

**WORK INSTRUCTION**Process Name/Title: **KITTING ASSEMBLY PROCESS**Product Name/Code: **900B / 7N0114-7020A** Customer: **TRQSS**Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

July 17, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-273

Revision No.:

1

Page No.:

1 of 4**PARTS:**

1. All parts (Connector 6189-0451 (W); AVSSf 0.3 Y-OR wires L=328±2mm; Black vinyl tube Ø7 L=57±3mm)

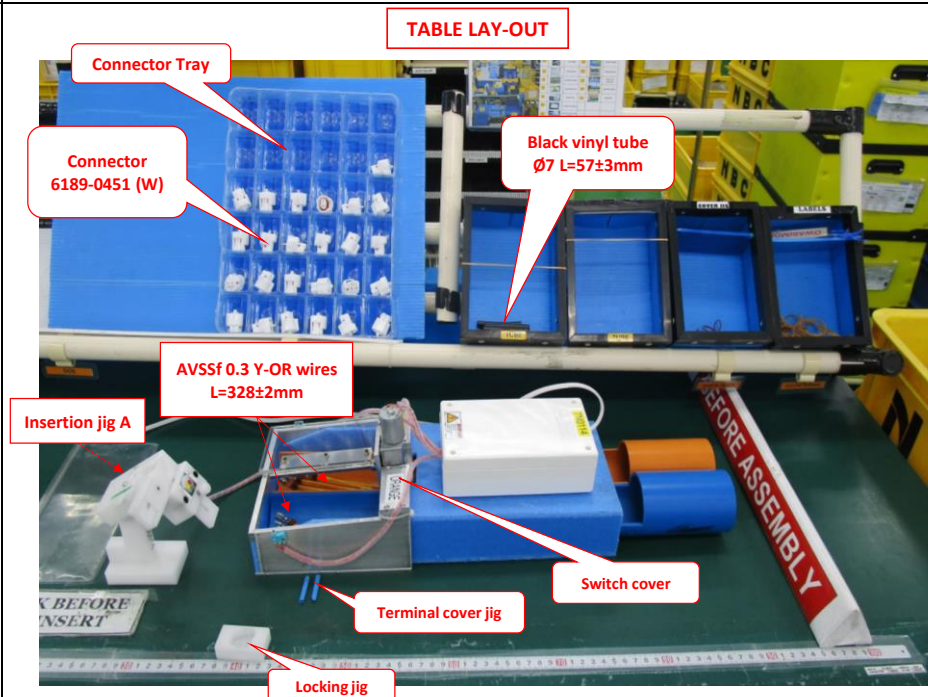
JIG:

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

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

1

Table Lay-out

**Safety Instruction**

Be sure to wear required 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

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools
3. No wrong position of parts/tools

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	Removal of validity date. Change document status from pre-launch to masspro.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
07/12/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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PARTS:

1. Connector 6189-0451 (W)

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME

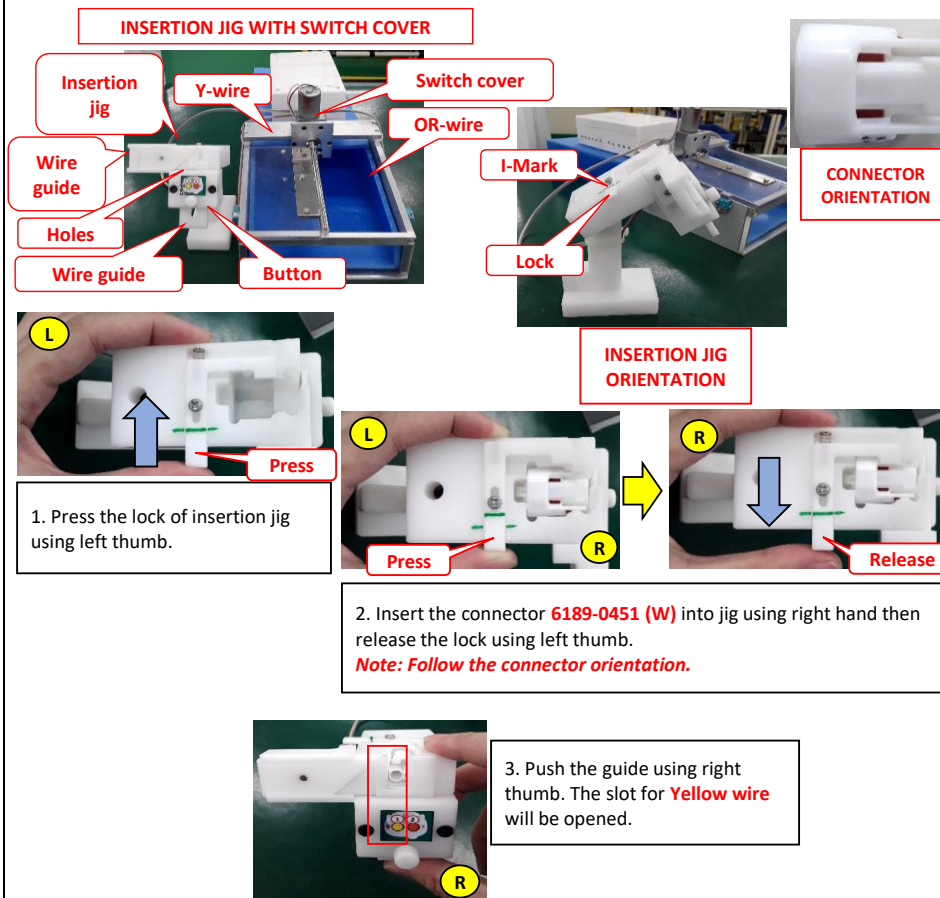
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

Connector setting to
insertion jig
6189-0451 (W)



n/a



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. AVSSf wires Y and OR L=328±2mm

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

Wire insertion to connector 6189-0451 (W)

WIRE FACING

Orange wire

Orange wire slot

Button

Yellow

Orange

1. Hold the insertion jig using left hand, get **Yellow wire** and insert to connector slot **1** using right hand.

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

3. Hold the insertion jig using left hand, get **Orange wire** and insert to connector slot **2** using right hand.

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: Please hold the wire near terminal during insertion.

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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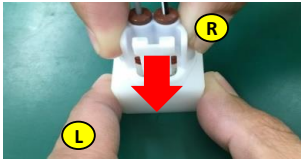
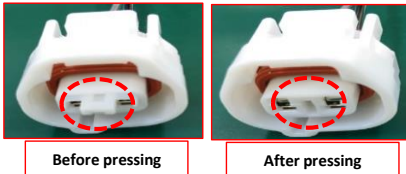




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PARTS:		1. Assy parts 2. Black vinyl tube Ø7 L=57±3mm			JIG	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	Connector lock	 1. Put the connector into locking jig using right hand then press 2x . Touch the connector lock if properly locked.			 LOCKING JIG	NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK. 1. Use the provided locking jig per model 2. No unlock/half-lock connector
5	Wire insertion to Black vinyl tube Ø7 L=57±3mm	 1. Get the cover jig then insert to Y-OR wires using right hand.  2. Get the vinyl tube Ø7 L=57±3mm using right hand then insert the Y-OR wires using left hand.  3. After insertion, remove the cover jig using right hand.			 TERMINAL COVER JIG	1. No wrong usage of parts 2. No damaged rubber seal

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