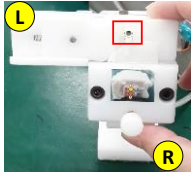
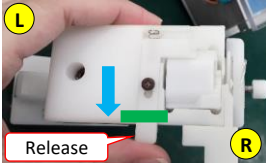
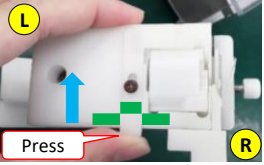
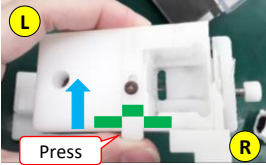

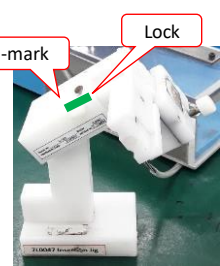
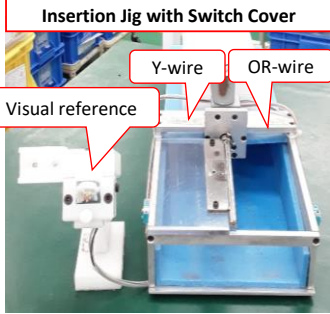



	WORK INSTRUCTION				Effectivity Date:		June 16, 2021	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Product Name/Code: 480A / A7045D		Customer: TRQSS		Document No.:		WI-ENG-PDE-298A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		4	Page No.: 1 of 7

PARTS:	1. Connector 6189-1142 (W)				JIG:	1. Insertion jig with switch cover				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS			
1	P1	<div>Connector setting to Insertion jig 6189-1142 (W)</div> <div></div> <div>1. Press the insertion jig lock using left hand.</div> <div>2. Get the connector 6189-1142 (W) using right hand and insert to insertion jig. Release the lock after insertion.</div> <div>3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.</div>				<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>CONNECTOR ORIENTATION ILLUSTRATION</div> <div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector</div>			

Revision History						Prepared by	Reviewed by	Approved by	Noted by
06/16/21	4	Transfer process owner from Production (WI-PRO-ASY-010A) to Engineering (WI-ENG-PDE-298A); Change the process illustration				J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes
07/30/19	3	Change wire color procedure/coupler insertion (6189-1161)				J. Silang	W. Carbillon	O. Merin	n/a
07/01/19	2	Include the Process Distribution/ Include Insertion Jig				J. Silang	A. Morcozo	O. Merin	n/a
07/10/17	n/a	Initial issue				J. Montealto/ L. Briones	O. Merin	T. Sugiyama	n/a
Eff. Date	Rev. No	Details of Change				Revise	Check	Approve	Noted
						Est. Date:	July 10, 2017		

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Purpose:



PROTOTYPE



PRE-LAUNCH



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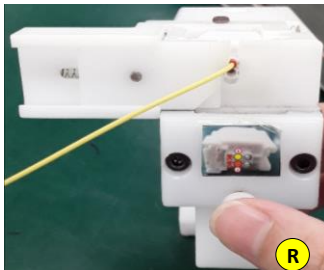
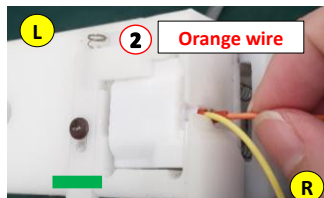
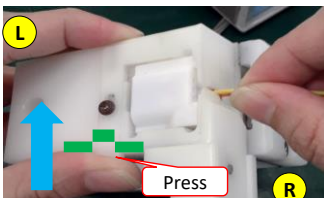
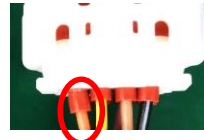
2 of 7

PARTS:

1. AVSSf 0.3 wires Y L=828mm, OR L=828mm

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Wire Insertion to connector 6189-1142 (W)	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the Yellow wire and insert to terminal slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb. slot for Orange wire will be open.</p></div> <div><p>3. Get the Orange wire and insert to terminal slot 2 using right hand.</p></div> <div><p>4. After insertion, press the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>	n/a	<div><p>Note: During insertion, hold the wire not <u>rubber seal</u> to prevent sagging.</p></div>  <div><ol style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deformed terminal5. No wrong wire facing<p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p></div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **480A / A7045D**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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n/a

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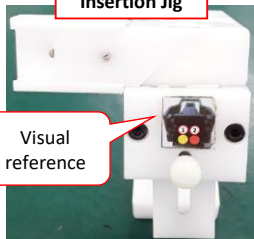
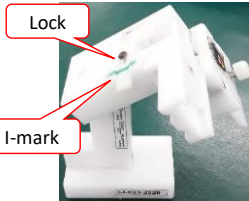

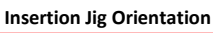
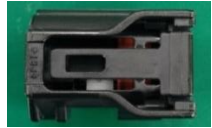
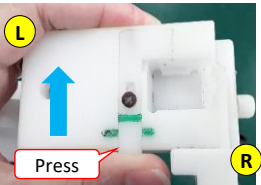
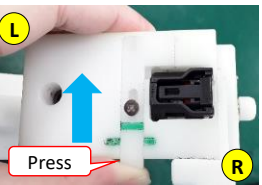
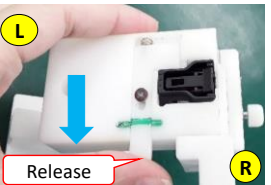
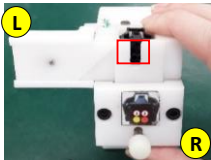


PARTS:

1. Black Corrugated tube $\phi 7$ L= 730 \pm 3mm (no slit)
2. Black Corrugated tube $\phi 7$ L= 68 \pm 3mm (no slit)

3. Connector 6189-1161 (B)

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to COT $\phi 7$ L= 730 \pm 3mm (no slit) and $\phi 7$ L= 68 \pm 3mm (no slit)	  <div>1. Get the corrugated tube $\phi 7$ L= 730\pm3mm using right hand then insert the yellow wire and orange wire by using left hand.</div> <div>2. Get the corrugated tube $\phi 7$ L= 68\pm3mm using right hand then insert the yellow wire and orange wire by using left hand.</div>	n/a	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal
4	P1 Connector setting to Insertion jig 6189-1161 (B)	        <div>1. Press the insertion jig lock using left hand.</div> <div>2. Get the connector 6189-1161 (B) using right hand and insert to insertion jig. Release the lock after insertion.</div> <div>3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.</div>	 <div>3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.</div>	<div>CONNECTOR ORIENTATION ILLUSTRATION</div>   <div>1. Use the provided jig per model</div> <div>2. No wrong orientation of connector</div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code:

480A / A7045D

Customer:

TRQSS

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. Assy parts 1

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

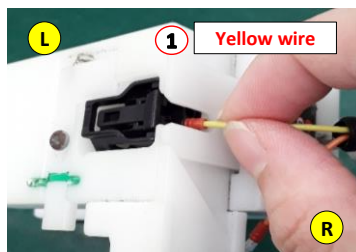
5

P1

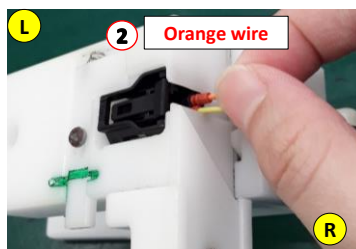
Wire insertion to connector 6189-1161 (B)



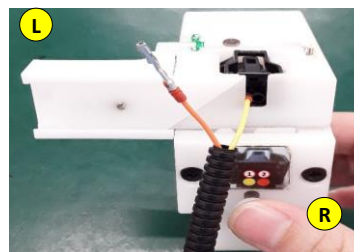
Wire facing



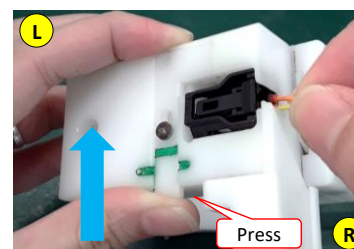
1. Hold the insertion jig using left hand. Get the **Yellow wire** and insert to terminal slot 1 using right hand.



