

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

April 24, 2023

Validity Date:

n/a

Model Code/Part Number:

**780B / 7R0105-7023A**

Customer:

**TRMX**

Document No.:

**WI-ENG-PDE-569A**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

Page No.:

1 of 7

**PARTS:**

1. All parts: Connector 6188-0407 (W); TVSSf 0.3 wires G-B/W L=583mm±3mm; Black Corrugated tube Ø5 L=188±3mm (no slit); Black Sunprene tube Ø5 L=325±3mm; Black tape [1pc.]

JIG:

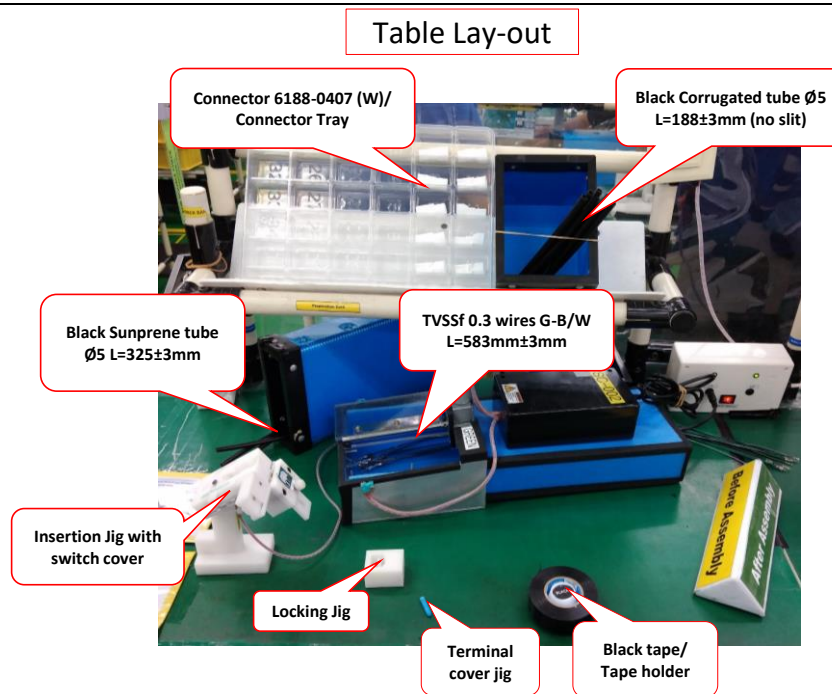
1. Insertion jig with switch cover
2. Locking jig
3. Terminal cover jig

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

1

P1

Table Lay-out

**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.

**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**

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
04/24/23	4	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a					
11/04/22	3	Correction of measurement from COT and sunprene tube to wire near terminal from 184±3mm to 384±3mm in process no.8.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
10/14/22	2	Improve quality pointers and notes in process no.1,3,4,7 and 8 as document improvement.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
07/26/22	1	Change: Document purpose from pre-launch to masspro. Table lay-out illustration. Additional process no.8 from P2 to P1. Transferring of clip clamp type attachment to P2.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes		J. Loterte	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:				

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☒ MASSPRO

Revision No.:

4

Page No.:

2 of 7

### PARTS:

1. Connector 6188-0407 (W)

### JIG

1. Insertion jig with flip 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

Connector ORIENTATION

Insertion jig

Switch cover

**L**

**R**

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

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 orientation of connector
3. No wrong use of connector
4. No damaged connector

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Revision No.:

4

Page No.:

3 of 7

## PARTS:

1. TVSSf 0.3 G-B/W wires L=583mm±3mm

## JIG

1. Insertion jig with switch cover

## NO.

## PROCESS NAME

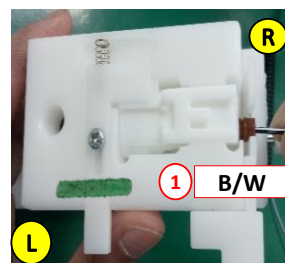
## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

## QUALITY POINTERS

3

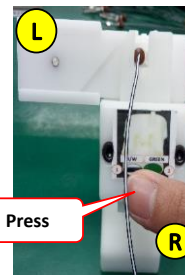
P1

Wire Insertion 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.

