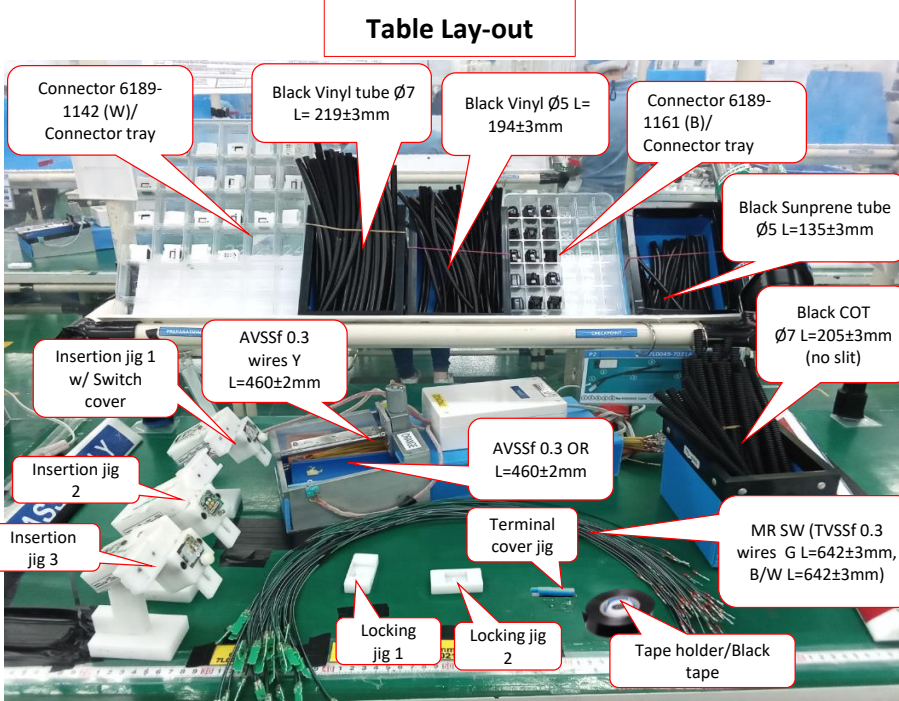



	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date:		April 26, 2023	
	Process Name/Title:				Validity Date:		n/a	
	Model Code/Part Number: <b>780B / 7R0102-7023A</b>		Customer: <b>TRMX</b>		Document No.:		WI-ENG-PDE-553A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.: 1 of 12

<b>PARTS:</b> 1. Connector 6189-1142 (W); Connector 6189-1161 (B); AVSSf 0.3 wires Y L=460±2mm; AVSSf 0.3 wires OR L=460±2mm; Black Vinyl tube Ø7 L=219±3mm; Black Vinyl Ø5 L=194±3mm; Black Sunprene tube Ø5 L=135±3mm; MR SW CP TVSSf 0.3 wires G L=642±3mm; TVSSf 0.3 wires B/W L=642±3mm; Black tape			<b>JIG:</b> 1. Insertion jig w/ switch cover & insertion jig only 2. Locking jig 3. Terminal cover jig		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
1	P1	<p><b>Table Lay-out</b></p> 	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/tools 2. No excess parts/tools  <p><b>Document reference/s:</b></p> <p>1. Please refer to WI-PRO-CNC-017 for Wire and Strip Length tolerance.          2. Please refer to WI-PRO-KIT-005 for Wire Taping without Vinyl tube.</p>	

Revision History								Prepared by	Reviewed by	Approved by	Noted by
04/26/23	3	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a	 J. Loterte	 C. Villanueva	 A. Arañes	n/a	
11/10/22	2	Improve Quality pointers; Reminders/notes and references on page no.3,5,7 and 10 due to document improvements.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes					
07/22/22	1	Change from Pre-launch to Masspro.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes					
07/20/22	0	Initial Issue. QR Code 7V4010-0020 label direction.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	July 20, 2022

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### PARTS:

