



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

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Validity Date:	n/a		
Document No.:	WI-ENG-PDE-310A		
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Process Name/Title:

Product Name/Code: 291B / 7L0037-7020

Customer: TRQSS

Purpose:

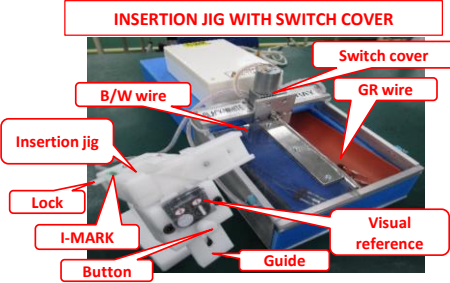
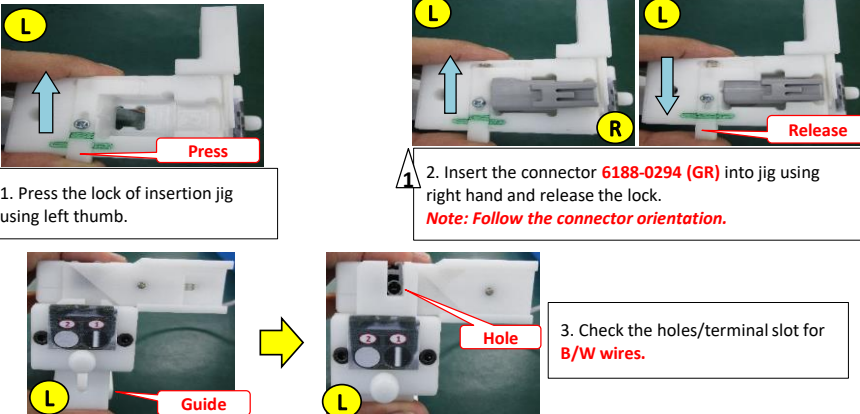
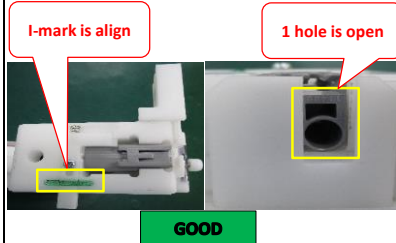
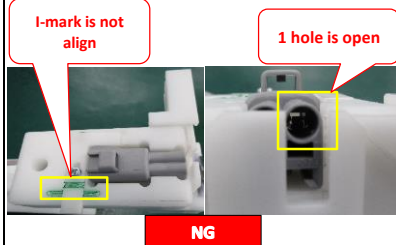
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

PARTS:

- Connector 6188-0294 (GR)
- AVSSf 0.3 B/W-GR wires L=776±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 1 6188-0294 (GR)	<p>INSERTION JIG WITH SWITCH COVER</p>  <p>CONNECTOR ORIENTATION</p>  <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 6188-0294 (GR) into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></p> <p>3. Check the holes/terminal slot for B/W wires.</p>	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Connector Orientation Illustration</p>   <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/17/21	1	Transfer process owner from Production (WI-PRO-ASY-049) to Engineering (WI-ENG-PDE-310A). Improve process illustration and quality pointers. Change connector color in accordance with color standardization for plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts).	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
07/10/17	0	Previously established as Production work instruction (WI-PRO-ASY-049). Initial issue	J. Montalvo	O. Merin	T. Sugiyama	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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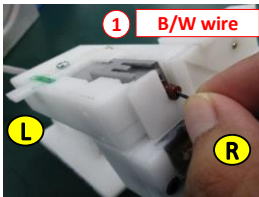
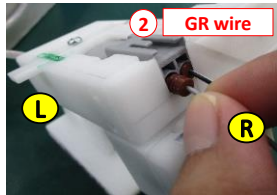

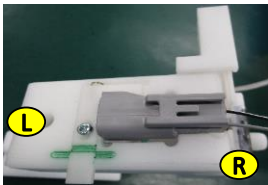
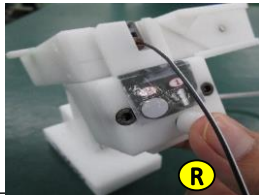
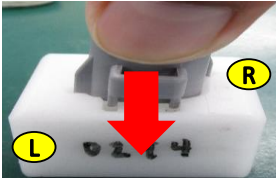




