



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

December 10, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number:

086D

/

7N0162-7020

Customer:

TRJ

Document No.:

WI-ENG-PDE-529A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

2

Page No.:

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PARTS:

1. All parts: Connector 6188-0407 (W); TVSSf 0.3 wires G-B/W L=599±3mm; Black Corrugated tube Ø5 L=448±4mm (no slit); Black Sunprene tube Ø9 L=97±3mm; Black tape [1pc]

JIG:

1. Insertion jig with switch cover
2. Locking jig
3. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<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 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</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	May 23, 2022
12/10/22	2	Improve quality pointers in all process. Inclusion of quality checkpoints.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	Prepared by	Reviewed by
06/03/22	1	Change document purpose from pre-launch to masspro	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	Reviewed by	Approved by
05/23/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes		

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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

2

P1

Connector setting to
Insertion jig
6188-0407 (W)

INSERTION JIG WITH FLIP COVER

Visual reference

Lock

Holes

I-mark

Switch cover

Insertion jig

CONNECTOR ORIENTATION

Press

Press

Release

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

I-mark is align

2 Holes are open

GOOD

I-mark is not align

All holes are open

NG

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=599±3mm

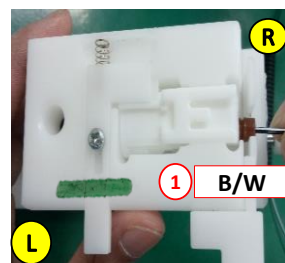
JIG

1. Insertion jig with switch cover

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****2 QUALITY POINTERS**

3

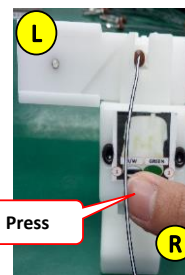
P1

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.

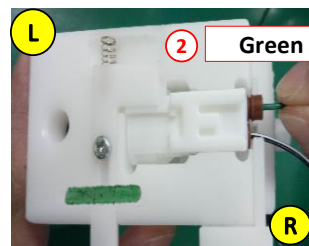


Wire facing



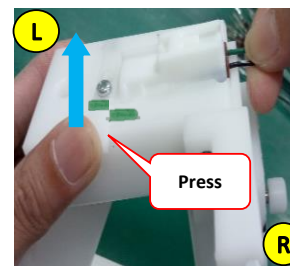
Press

2. Push the button using right hand. The slot for **Green wire** will be opened.



Green

3. Get the **Green wire** then insert to terminal **slot 2** using right hand.



Press

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.

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 Corrugated tube Ø5 L=448±4mm (no slit)

JIG

1. Locking jig
2. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

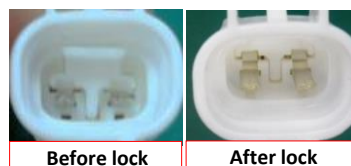
TOOLS/PPE

2 QUALITY POINTERS

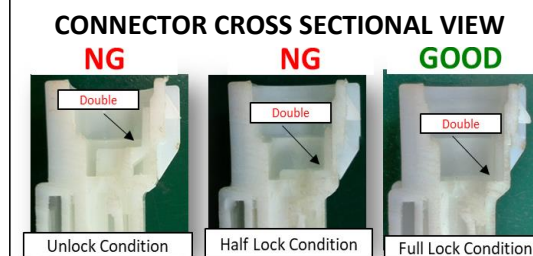
4

P1

Connector lock



1. Put the connector into locking jig using both hands then press **2x** using both hands. Touch the connector lock to confirm if properly locked.