1. Connector 6189-1142 (W)

### JIG

1. Insertion jig with switch cover

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

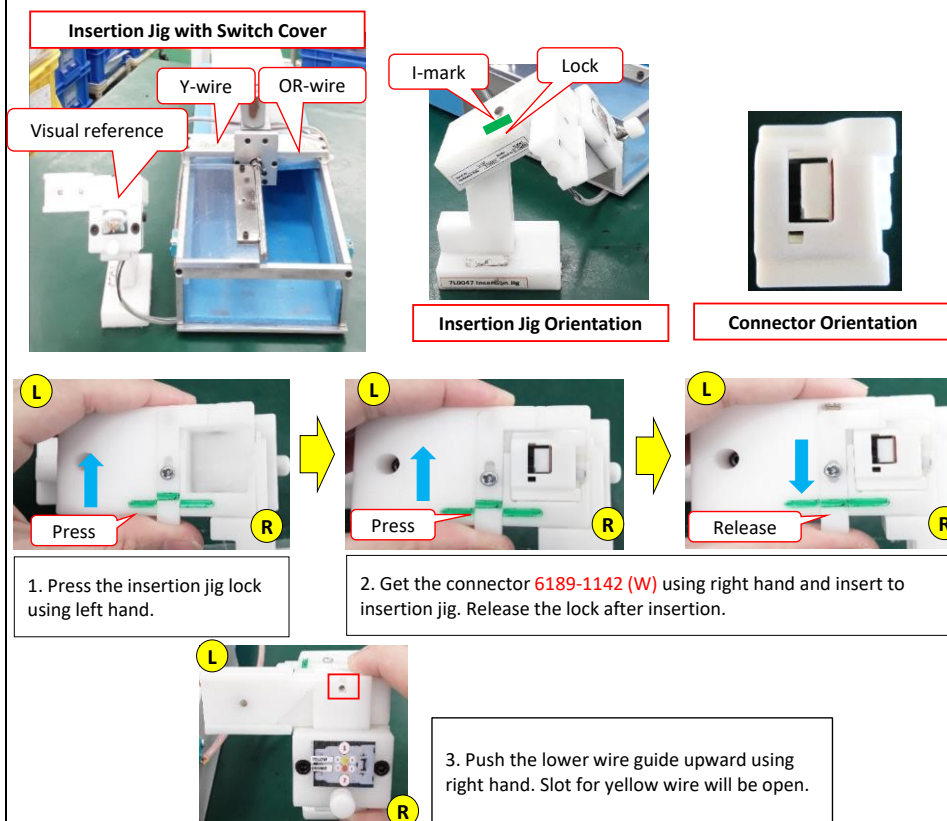
### TOOLS/PPE

### QUALITY POINTERS

2

P1

Connector setting to  
Insertion jig  
6189-1142 (W)



n/a



1. Use the provided jig per model
2. No wrong orientation of connector

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## PARTS:

1. AVSSf 0.3 wires Y L=460±2mm, OR L=460±2mm

## JIG

1. Insertion jig with switch cover

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION


## TOOLS/PPE

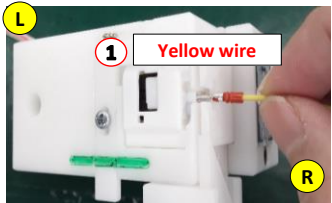
## QUALITY POINTERS

3

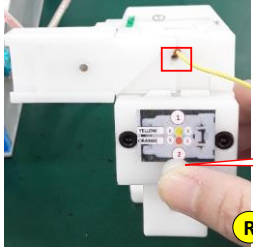
P1

Wire Insertion to  
connector  
6189-1142 (W)

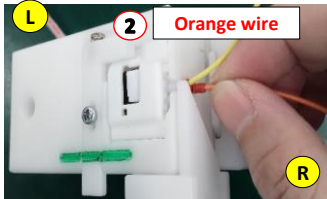
 Wire facing

 **1** Yellow wire

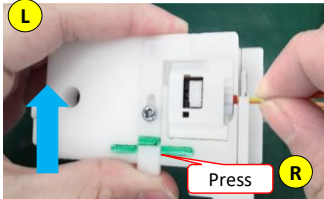
1. Hold the insertion jig using left hand. Get the **Yellow wire** and insert to connector using right hand.