3. Get the **Orange wire** and insert to terminal slot 2 using right hand.



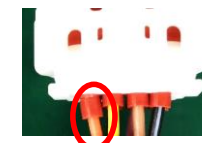
2. Press the button using right thumb. slot for **Orange wire** will be open.



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

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

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

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Purpose:



PROTOTYPE



PRE-LAUNCH



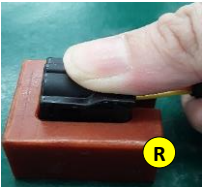
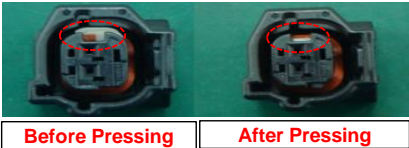



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PARTS:	1. Black Vinyl tube $\phi 5$ L= 170 \pm 3mm 2. A7475-A7045C1-7040 (GR and B/W wires)			JIG	1 . Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Connector lock	<div> 1. Put the connector into locking jig and push down to lock using right thumb.</div> <div> Before Pressing After Pressing</div> <div> NG NG GOOD Unlock Condition Half lock Condition Full lock Condition</div>		Locking Jig 	1. No unlock/Half-locked connector 2. No damaged lock
7	Wire insertion to Vinyl tube $\phi 5$ L= 170 \pm 3mm	<div> 1. Hold the Vinyl tube $\phi 5$ L= 170\pm3mm using left hand. Get the wire A7475-A7045C1-7040 (GR and B/W) and insert to Vinyl tube using right hand.</div>		n/a	1. No wrong use of parts

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☐ PROTOTYPE

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PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

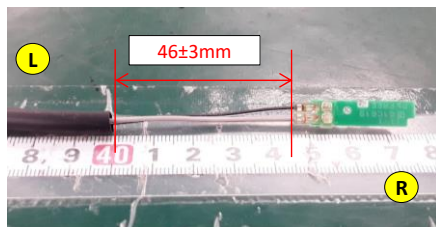
TOOLS/PPE

QUALITY POINTERS

8

P1

Taping
Vinyl tube to wire near
PCB



1. Hold the Vinyl tube using left hand. Measure the end of the Vinyl tube up to the edge of Hotmelt $46\pm3\text{mm}$ using right hand.

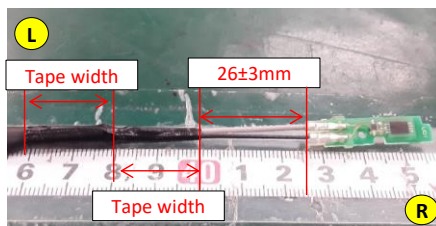


2. Hold the vinyl tube using left hand then start taping using right hand.
Refer to WI-PRO-ASY-001 for taping procedure.

MEASURING TAPE



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



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

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PARTS:		1. Black Corrugated tube $\phi 7$ L= 130 \pm 3mm (no slit) 2. Assy parts			JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
9	P1	Wire insertion to Black Corrugated tube $\phi 7$ L= 130 \pm 3mm (no slit)	<div><p>1. Get the corrugated tube $\phi 7$ L= 130\pm3mm using left hand then insert the wire A7475-A7045C1-7040 (GR and B/W) using right hand.</p></div>	n/a	1. No wrong use of parts	
10		Wire insertion to assy parts	<div><p>COT $\phi 7$ L= 730\pm3mm</p><p>1. Get the assy parts 1 using left hand. Insert the GR and B/W wire from assy parts 2 in COT $\phi 7$ L= 730\pm3mm using right hand.</p></div>	n/a	1. No wrong insertion to COT	

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