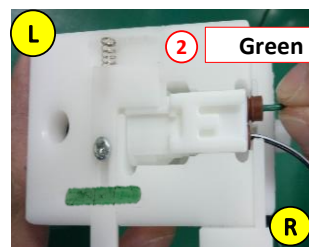


Wire facing



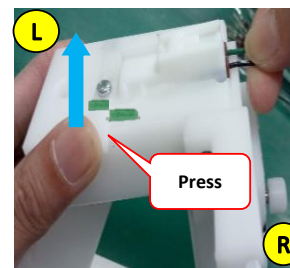
Press

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



2 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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4

Page No.:

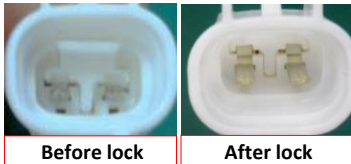
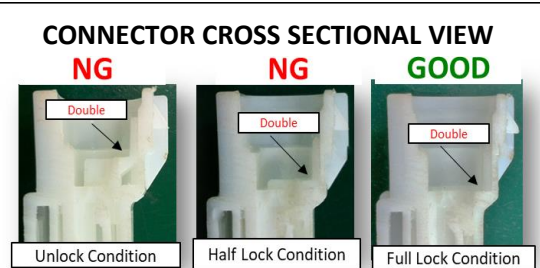

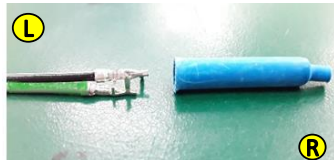



4 of 7

### PARTS:

1. Assy parts
2. Black Corrugated tube Ø5 L=188±3mm (no slit)

### JIG

1. Locking jig
2. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Connector lock	 <p><b>CONNECTOR CROSS SECTIONAL VIEW</b></p>  <p>1. Put the connector into locking jig using right hand then press <b>2x</b>. Touch the connector lock if properly locked.</p>	<p><b>LOCKING JIG</b></p> 	<p><b>Important reminders/Note/s:</b></p> <p><b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></p> <ol style="list-style-type: none"><li>1. Use the provided locking per model</li><li>2. No unlock/half-locked connector</li></ol>
5	Wire insertion to Corrugated tube Ø5 L=188±3mm (no slit)	 <p>1. Get the terminal cover jig using right hand then insert the <b>G-B/W wires</b> using left hand.</p>  <p>2. Get the Corrugated <b>Ø5 L=188±3mm (no slit)</b> using right hand and insert the <b>G-B/W wires</b> using left hand.</p>  <p>3. After insertion, remove the terminal cover jig using right hand.</p>	<p><b>TERMINAL COVER JIG</b></p> 	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No deformed terminal</li></ol>

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Revision No.:

4

Page No.:

5 of 7


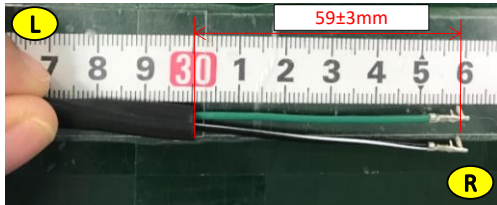
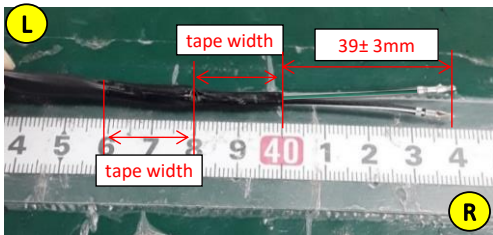
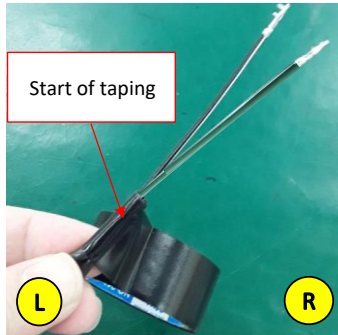