 Press

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

 **2** Orange wire

3. Get the **Orange wire** and insert to connector using right hand.

 Press

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. **During insertion, hold the wire not the rubber seal to prevent the sagging.**

**Document reference/s:**

1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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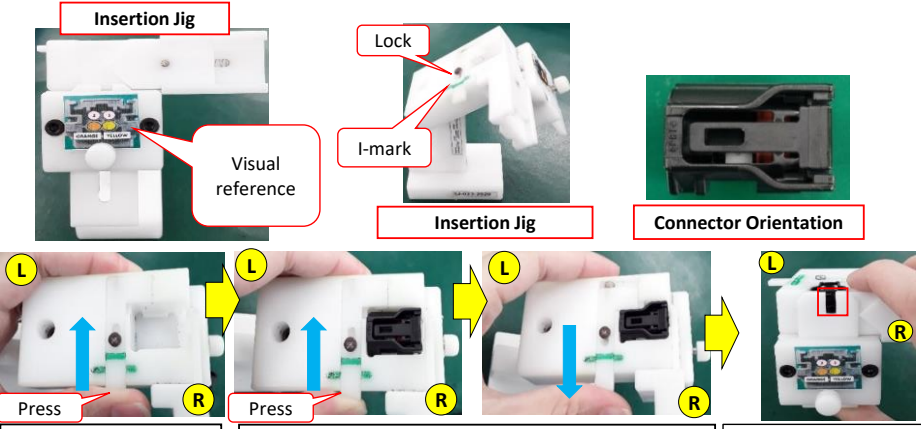


### PARTS:

1. Assy parts.
2. Black Vinyl tube Ø7 L= 219±3mm

3. Black Vinyl tube Ø5 L= 194±3mm
4. Connector 6189-1161 (B)

### JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Vinyl tube Ø7 L= 219±3mm Ø5 L= 194±3mm	 <ol style="list-style-type: none"><li>1. Get the Vinyl tube <b>Ø7 L= 219±3mm</b> using right hand then insert the <b>yellow wire</b> and <b>orange wire</b> by using left hand.</li></ol>  <ol style="list-style-type: none"><li>2. Get the Vinyl tube <b>Ø5 L= 194±3mm</b> using right hand then insert the <b>yellow wire</b> and <b>orange wire</b> by using left hand.</li></ol>	n/a	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No deformed terminal</li></ol>
5	Connector setting to Insertion jig 6189-1161 (B)	 <ol style="list-style-type: none"><li>1. Press the insertion jig lock using left hand.</li><li>2. Get the connector <b>6189-1161 (B)</b> using right hand and insert to insertion jig. Release the lock after insertion.</li><li>3. Push the lower wire guide upward using right hand. Slot for <b>yellow wire</b> will be open.</li></ol>	n/a	<div><b>CONNECTOR ORIENTATION ILLUSTRATION</b></div>   <ol style="list-style-type: none"><li>1. Use the provided jig per model</li><li>2. No wrong orientation of connector</li></ol>

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### PARTS:

1. Assy parts

### JIG

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### QUALITY POINTERS

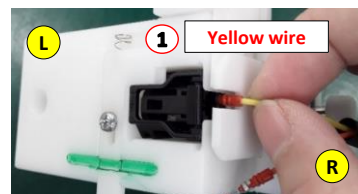
6

P1

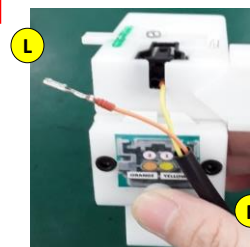
Wire insertion to  
connector  
6189-1161 (B)



Wire facing



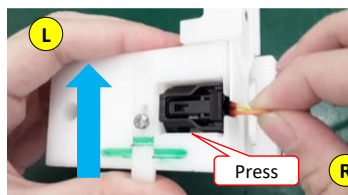
1. Hold the insertion jig using left hand.  
Get the **Yellow wire** and insert to  
connector using right hand.



