

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

Effectivity Date:

February 18, 2022

Model Code/Part Number: **780B / 7R0105-7022**Customer: **TRMX**

Validity Date:

n/a

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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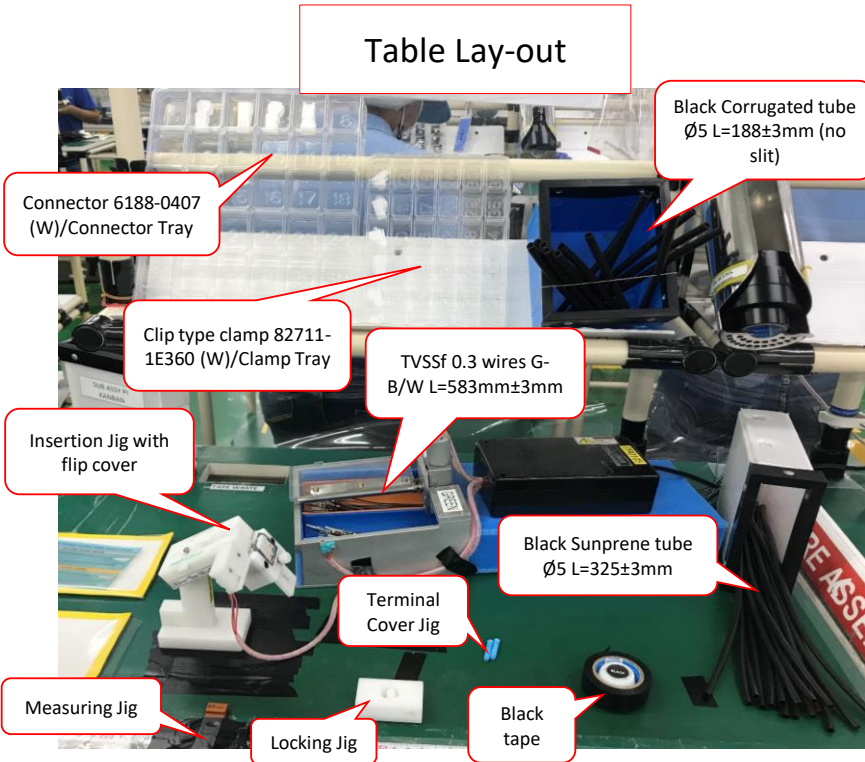
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PARTS:

1. All parts: Connector 6188-0407 (W); TVSSf 0.3 wires G-B/W L=583mm±3mm; Clip type clamp 82711-1E360 (W); Black Corrugated tube Ø5 L=188±3mm (no slit); Black Sunprene tube Ø5 L=325±3mm; Black tape

JIG:

1. Insertion jig with flip cover

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.	<i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i> 1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
02/18/22	0	Initial Issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted

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PARTS:

1. Connector 6188-0407 (W)

JIG

1. Insertion jig with flip cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

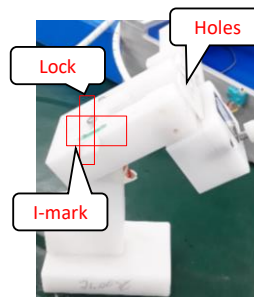
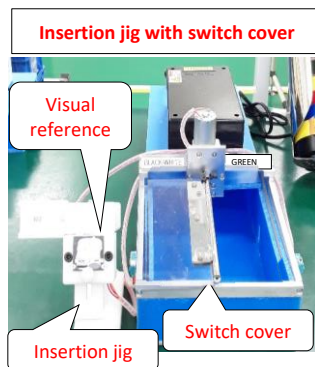
TOOLS/PPE

QUALITY POINTERS

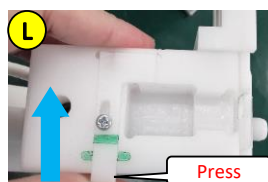
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P1

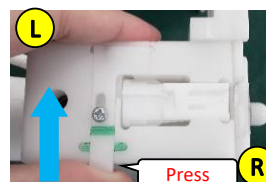
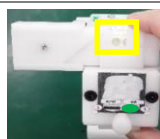
Connector setting to
Insertion jig
6188-0407 (W)



Connector orientation



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.