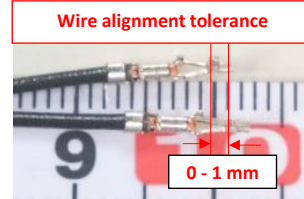
**PARTS:**

1. Assy parts
2. Black Sunprene tube Ø5 L=325±3mm

3. Black tape

**JIG**

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Wire insertion to Sunprene tube Ø5 L=325±3mm	 <p>1. Get the Black Sunprene tube <b>Ø5 L=325±3mm</b> using right hand and insert the <b>G-B/W</b> wires using left hand</p>	n/a	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No deformed terminal</li></ol>
7	P1 Taping 1 Black sunprene tube to wire near terminal	 <p>1. Hold the sunprene tube using left hand and measure from end of sunprene tube up to terminal pointed tip <b>59±3mm</b> using both hands.</p>  <p>2. Hold the Sunprene tube using left hand. Get the <b>Black tape</b> using right hand and begin taping process using both hands</p> <p>3. After taping, check the measurement, terminal alignment and taping condition.</p>	 <p><b>MEASURING TAPE</b></p> 	 <ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong use of tape</li><li>6. No wrong dimension</li></ol> <p><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p>

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☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

4

Page No.:

6 of 7

### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

8

P1

Taping 2  
Black COT and Black  
sunprene tube near  
terminal



1. Measure the end of the corrugated tube up to the end of the terminal pointed tip **384±3mm** using both hands.



2. Get the **Black tape** using right hand. Hold corrugated tube using left hand then start taping using both hands.



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

MEASURING TAPE



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

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

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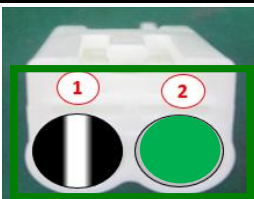
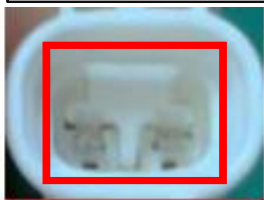
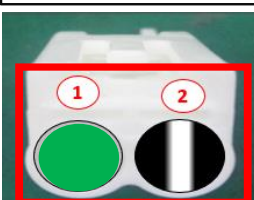
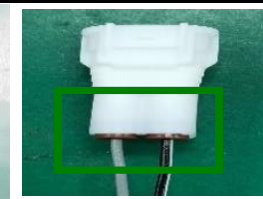
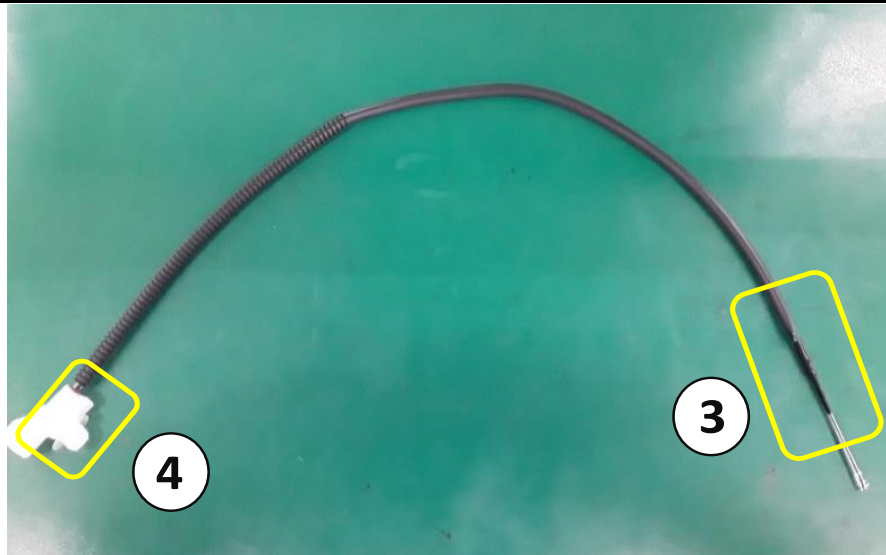
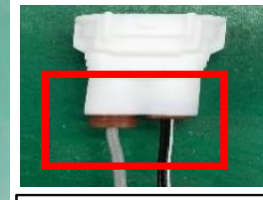
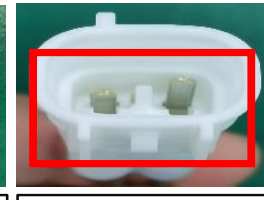
7 of 7

**PARTS:**

1. Assy parts

**JIG**

n/a

**QUALITY CHECKPOINTS****P1****7R0105-7023A****GOOD****GOOD****NO GOOD****NO GOOD****GOOD****GOOD****NO GOOD****NO GOOD****1** No **Unlock**  
**Connector****2** No **Wrong Insert****3** No **Missing Tape****4** No **Missing Clip Clamp****5** No **Terminal Backing**  
**Out**

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