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



3. Get the **Orange wire** and insert to  
connector using right hand.



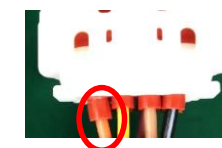
4. After insertion, push the lock using  
left thumb and then hold the wires and  
gently pull out the connector from jig  
using right hand.

n/a

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

### Important reminders/Note/s:

1. Make sure wires are properly inserted.  
Conduct Pull-Push-Pull-Push after insertion.  
Do not exert extra force.
2. During insertion, hold the wire not the rubber seal to prevent the sagging.



### Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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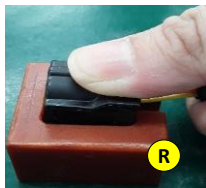




### PARTS:

1. Assy parts
2. Black Sunprene tube  $\varnothing 5$  L= 135 $\pm$ 3mm

3. MR SW CP (TVSSf 0.3 wires G L=(642mm;B/W L=642mm)

### JIG

1. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	Connector lock	  <b>Before Pressing</b> <b>After Pressing</b>  <b>NG</b> <b>NG</b> <b>GOOD</b> <b>Unlock Condition</b> <b>Half lock Condition</b> <b>Full lock Condition</b> <div>1. Put the connector into locking jig and push down to lock <b>2x</b> using right thumb. Check the connector if properly locked.</div>	<b>LOCKING JIG</b> 	<ol style="list-style-type: none"><li>1. No unlock/Half-locked connector</li><li>2. No damaged lock</li></ol>
8	Wire insertion to Sunprene tube $\varnothing 5$ L= 135 $\pm$ 3mm	 <div>1. Get the Sunprene tube <math>\varnothing 5</math> L= 135<math>\pm</math>3mm using left hand then insert the <b>G</b> and <b>B/W</b> hotmelted wires by using right hand.</div>	n/a	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No deformed terminal</li></ol>

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### PARTS:

1. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

9

P1

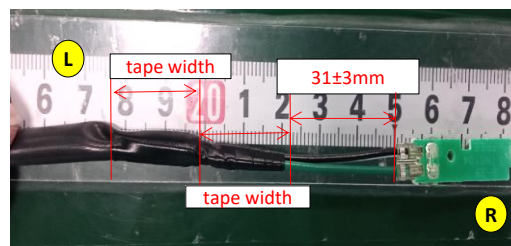
Taping 1  
Sunprene tube to wire  
near PCB



1. Hold the Sunprene tube using left hand. Measure the end of Sunprene up to the edge of hotmelted wires **51±3mm** using right hand.



2. Hold the Sunprene tube using left hand. Get the Black tape using right hand and start taping.



3. After taping, check the measurement 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

**Important reminders/Note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.

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**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**Model Code/Part Number **780B / 7R0102-7023A**Customer: **TRMX**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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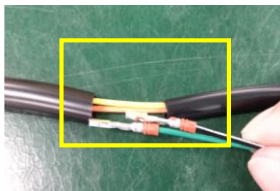

**PARTS:**

1. Black Corrugated tube  $\varnothing 7$  L= 205 $\pm$ 3mm (no slit)
2. Assy parts 1 (G and B/W wires)

3. Assy parts 2 (Y and OR wires)

**JIG**

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	Wire insertion to COT $\varnothing 7$ L= 205 $\pm$ 3mm (no slit)	 <p>1. Get the Corrugated tube <math>\varnothing 7</math> L= 205<math>\pm</math>3mm (no slit) using left hand then insert the <b>G</b> and <b>B/W</b> wires from assy parts 2 by using right hand.</p>	n/a	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No deformed terminal</li></ol>
11	P1 Wire insertion to Assy parts 2	 <p><math>\varnothing 7</math> L= 219<math>\pm</math>3mm</p> <p><math>\varnothing 5</math> L= 194<math>\pm</math>3mm</p> <p>1. Get the assy parts 2 using both hands. Insert the <b>G</b> and <b>B/W</b> wire to Vinyl tube <math>\varnothing 7</math> L= 219<math>\pm</math>3mm using right hand.</p> 	n/a	<ol style="list-style-type: none"><li>1. No wrong insertion</li><li>2. No deformed terminal</li></ol>

