			WORK INSTR	UCTION		Effectivity Date:	June 22, 2021	
		Process Name/Title:		SSEMBLY PROC	ESS	Validity Date:	n/a	
		Product Name/Code:	100B / 7M0594-7020D	Customer:	TRJ	Document No.:	WI-ENG-PDE-286A	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	4 Page No.: 1 o	of 11
<u> </u>		I					<u> </u>	
PARTS:		nector 6188-0066 (GR) Sf 0.3 Y/OR wire L=376±2r	mm			JIG:	Insertion jig with switch cover	
NO.	Р	ROCESS NAME	WORK PRO	CEDURE/ ILLUSTR	ATION	TOOLS/PPE	QUALITY POINTERS	
1	P1	Connector setting to insertion jig 6188-0066 (GR)	Insertion Jig With SWITCH COVER Switch cov V-wire jig I-Mark Visure reference Holes Press 1. Press the lock of insertion jig using left thumb.	2. Insert the connector right hand and releas Note: Follow the con	CONNECTOR ORIENTATION R Release or 6188-0066 (GR) into jig using	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 hole ope Good I-mark is not align 2 holes a 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	e is
	T (Revision History	0004) Ohaana aana i		Prepared by Re	eviewed by Approved by Not	ted by
06/22/21 4	color in		on (WI-PRO-ASY-122A) to Engineering (WI-ENG-PDE- dization for plastic parts (Refer to GL-COM-003). Apply		M. Catapang C. Villanueva A. Shimamura	A. Arañes	to:#(0-t) (a	
03/17/20 3		insertion jig/change illustration	•		J. Silang A. Morcozo O. Merin	MIM ENTRY C	fill Sunk	179
04/10/18 n/a Eff. Date Rev. N		sly established as Engineering	instruction (EI-ENG-PDE-030). Initial issue Details of Change		D. Castilo R. Alcantara A. Arañes Revised Checked Approved		VHrandeva A. Shimamura A. A 10, 2018	izañes .
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	Product Name/Code:	100B / 7M0594-7020D	Customer: TRJ	Document No.:	WI-ENG-PDE-286A
	Purpose:	☐ PROTOTYPE [PRE-LAUNCH MASSPRO	Revision No.:	4 Page No.: 2 of 11
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	 Assy parts Black Corrugated tube (no slit) Black Corrugated tube (no slit) 			JIG	Insertion jig with switch cover
NO.	PROCESS NAME		DURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to connector 4\(6188-0066 (GR) \)	1. Get the Y wire then insert to terminal slot 1 using right hand. 2 Orange R 3. Get the OR wire then insert to terminal slot 2 using right hand.	2. Press the button using right thumb. The slot for OR wire will be opened. 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 A Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
3	Wire insertion to Black Corrugated tube (no slit) \$\phi T = 92 \pm 3mm\$ \$\phi 5 L = 201 \pm 3mm\$	then in orange 2. Get the first state of the state of th	the corrugated tube (no slit) 92±3mm using right hand nsert the yellow wire and e wire by using left hand. the corrugated tube (no slit) 201±3mm using right hand sert the yellow wire and wire by using left hand.	01±3mm n/a	No wrong use of parts No deformed terminal

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PARTS: 1. Conn		ector 6189-1161 (B)						JIG	1. Inserti	on jig	
NO.	PROCESS NAME WORK PROCEDURE/ ILLUSTRATION				ATION	TOOLS/I	PPE	Ql	JALITY PO	INTERS	
4	P1	Connector setting to insertion jig 6189-1161 (B)	1. Press the lock of in using left thumb.	Visual reference Button Wire Guide Press sertion jig 2. I right	ht hand and release the ote: Follow the connecte	Release 189-1161 (B) into jig using e lock.	n/a		I-mar alig	GOOD k is ign NG ne provided jig	2 Holes are opened per model n of connector nnector

				WORK INSTRUC	CTION			Effectivity Date:		June 22	, 2021
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PARTS:	1. Assy parts	s							JIG	Insertion jig Locking jig	
NO.	NO. PROCESS NAME			WORK PROCE	DURE/ ILL	USTRATION		TOOLS/	PPE	QUALITY P	OINTERS
5	4	Wire insertion to connector 6189-1161 (B)	1. Hold the Y wire ther slot 1 using right hand. 3. Hold the OR wire the slot 2 using right hand.	Orange R en insert to terminal			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 insertior 3. One by one inserti 4. No deformed term 5. No wrong wire fac Note: Make sure w inserted. Conduct Pull-Push-linsertion. Do not exert extra f	n on inal ing ires are properly Pull-Push after
6	4	Connector Lock	1. Put the connector in using both hands and t Check the connector if	nto locking jig	DRE PRESSING FER PRESSING	NG Unlock Condition	NG GOOD Half Lock Condition Full Lock Condition	LOCKING	i JIG	NOTE: MANUAL LO CAUSED DAMAGED 1. Use the provided le model 2. No unlock/half-loc	ocking jig per

