

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

April 26, 2023

Model Code/ Product Number: **780B / 7R0106-7022A**

Customer:

TRMX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-565A

Revision No.:

3

Page No.:


1 of 7

PARTS:

1. Connector 6188-0407 (W); TVSSf 0.3 wire B/W-G L=398±2mm; Clip type clamp 82711-60270 (L); Black Corrugated tube Ø5 L=203±3mm (no slit); Black Sunprene tube Ø5 L=125±3mm; Black tape

JIG:

1. Insertion jig with Switch cover
2. Terminal cover jig
3. Locking 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 work place is prohibited. Keep it in your locker. Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	Important reminders/Note/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	Prepared by:	Reviewed by:	Approved by:	Noted by:
04/26/23	3	Inclusion of quality checkpoints	J. Loterte	C.Villanueva	A. Arañes	n/a				
10/28/22	2	Improve Quality pointers; Reminders/Notes and references on page no. 1,3,4 and 6 due to process improvement.	M. Ariola	J. Loterte	C.Villanueva	A. Arañes				
07/28/22	1	Change from Pre-launch to Masspro.	M. Ariola	J. Loterte	C.Villanueva	A. Arañes				
07/20/22	0	Initial Issue QR Code 7V3020-0020 Label direction.	M. Ariola	J. Loterte	C.Villanueva	A. Arañes	J. Loterte	C. Villanueva	A. Arañes	n/a

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PARTS:

1. Connector 6188-0407 (W)

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P1

Connector setting to
Insertion jig
6188-0407 (W)

Insertion jig with switch cover

Visual reference

Insertion jig

Switch cover

Lock

I-mark

Holes

Connector orientation

L

R

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.

GOOD

NG

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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PARTS:

1. TVSSf 0.3 wire B/W L=398±2mm
2. TVSSf 0.3 wire G L=398±2mm

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)

Wire facing

B/W

1

R

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

Press

R

2. Press the button using right hand. Slot for **Green wire** will be open.

L

2

G

R

3. Get the **Green wire** then insert to terminal slot **②** using right hand.

L

Press

R

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. Make sure wires are properly inserted.
Conduct Pull-Push-Pull-Push after insertion.
Do not exert extra force.
2. Please hold the wire near terminal during insertion.
3. Insertion of wire must be from left to right.

Document reference/s:

1. Refer to GL-PRO-ASY-029
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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PARTS:

1. Assy parts
2. Clip type clamp 82711-60270 (L)

JIG

1. Locking jig

NO.

PROCESS NAME

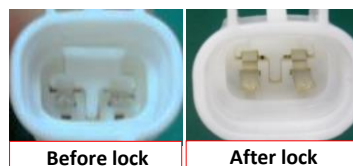
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

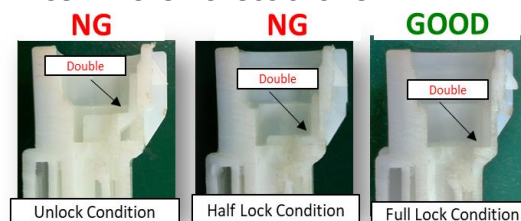
QUALITY POINTERS

4

Connector lock



CONNECTOR CROSS SECTIONAL VIEW



Put the connector into locking jig using right hand then press **2x**. Check the connector if properly lock.

Locking jig



1. Use the provided locking per model
2. No unlock/half-locked connector

Important reminders/Note/s:

1. Manual locking may cause damaged connector lock.

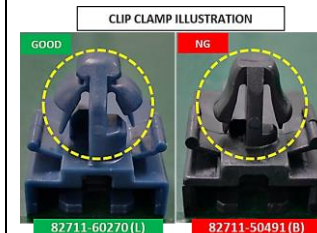
5

Clamp attachment
(Clip type Clamp)



1. Hold the connector using left hand, get the clip type clamp 82711-60270 (L) then insert the clamp using right hand. *Note: Sound will be heard if properly inserted.*

N/A



1. No damaged clamp
2. No wrong use of clamp

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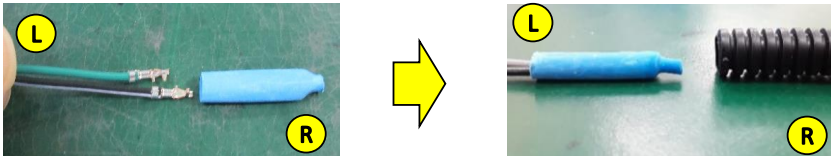