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## PARTS:

1. Assy parts

## JIG

1. Insertion jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

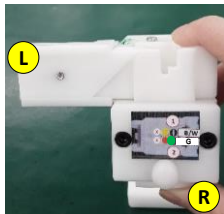
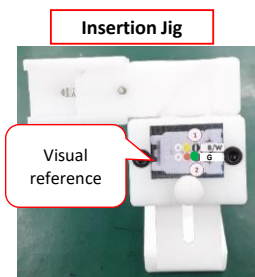
## TOOLS/PPE

## QUALITY POINTERS

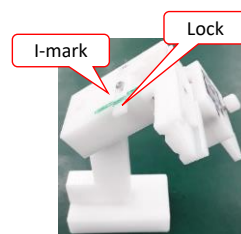
12

P1

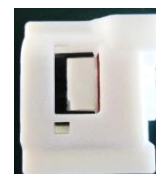
Connector setting to  
Insertion jig  
6189-1142 (W)



1. Press the lower wire guide using right thumb to make sure connector with inserted wires will be inserted.



Insertion Jig Orientation



Connector Orientation



2. Press the Insertion jig lock using left thumb. Get the assy parts and insert the connector using right hand.



3. After insertion, release the insertion jig lock using left thumb.

n/a

## CONNECTOR ORIENTATION ILLUSTRATION



1. Use the provided jig per model
2. No wrong orientation of connector

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

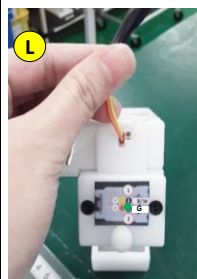
TOOLS/PPE

QUALITY POINTERS

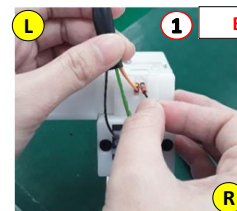
13

P1

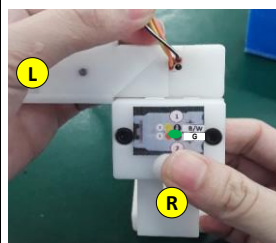
Wire insertion to  
Connector  
(Assy parts)



1. Hold the assy parts upward using left hand. Slot for B/W wire must be open.



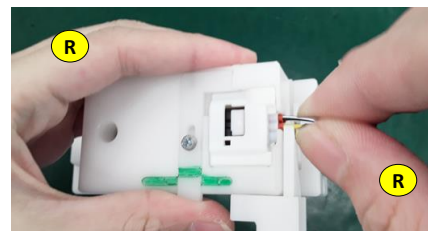
2. Insert the B/W wire using right hand.



3. Press the push button using right hand. Slot for **G wire** will be open.



4. Hold the **G wire** and insert to connector using right hand.



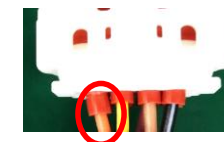
5. After insertion, press the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.

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. During insertion, hold the wire not the rubber seal to prevent the sagging.



**Document reference/s:**

1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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**PARTS:**

1. Assy parts

**JIG**

1. Locking jig

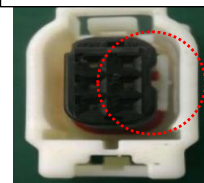
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

14

Connector lock



1. Put the connector into locking jig and push down to lock **2x** using right thumb. Check the connector if properly locked.