LOCKING JIG

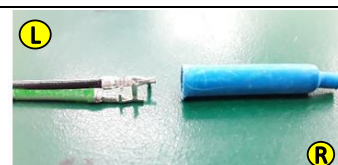


Important reminders/Note/s:
1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR

1. Use the provided locking jig per modle
2. No unlocked/half-locked connector
3. No damaged lock

5

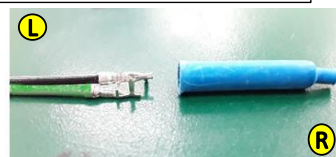
Wire insertion to Corrugated tube Ø5 L=448±4mm (no slit)



1. Get the terminal cover jig using right hand then insert the **G-B/W** wires using left hand.



2. Get the Corrugated **Ø5 L=448±4mm (no slit)** using right hand and insert the **G-B/W** wires using left hand



3. After insertion, remove the terminal cover jig using right hand.

TERMINAL COVER JIG



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

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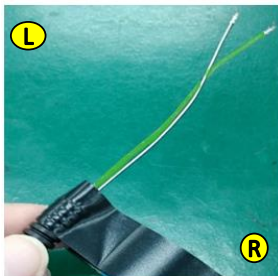
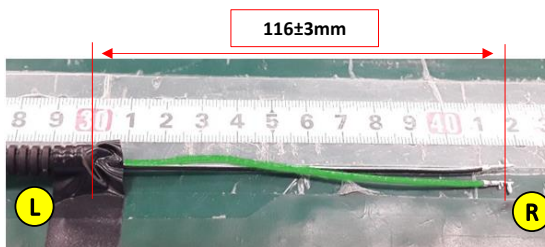
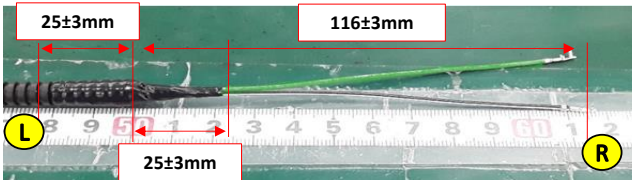

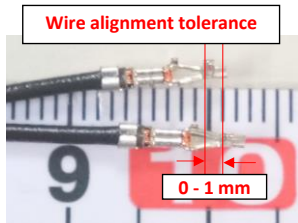

PARTS:

1. Assy parts
2. Black tape

3. Black Sunprene tube Ø9 L=97±3mm

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	2 QUALITY POINTERS
6	P1 Taping 1 COT to wire near terminal	 <p>1. Hold the COT using left hand get Black tape using right hand and conduct pre taping using both hands.</p>  <p>2. Measure the end of COT to terminal tip 116±3mm and continue taping process.</p>  <p>3. After taping, check the measurement, terminal appearance and taping condition.</p>	 <p>MEASURING TAPE</p>	 <p>Wire alignment tolerance 0 - 1 mm</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p>
7	Wire insertion to Black sunprene Ø9 L=97±3mm	 <p>1. Get the Black Sunprene tube Ø9 L=97±3mm using right hand and insert the G-B/W wires using left hand</p>	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. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

