



WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	November 12, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-184A		
Revision No.:	3	Page No.:	1 of 5

Process Name/Title:

Model Code/Part Number: **150B** / **3** **7L0060-7022**

Customer:

TRQSS

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

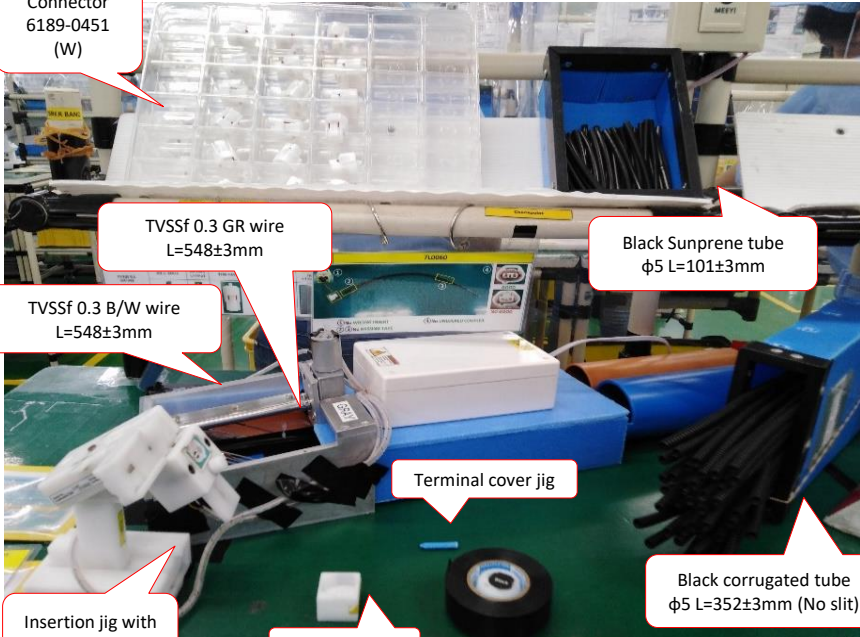
☒ MASSPRO

PARTS:









1. Assy parts; Black corrugated tube $\phi 5$ L=352 \pm 3mm (No slit); Black Sunprene tube $\phi 5$ L=101 \pm 3mm TVSSf 0.3 B/W wire L=548 \pm 3mm; TVSSf 0.3 GR wire L=548 \pm 3mm;

JIG:

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

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out	<p>Table Lay-out</p> 	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Established Date:	Prepared by:	Checked by:	Approved by:	Noted by:
11/12/21	3	Change part number from 7L0060-7021 to 7L0060-7022 due to additional clamp (82711-60640 (B) (Refer to WI-ENG-PDE-184B). Improve work procedure and illustration. Additional table lay-out, checkpoint in checking of wire tolerance.	K. Doria	J. Loterte	C. Villanueva	A. Arañes					
05/18/21	2	Remove validity date. Add tape quantity.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes					

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PARTS:

1. Connector 6189-0451 (W)

JIG

1. Insertion jig with flip cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

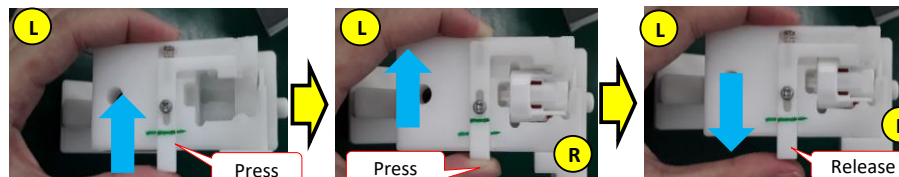
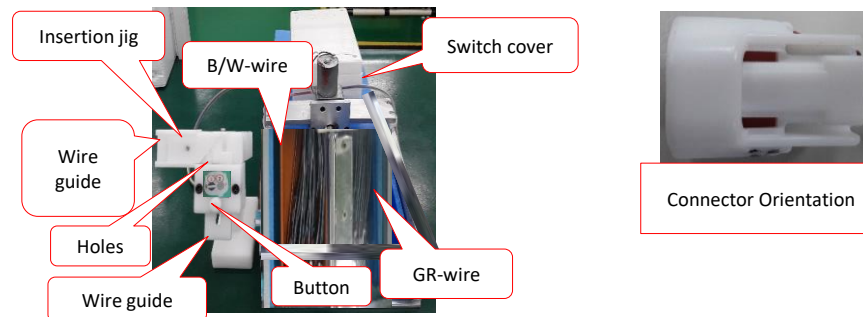
QUALITY POINTERS