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PARTS:		1. Black Corrugated tube Ø5 L=203±3mm (no slit) 2. Black Sunprene tube Ø5 L=125±3mm	JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Wire insertion to Corrugated tube Ø5 L=203±3mm (no slit)	 <div>1. Get the terminal cover jig using right hand then insert the G and B/W wires.</div> <div>2. Get the Corrugated Ø5 L=203±3mm (no slit) using right hand and insert the G and B/W wires</div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>	Terminal Cover jig 	1. No wrong use of parts 2. No deformed terminal
7	Wire insertion to Sunprene tube Ø5 L=125±3mm	 <div>1. Get the Black Sunprene tube Ø5 L=125±3mm using right hand and insert the G and B/W wires</div>	n/a	1. No wrong use of parts 2. No deformed terminal

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PARTS:

1. Assy parts
2. White tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

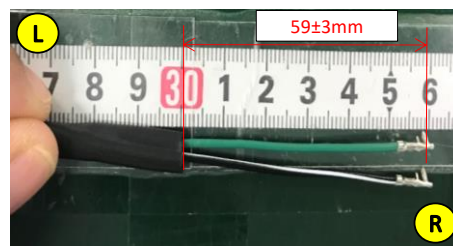
TOOLS/PPE

QUALITY POINTERS

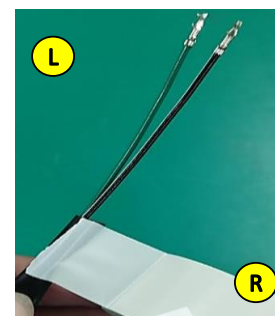
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P1

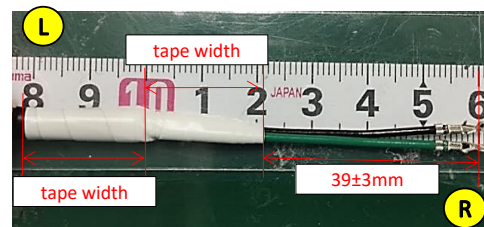
Taping 1
Sunprene to wire near
terminal



1. Hold the Sunprene tube using left hand. Measure from end of Sunprene up to the terminal pointed tip $59\pm 3\text{mm}$.



2. Hold the Sunprene tube using left hand. Get **White tape** using right hand and start taping using both hands.



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

Measuring tape

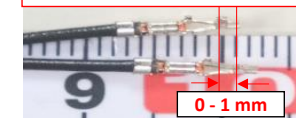


1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape
5. No wrong dimension
6. No missig tape

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. Use **WHITE TAPE** only.

Wire alignment tolerance



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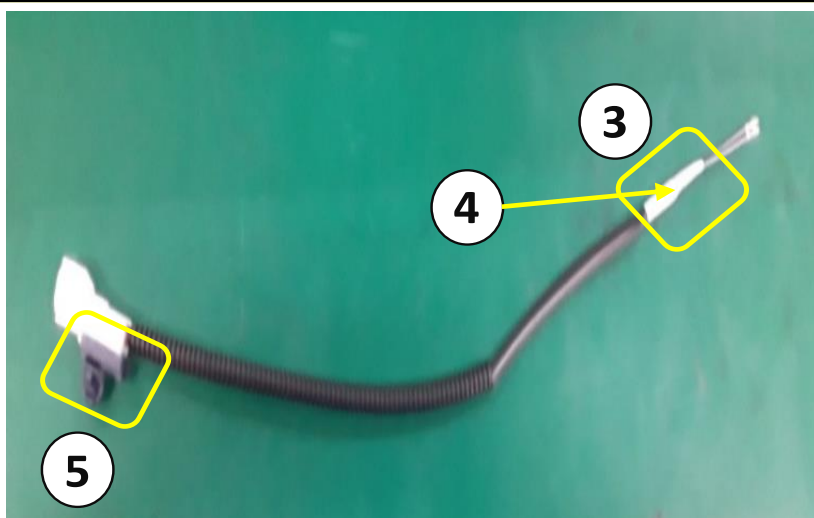
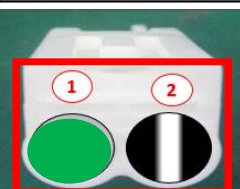
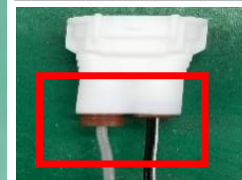
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PARTS:

1. Assy parts

JIG

n/a

**QUALITY CHECKPOINTS****P1****7R0106-7022A****GOOD****GOOD****GOOD****GOOD****NO GOOD****NO GOOD****NO GOOD****NO GOOD****1** No **Unlock**
Connector**2** No **Wrong Insert****3** No **Missing Tape****4** No **Wrong Used of Tape**
(white tape)**5** No **Missing Clip**
Clamp**6** No **Terminal Backing Out**

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