



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: **010B** / **7L0031-7023**

Customer:

TRQSS

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

November 25, 2021

Validity Date:

n/a

Document No.:

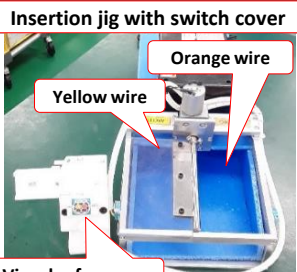
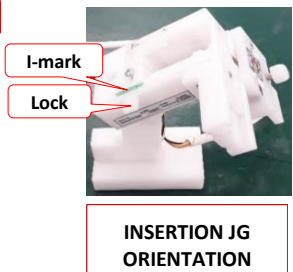

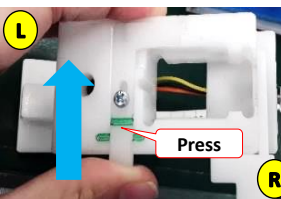
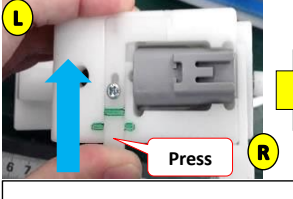
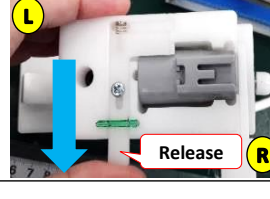
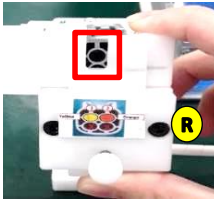
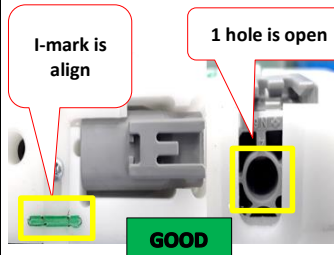
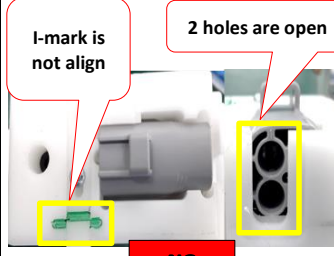
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PARTS:		1. Connector 6188-0066 (GR)			JIG	1. Insertion jig with switch cover	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
2	P1	<p>Connector setting to insertion jig 6188-0066 (GR)</p> <div>    </div> <div>    </div> <div>  </div> <p>1. Press the lock using left hand.</p> <p>2. Get the connector 6188-0066 (GR) using right hand and insert to insertion jig. Release the lock after insertion. <i>Note: Follow the connector orientation.</i></p> <p>3. Push the lower wire guide upward using right hand. Slot for Yellow wire will be opened.</p>			n/a	<p>CONNECTOR ORIENTATION ILLUSTRATION</p> <div>   </div> <p>1. Use the provided jig per model</p> <p>2. No wrong orientation of connector</p> <p>3. No wrong use of connector</p> <p>4. No damaged connector</p>	

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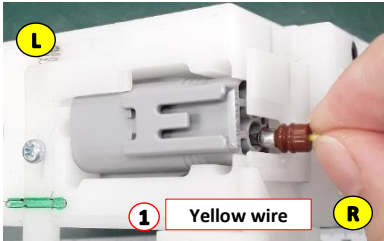
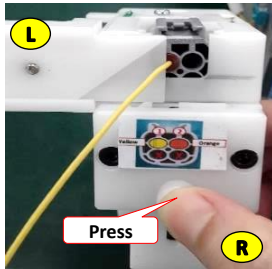
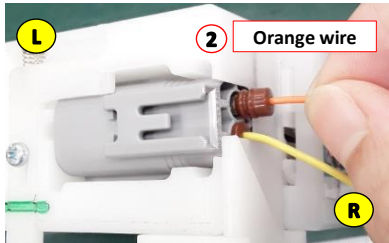
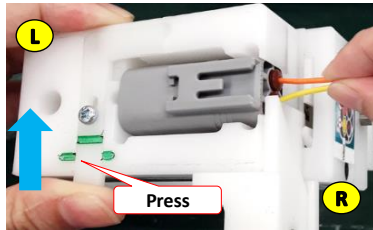
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. AVSSf 0.3 Y L=365±2mm; OR L=365±2mm		JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME		4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	Wire Insertion to connector 6188-0066 (GR)	<div><div><p>WIRE FACING</p></div><div><p>1 Yellow wire</p><p>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</p></div><div><p>Press</p><p>2. Press the button using right thumb. The slot for Orange wire will be opened.</p></div><div><p>2 Orange wire</p><p>3. Get the Orange wire then insert to terminal slot 2 using right hand.</p></div><div><p>Press</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><div><p>4 <i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p><ul style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deformed terminal5. No wrong wire facing<p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p></div><div><p>4 <i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p></div></div>