**BEFORE PRESSING****AFTER PRESSING****LOCKING JIG**

1. No unlock/Half-locked connector  
2. No damaged lock

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# WORK INSTRUCTION

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

Model Code/Part Number **780B / 7R0102-7023A**

Customer: **TRMX**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 26, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-553A

Revision No.:

3

Page No.:

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## PARTS:

1. Assy parts

## JIG

1. Locking jig



## QUALITY CHECKPOINTS

# P1

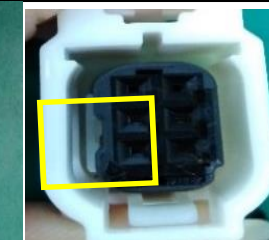
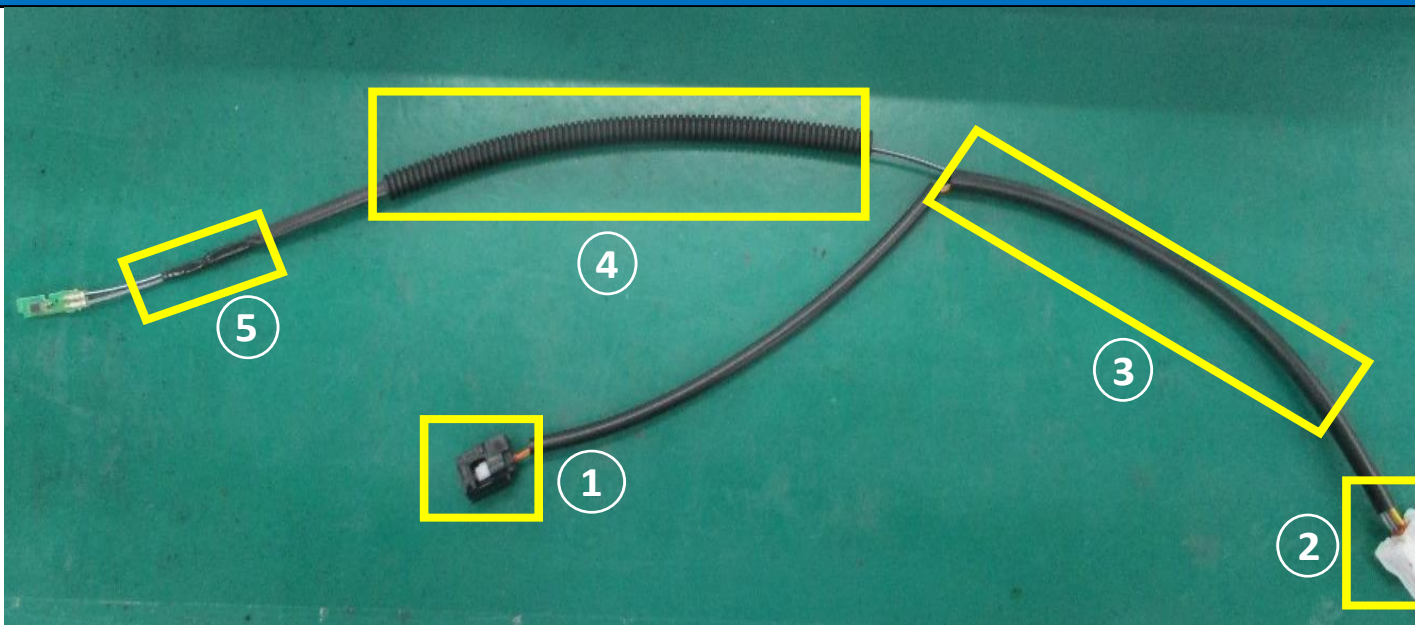
# 7R0102-7023A



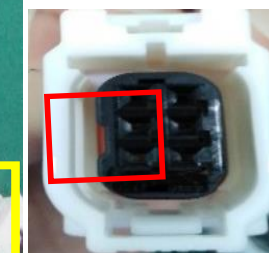
**NO GOOD**



**GOOD**



**GOOD**



**NO GOOD**

① ② **No WRONG INSERT**  
**No TERMINAL BACKING OUT**

③ **No MISSING VINYL**  
⑤ **No MISSING TAPE**

④ **No MISSING COT**

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