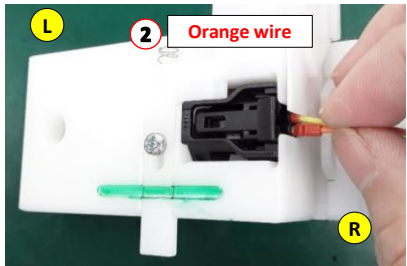
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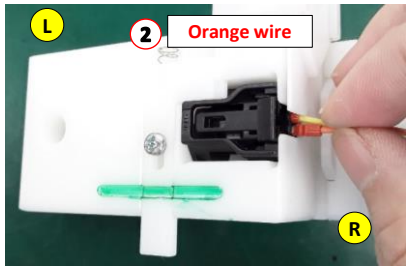
P1

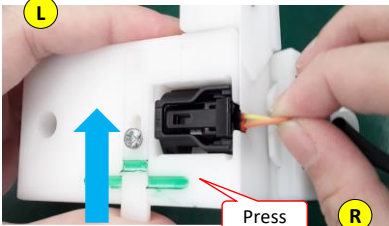
Wire insertion to
connector
6189-1161 (B)

 WIRE FACING

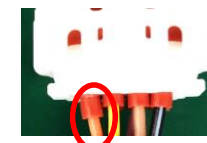
 1. Hold the insertion jig using left hand. Get the **Y wire** and insert to connector using right hand.

 2. Press the button using right thumb. slot for **OR wire** will be open.

 3. Get the **OR wire** and insert to connector using right hand.

 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.

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

Note: Make sure wires are properly inserted.
Conduct **Pull-Push-Pull-Push** after insertion.
Do not exert extra force.

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☐ PROTOTYPE

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PARTS:

1

1. Assy parts
2. Yellow tape

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

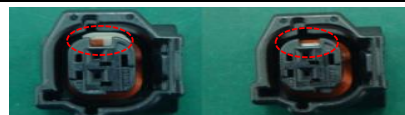
QUALITY POINTERS

7

Connector lock



1. Put the connector into locking using right hand and then press 2x using both hands.



Before Pressing

After Pressing



Unlock Condition

Half lock Condition

Full lock Condition

LOCKING JIG



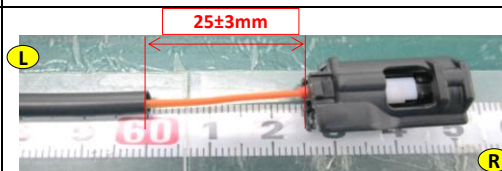
NOTE: MANUAL LOCKING MAY CAUSED DAMAGED CONNECTOR LOCK

1. Use the provided jig tool per model
2. No unlock/half-locked connector
3. No damaged lock

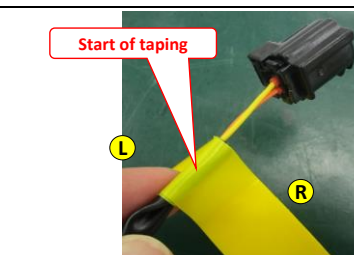
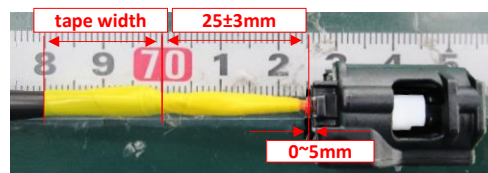
8

P1

Taping 1
Black vinyl tube to wire near connector



1. Hold the vinyl tube using left hand. Measure from end of vinyl tube up to connector 25±3mm using both hands.



2. Hold the vinyl tube using left hand. Get the Black tape using right hand and start taping process using both hands.

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

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

MEASURING TAPE



Note:
Set aside the assy part after assembly.

NOTE:
Use YELLOW TAPE only.

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

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

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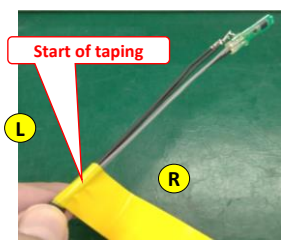
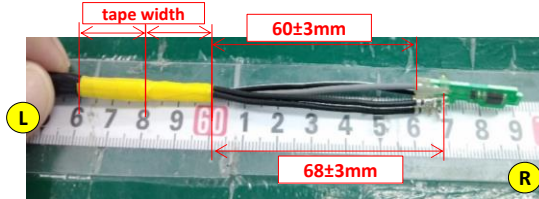

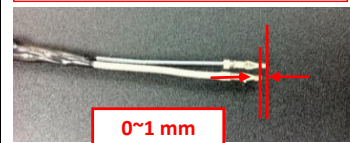
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PARTS:		1. Assy parts 2. MRSW CP A7475 7R0103-7040 TVSSf 0.3 B/W L=757±3mm; GR wires L=757±3mm 3. AVSSf 0.3 B/B wires L=756±3mm [2pcs.]		4. Black sunprene tube $\phi 5$ L=106±3mm 5. Black tape		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
1 9		 1. Get the GR-B/W hotmelted wires (MR SW CP) and B/B wires L=756±3mm using both hands then hold using left hand.  2. Get the sunprene tube $\phi 5$ L= 106±3mm using right hand then insert the GR-B/W hotmelted wires and B/B wires using left hand.			n/a	1. No wrong use of parts 2. No deformed terminal	
10	P1 Taping 2 Black sunprene tube to wire near terminal and hotmelted wires	 1. Hold the sunprene tube using left hand. Measure from end of sunprene up to the edge of hotmelted wires 80±3mm and up to terminal pointed tip 88±3mm using right hand.  2. Hold the sunprene tube using left hand. Get the Yellow tape using right hand then start taping process using both hands. Refer to WI-PRO-ASY-001 for taping procedure.  3. After taping, check the measurement, wire alignment and taping condition.			 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 Wire alignment tolerance  0~1 mm	

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PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:

1. Assy parts
2. Black corrugated tube (no slit) $\phi 7$ L= 355 \pm 3mm

**JIG**

n/a

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

11

Wire insertion to
Black corrugated tube
(no slit)
 $\phi 7$ L= 355 \pm 3mm



1. Hold the wires using left hand, get the corrugated tube (no slit) $\phi 7$ L= 355 \pm 3mm using right hand then insert the **GR-B/W hotmelted wires and B/B wires** using left hand.



n/a

**GOOD****NG**

1. No wrong use of parts
2. No deformed terminal

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