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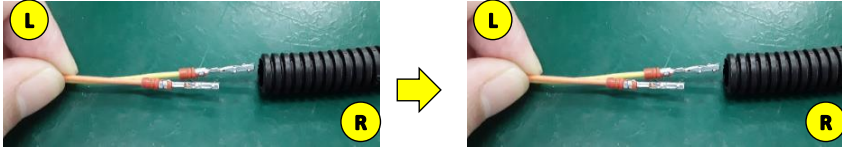
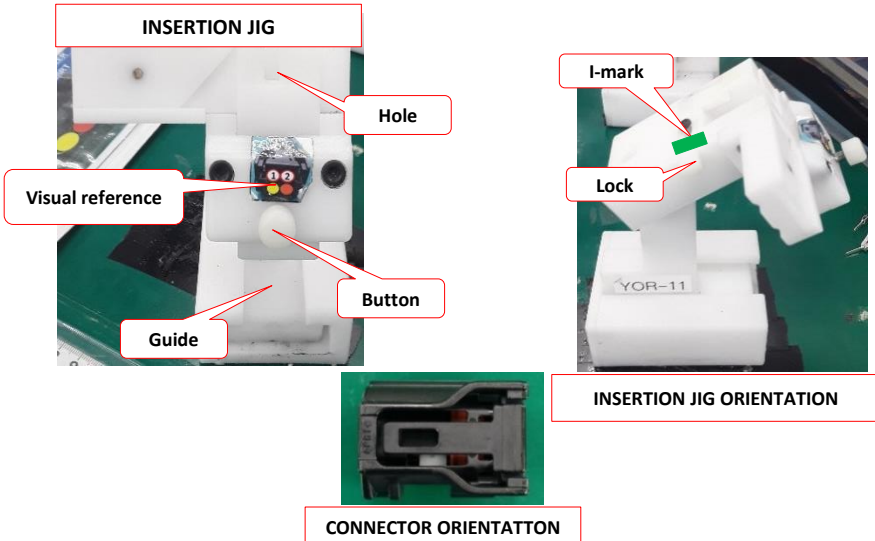
PARTS:

1. Assy parts
2. Black corrugated tube (no slit) $\varnothing 7$ L= 156 \pm 3mm

3. Black corrugated tube (no slit) $\varnothing 5$ L= 158 \pm 3mm
4. Connector 6189-1161 (B)

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black corrugated tube (no slit) $\varnothing 7$ L= 156 \pm 3mm (1ST) $\varnothing 5$ L= 158 \pm 3mm (2ND)	 <ol style="list-style-type: none">1. Hold the wires using left hand. Get the Corrugated tube (no slit) $\varnothing 7$ L=156\pm3mm using right hand then insert then Y-OR wires using left hand.2. Hold the wires using left hand. Get the Corrugated tube (no slit) $\varnothing 5$ L=158\pm3mm using right hand then insert then Y-OR wires using left hand.	n/a	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal
5	Connector setting to insertion jig 6189-1161 (B)		n/a	<ol style="list-style-type: none">1. Use the provided jig per model2. No wrong orientation of connector3. No wrong use of connector4. No damaged connector