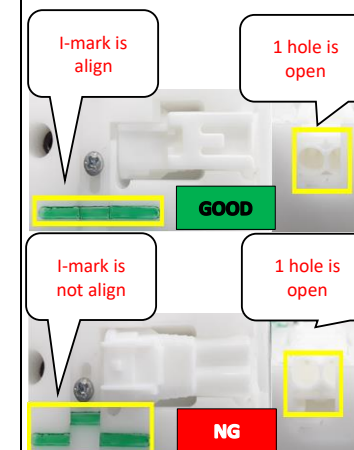
Note: Refer to above illustration for correct setting.



3. Press the lower guide. The holes/terminal slot for B/W wire.

n/a

Connector Orientation Illustration



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

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PARTS:

1. TVSSf 0.3 wires B/W L=583mm±3mm; G L=583mm±3mm

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

1 B/W

2 G

Press

1. Get **B/W wire** then insert to terminal slot **①** using right hand.

2. Push the button after insertion. Slot for **G wire** will be open.

3. Get **G 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

Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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. Clip type clamp 82711-1E360 (W)

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P1

Connector lock



Before lock



After lock



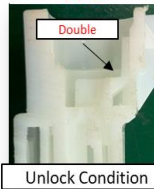
R

CONNECTOR CROSS SECTIONAL VIEW

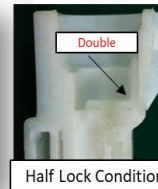
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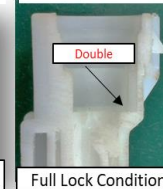
GOOD



Unlock Condition



Half Lock Condition



Full Lock Condition

1. Put the connector into locking jig using right hand then press to lock 2x.

LOCKING JIG



NOTE:
MANUAL LOCKING MAY CAUSE
DAMAGED LOCK

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

5

Clamp attachment
(Clip type clamp)
82711-1E360 (W)



R



L



R



L

1. Hold the connector using left hand. Get the clip type clamp 82711-1E360 (W) then insert the clamp using right hand.
Note Sound will be heard if properly inserted.

n/a

1. Must be fully inserted

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PARTS:

1. Black Corrugated tube Ø5 L=188±3mm (no slit)
2. Black Sunprene tube Ø5 L=325±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=188±3mm
(no slit)



1. Get the terminal cover jig using right hand then insert the G and B/W wires.



2. Get the Corrugated Ø5 L=188±3mm (no slit) using right hand and insert the G and B/W wires



3. After insertion, remove the terminal cover jig using right hand.

TERMINAL COVER JIG



1. No wrong use of parts
2. No deformed terminal

7

Wire insertion to
Sunprene tube
Ø5 L=325±3mm



1. Get the Black Sunprene tube Ø5 L=325±3mm using right hand and insert the G and B/W wires

n/a

1. No wrong use of parts
2. No deformed terminal

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

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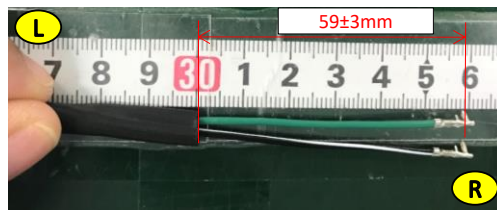
TOOLS/PPE

QUALITY POINTERS

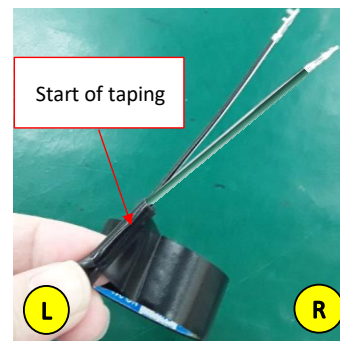
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P1

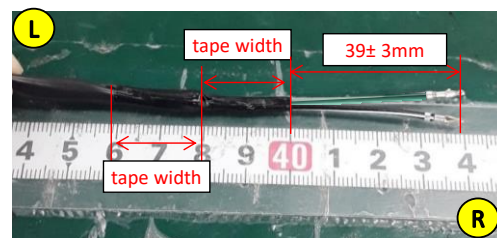
Taping
Sunprene to wire near
terminal



1. Hold the Sunprene tube using left hand. Measure from end of Sunprene up to the terminal pointed tip **59±3mm**.



2. Hold the Sunprene tube using left hand. Get Black tape using right hand and start taping using both hands.
Refer to WI-PRO-ASY-001 for taping procedure.



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

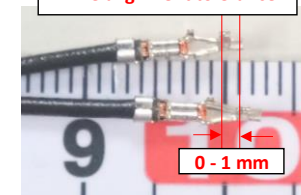
MEASURING TAPE



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

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

Wire alignment tolerance



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