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PARTS:	n/a			JIG	1. Insertion jig with switch cover 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div>Wire insertion to connector 1 6188-0294 (GR)</div> <div>P1</div>	<div><div><div><div><div>1</div><div>B/W wire</div></div><div><div>L</div><div>R</div></div></div><div></div></div><div><div>1. Get the B/W wire then insert to terminal slot 1 using right hand.</div></div></div> <div><div><div><div>2</div><div>GR wire</div></div><div><div>L</div><div>R</div></div></div><div></div></div> <div><div>3. Get the GR wire then insert to terminal slot 2 using right hand.</div></div> <div><div><div><div><div>WIRE FACING</div></div><div></div></div></div><div><div><div><div>4</div><div>After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div></div><div><div>L</div><div>R</div></div></div><div></div></div></div> <div><div><div><div>2. After insertion of B/W wire, press the button using right thumb. The slot for GR wire will be opened.</div></div><div></div></div></div> <div>n/a</div> <td><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>1 Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div></td>		<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>1 Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>	
3	<div>Connector Lock</div> <div>1</div>	<div><div><div><div><div><div>1</div><div>Put the connector into locking jig using right hand then press 2x. Check the connector lock if properly locked.</div></div><div><div>L</div><div>R</div></div></div><div></div></div></div><div><div><div><div>Before Pressing</div><div>After Pressing</div></div><div></div></div></div><div><div><div><div><div>Coupler Cross Sectional View</div><div>NG NG GOOD</div><div>Double lock Double lock Double lock</div><div>Unlock Condition Half Lock Condition Full Lock Condition</div></div><div></div></div></div></div></div>		<div>LOCKING JIG</div> <div></div>	<div>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK</div> <div>1. Use the provided jig per model 2. No unlock/half-locked connector</div>

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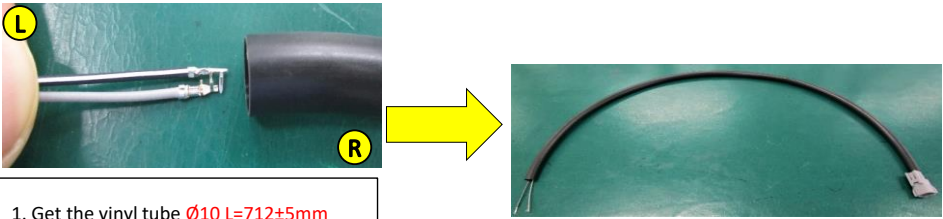

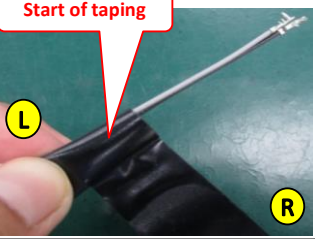
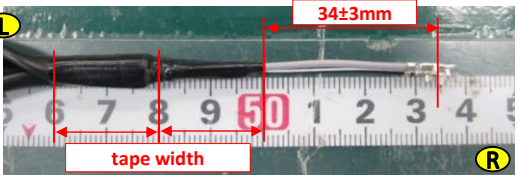

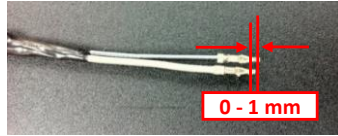
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PARTS:		1. Assy parts 2. Black vinyl tube Ø10 L=712±5mm			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	1 Wire insertion to Black vinyl tube Ø10 L=712±5mm	 <p>1. Get the vinyl tube Ø10 L=712±5mm using right hand and then insert the B/W-GR wires using left hand.</p>				1. No wrong use of parts
5	P1 1 Taping 1 Black vinyl tube to wire near terminal	 <p>1. Measure from end of the vinyl tube up to terminal pointed tip 54±3mm.</p>  <p>2. Hold the vinyl tube using left hand then start taping using right hand. Refer to WI-PRO-ASY-001 for taping procedure.</p>  <p>3. After taping, check the measurement, wire alignment and taping condition.</p>			 <p>MEASURING TAPE</p>	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension</p> <p>Wire alignment tolerance</p>  <p>0 - 1 mm</p>

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