2

P1

Connector setting to
insertion jig
6189-0451 (W)

INSERTION JIG WITH SWITCH COVER



1. Press the lock of insertion jig using left thumb.

2. Insert the connector 6189-0451 into jig using right hand and release the lock.

3. Push the guide using right hand. The slot for B/W wire will be open.



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

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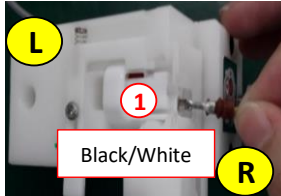
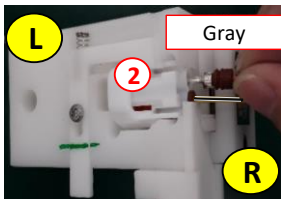






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PARTS:		1. TVSSf 0.3 Wires GR L=548±3mm; B/W L=548±3mm			JIG	1. Insertion jig 2. Locking jig	
NO.	3	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
3	P1	Wire insertion to Connector 6189-0451 (W)	<div><div><p>1. Get the B/W wire then insert to terminal slot ① using right hand.</p></div><div><p>3. Get the GR wire then insert to terminal slot ② using right hand.</p></div></div> <div><div><p>2. After insertion of B/W wire press the button using right hand. The slot for GR wire will be open.</p><p>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.</p></div></div>		N/A	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>	
			3				
4		Connector Lock	<div><div><p>Put the connector into locking jig using right hand then press to lock 2x. Check the connector lock to confirm if properly locked.</p></div><div><p>Check the double lock deformation</p></div></div>		Locking jig 	<div>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</div> <div>1. Must be fully inserted 2. No double lock deformation 3.No Unlock/Half-locked of connector</div>	

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PARTS:		1. Black Corrugated tube $\phi 5$, L= 352 \pm 3mm (no slit) 2. Black tape	3. Assy parts	JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5		<p>Wire insertion to corrugated tube $\phi 5$ L=352\pm3mm (no slit)</p> <p>1. Get the terminal cover jig using right hand then insert the GR-B/W wires using left hand.</p> <p>2. Get the Black corrugated tube (no slit) $\phi 5$ L=352\pm3mm using right hand then insert the GR-B/W wires using left hand.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>		Terminal cover jig	1. No wrong use of corrugated tube 2. No deformed terminal
6	P1	<p>Taping 1 COT to wire near connector</p> <p>1. Hold the corrugated using left hand. Get Black tape using right hand and start pre-taping using both hands.</p> <p>2. Measure the corrugated tube up to connector 25\pm3mm using left hand then proceed to taping. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p> <p><i>Note:</i> 0 - 5mm → End tape up to connector (includes rubber seal)</p> <p>3. After taping, check the measurement and taping condition.</p>		Measuring tape	1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape <i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.

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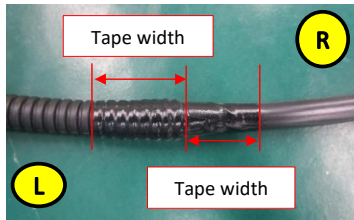

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PARTS:		1. Black tape 2. Assy parts	3. Black sunprene tube $\phi 5$ L=101 \pm 3mm	JIG	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7		Wire insertion to Black Sunprene tube $\phi 5$ L=101 \pm 3mm	 <div>Get the black sunprene tube $\phi 5$ L=101\pm3mm using right hand and insert the wires using left hand.</div>	N/A	1. No wrong use of parts
8	P1	Taping 2 Black Corrugated tube to Black Sunprene tube	<div><div>1. Hold the COT using left hand and fix the sunprene tube using right hand.</div><div>2. Hold the assy parts using left hand. Get the Black tape and start the taping process using right hand. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></div><div>3. After taping, check the measurement and taping condition.</div></div>	Measuring tape 	<div><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</div> <div>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missingf tape</div>

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