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☐ PRE-LAUNCH

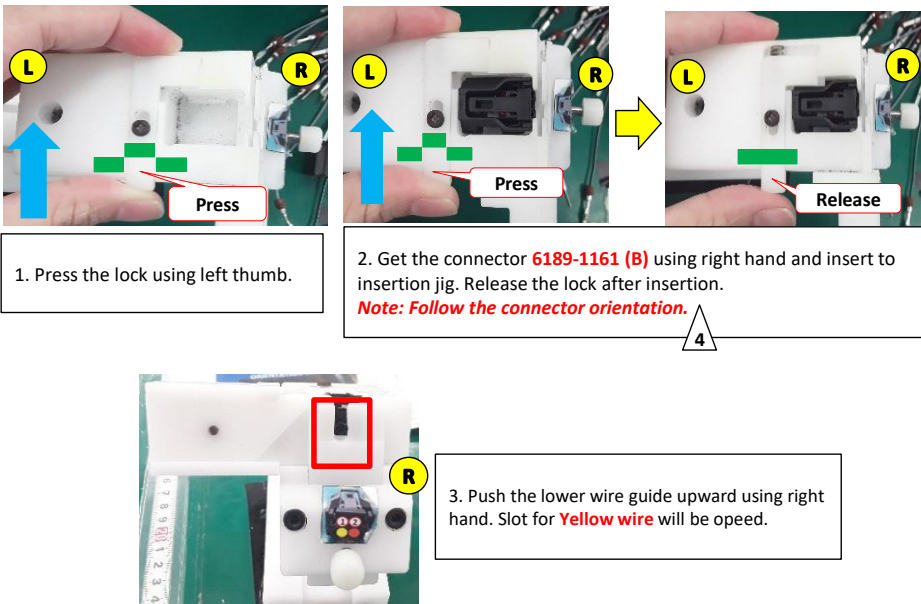
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PARTS:		n/a		JIG	1. Insertion jig
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Connector setting to insertion jig 6189-1161 (B) (Continuation)	 <p>1. Press the lock using left thumb.</p> <p>2. Get the connector 6189-1161 (B) using right hand and insert to insertion jig. Release the lock after insertion. <i>Note: Follow the connector orientation.</i></p> <p>3. Push the lower wire guide upward using right hand. Slot for Yellow wire will be opened.</p>		n/a	<p>CONNECTOR ORIENTATION ILLUSTRATION</p> <p>GOOD</p> <p>I-mark is align 1 hole is open</p> <p>NG</p> <p>I-mark is not align 1 hole is open</p> <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

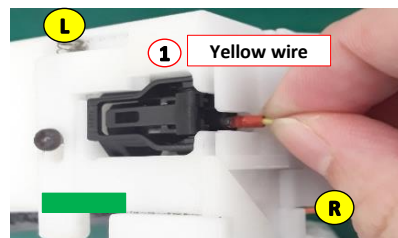
QUALITY POINTERS

6

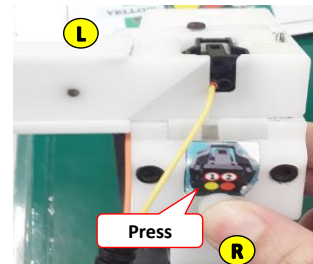
P1

Wire insertion to connector
6189-1161 (B)

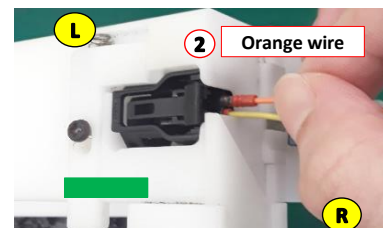
WIRE FACING



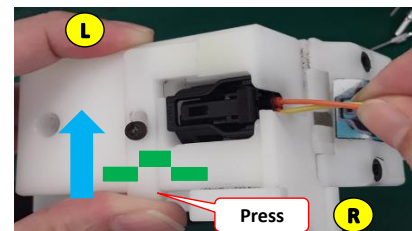
1. Hold the insertion jig using left hand.
Get the **Yellow wire** then insert to terminal
slot **1** using right hand.



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



3. Get the **Orange wire** then insert to
terminal 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

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

Make sure wires are properly inserted.
Conduct **Pull-Push-Pull-Push** after
insertion.
Do not exert extra force.



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

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Locking jig

NO.