				WORK INSTRUC	TION		Effectivity Date:	June 22, 2021
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PARTS:	1. Assy 2. Black						JIG	n/a
NO.	Pl	ROCESS NAME		WORK PROCE	DURE/ ILLU	STRATION	TOOLS/PPE	QUALITY POINTERS
7	P1	Taping 1 Black Corrugated tube to wire near connector	L 8 9 5 0	28±2mm 28±2mm Note: 3*8mm -> End tape u connector (in rubber seal)	then sta	the corrugated tube using left hand art taping using both hands. 2. Measure from end of the corrugated tube up to connector 28±2mm. Note: Refer to WI-PRO-ASY-001 for taping procedure 3. After taping, check the measurement and tape condition.	MEASURING TAPE 6 7 8 9 10 1 2 3 4 5 6 7 8 9 10 1 2	Note: 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 dimension 6. No wrong use of tape

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PARTS:	1. MRSW CF 2. Assy parts	P 7M0593-7050A GR- s	·B/W wires L=	=685±3m	m					JIG	1. Termi	nal cover jig		
NO.	PROC	CESS NAME			WORK PROCE	DURE/ ILLUS	STRATION		TOOLS/	n/a WI-ENG-PDE-286A 4 Page No.: 6 of 11 JIG 1. Terminal cover jig S/PPE QUALITY POINTERS			S	
8	P1 Wi	ire insertion to assy parts			φ5 L=201±3mm ±3mm 2. Hold the COT (no slit) φ7 MRSW CP GR-B/W wires L=	R using both using right	left hand then inserting the sertion, remove the		TERMINAL CO		2. No da 3. No ex	maged rubb posed rubbe	er seal	g

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PARTS:	1. Assy	parts				JIG	1. Insertion jig
NO. PR		ROCESS NAME	WORK	PROCEDURE/ ILLUSTRAT	TION	TOOLS/PPE	QUALITY POINTERS
10	P1	Connector setting to insertion jig 6188-0066 (GR) (Assy parts)	Press 1. Press the lock of insertion jig using left thumb.	wire using right hand. Note: Follow the connector o	CONNECTOR ORIENTATION Release Occopientation. 3. Press the guide using left thumb. The slot for B/W wire will be opened.	n/a	Connector Orientation Illustration I-mark is align 1 Hole is open GOOD 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. Assy parts			JIG	Insertion jig Locking jig
NO.	PROCESS NAME	WORK PRO	CEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	Wire insertion to connector 6188-0066 (GR) (Assy parts)	1 Hold the B/W wire then insert to terminal slot 1 using right hand. 2 Gray 3. Hold the GR wire then insert to terminal slot 2 using right hand.	2. Press the button using right thumb. The slot for GR wire will be opened. 4. After insertion, push the lock using left thumb 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 Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
12	Connector Lock	1. Put the connector into locking jig using both hands and then press 2x. Check the connector if properly locked.	Coupler Cross Sectional View NG NG GOOD Before pressing Unlock Half Lock Condition Full Lock Condition	LOCKING JIG	NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK 1. Use the provided locking jig per model 2. No unlock/half-locked connector

			V	VORK INSTRUC			Effectivity Date:	June 22, 2021
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PARTS:	 Assy Black Black 		55 L=163±3mm	4. AVSSf 0.3 B/B v	wires L=749±3mm		JIG	n/a
NO.		ROCESS NAME		WORK PROCE	DURE/ ILLUSTRATIO	N	TOOLS/PPE	QUALITY POINTERS
12	P1	Wire insertion to connector 6188-0066 (GR)	1. Hold the corrugated tube hand then start taping usin 28±2 tape width	e using left g right hand.	and tape cond	for taping procedure	MEASURING TAPE 6 7 8 9 10 1 2 3 4 5 6 7 8 9 10 1 2	Note: 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 dimension 6. No wrong use of tape
13	2	Wire insertion to Black Corrugated tube (no slit) \$\phi 5 L=163\pm 3mm\$	L	R	1. Get the COT (no slit) ф5 L hand then insert the B/B wi hand.	=163±3mm using right res L=749mm using left	n/a	No wrong use of parts No deformed terminal

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PARTS:	1. Conn	ector 6098-3802 (W)						JIG	1. Insertion jig	
NO.	PF	ROCESS NAME		WORK PROCE	DURE/ ILLUS	STRATION	TOOLS/	PPE	QUALITY POINTERS	
14	P1	Connector setting to insertion jig 6098-3802 (W)	Lock Lock 1. Press the lock of in left thumb.	Press sertion jig using 2. th	Insert the connect en release the lock ote: Follow the con	CONNECTOR ORIENTATION CONNECTOR ORIENTATION Release or 6098-3802 (W) into jig using right hand innector orientation. Obles for B/B wires.	n/a		Connector C Illustra I-mark is align I-mark is not align NG 1. Use the provided 2. No wrong orientat 3. No wrong use of 4. No damaged contact 4. No damaged contact 5.	2 Holes are open 2 Holes are open 2 Holes are open ijig per model tion of connector connector

	_			WORK INSTRUC	TION		Effectivity Date:		June 22, 2021
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PARTS:	n/a							JIG	1. Insertion jig
NO.	PI	ROCESS NAME		WORK PROCE	DURE/ ILLUSTRA	TION	TOOLS/	PPE	QUALITY POINTERS
15	P1	Wire insertion to connector 6098-3802 (W)	using right hand	Black wire then insert to terminal slot and the slot of wire must be from left to right R	2 using right hand 2 using right hand 3. After insertion, push t	2 Black wire then insert to terminal slot	n/a		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.