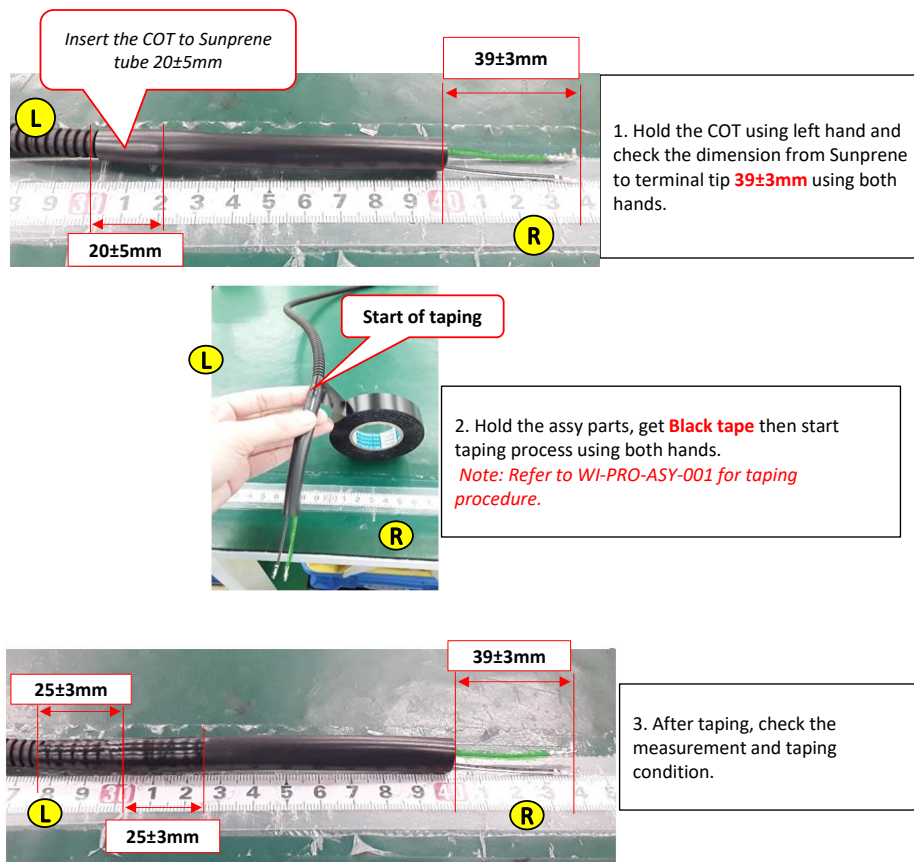
TOOLS/PPE

2 QUALITY POINTERS

8

P1

Taping 2
COT to Black sunprene
tube



MEASURING TAPE



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

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

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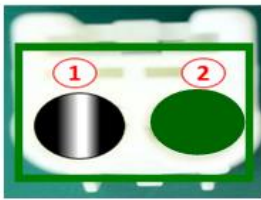
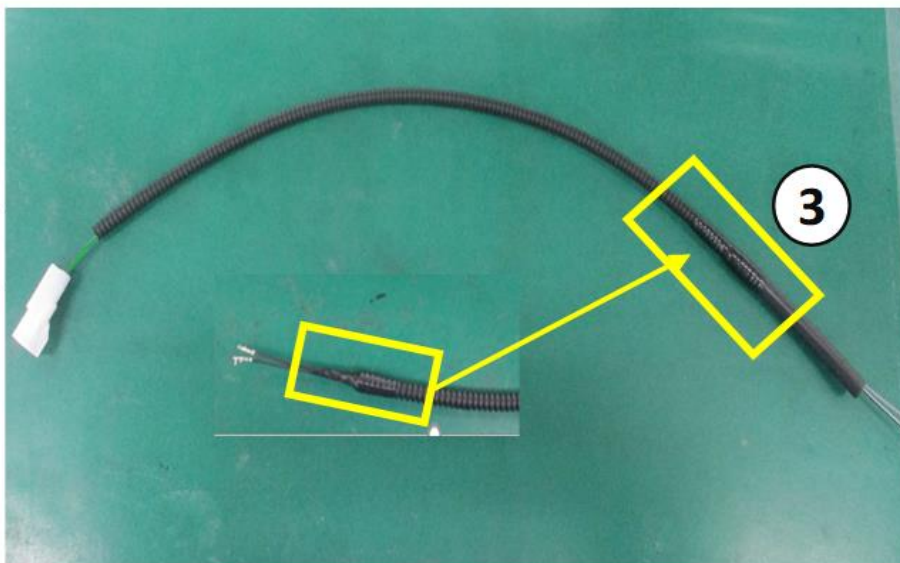
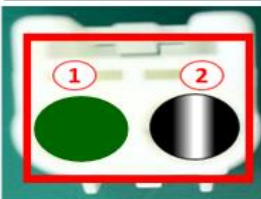
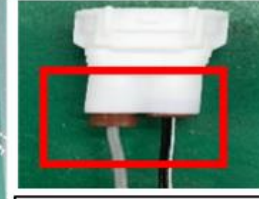
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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

**QUALITY CHECKPOINTS****P1****7N0162-7020****GOOD****GOOD****GOOD****GOOD****NO GOOD****NO GOOD****NO GOOD****NO GOOD**

- ① **No Unlock/
Halflocked
Connector**
- ② **No Wrong Insert**
- ③ **No Missing Tape**
(taping on COT-wire and
taping on sunprene tube)
- ④ **No Terminal Backing
Out**

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