PROCESS NAME

4

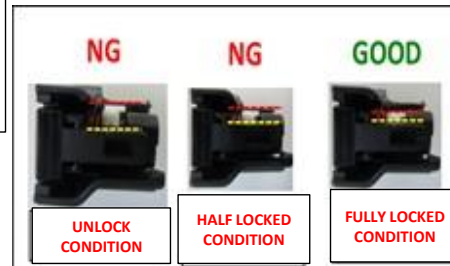
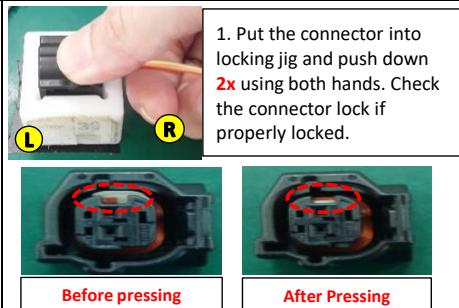
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

7

Connector lock

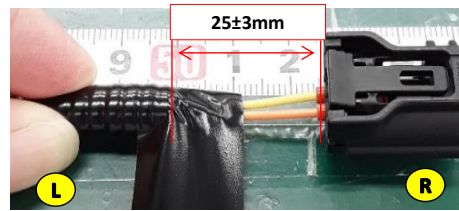
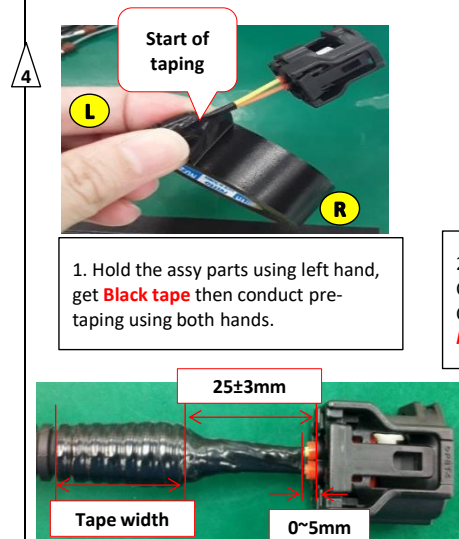


- Note:**
MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK.
1. No unlock/half-locked connector
 2. No damaged lock

8

P1

Taping 1
COT to wire near
connector



Note: Refer to WI-PRO-ASY-001 for taping procedure.



- 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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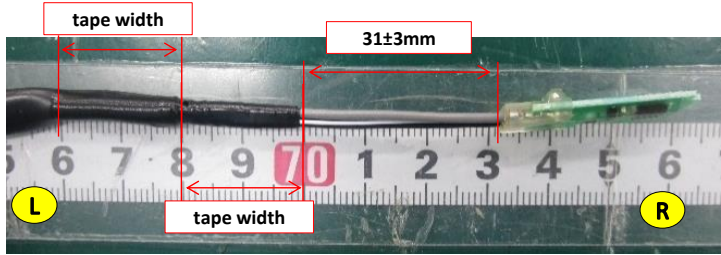

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PARTS:		1. Assy parts 2. Black tape		3. MRSW CP A7475-7L00312 TVSSf 0.3 wires GR-B/W L=678±3mm with inserted Black sunprene tube φ5 L=135±3mm		JIG	n/a
NO.	PROCESS NAME		4 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS
9	P1	Taping 2 Black sunprene tube to wire near hotmelted wires	<div><div><div>4</div><div><div></div><div>1. Get the assy parts GR-B/W wires with sunprene tube then measure from end of the sunprene tube up to the edge of hotmelt 51±3mm using both hands.</div></div></div><div><div></div><div>2. Hold the sunprene tube using left hand, get the black tape using right hand and begin taping process using both hands. Note: Refer to WI-PRO-ASY-001 for taping procedure.</div></div><div><div></div><div>3. After taping, check the measurement and taping condition.</div></div></div>		<div>Measuring jig</div> <div></div>		<div>Note: Please use calibrated/verified measuring tape when getting the measurement.3</div> <div>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</div>

Measuring jig



Note:
Please use calibrated/verified measuring tape when getting the measurement.3

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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9 of 9**PARTS:**

1. Assy parts
2. Black Corrugated tube (no slit) $\phi 7$ L=326 \pm 3mm

JIG

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1 Wire insertion to Black Corrugated tube (no slit) $\phi 7$ L=326 \pm 3mm	<div><p>1. Get the terminal cover jig using right hand then insert to both terminals (GR-B/W wires) using right hand.</p></div> <div><p>2. Get the corrugated tube $\phi 7$ L=326\pm3mm using right hand then insert the GR-B/W wires using left hand.</p></div> <div><p>3. After insertion, remove the cover jig using right hand.</p></div>	<div>TERMINAL COVER JIG</div>	<ol style="list-style-type: none">1. No wrong usage of parts2. No damaged rubber seal

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