



WORK INSTRUCTION

KITTING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: 011B / 7M0512-7020D

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

April 27, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-137

Revision No.:

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PARTS:

- Connector 6189-0249 (GR)
- AVSSf 0.3 Y/OR wires L=387±2mm

JIG:

1. Insertion jig with switch cover

NO.

PROCESS NAME

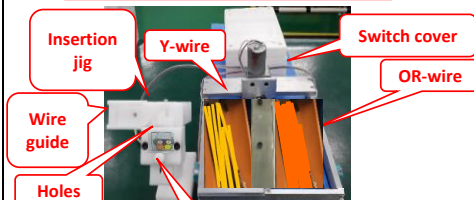
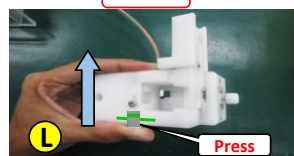
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

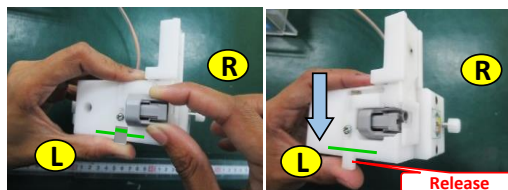
QUALITY POINTERS

1

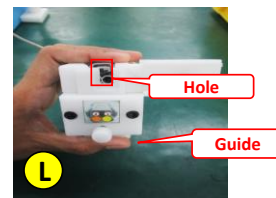
Connector setting to
insertion jig
6189-0249 (GR)

INSERTION JIG WITH SWITCH COVER**CONNECTOR ORIENTATION****Wire facing**

- Press the lock of insertion jig using left thumb.



- Insert the connector **6189-0249 (GR)** into jig using right hand and release the lock.



- Push the guide using left hand. The slot for **Y wire** will be opened.

Safety Instruction

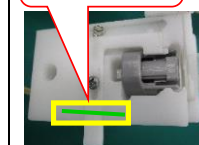
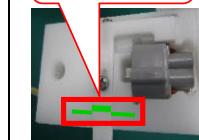
Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

- Maintain and always practice 5's.
- Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Connector Orientation Illustration**I-mark is align****1 hole is open****GOOD****I-mark is not align****2 holes are open****NG**

- Use the provided jig per model
- No wrong orientation of connector
- No wrong use of connector
- No damaged connector

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/27/21	2	Removal of validity date. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
10/22/20	1	Changed effectivity and validity date. Remove cycle time.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
07/07/20	0	Initial issue.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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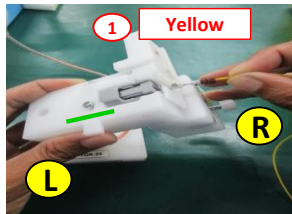
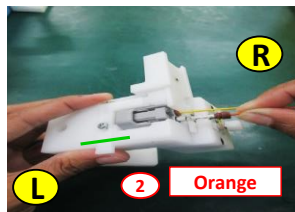

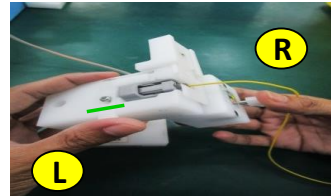
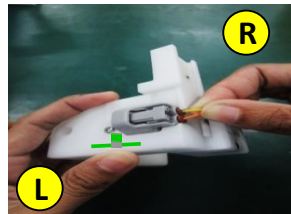
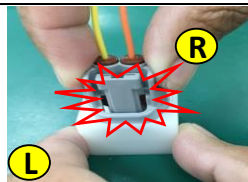
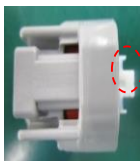
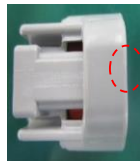



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PARTS:		n/a		JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to connector 6189-0249 (GR)	<div><div><p>1. Get the Y wire then insert to terminal slot ① using right hand.</p></div><div><p>3. Get the OR wire then insert to terminal slot ② using right hand.</p></div><div><p>Wire facing</p></div><div><p>2. After insertion of Yellow wire press the button using right hand. The slot for OR wire will be opened.</p></div><div><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>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div>
3	Connector Lock	<div><p>1. Put the connector into locking jig then press 2x using right hand. Check if properly locked.</p></div> <div><p>Before Pressing</p></div> <div><p>After Pressing</p></div> <div><p>GOOD</p></div> <div><p>NG</p></div> <div>Check the double lock deformation.</div>		<div>LOCKING JIG</div> 	<div>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</div> <div>1. Use the provided jig per model 2. No half-lock/unlock connector</div>



LOCKING JIG

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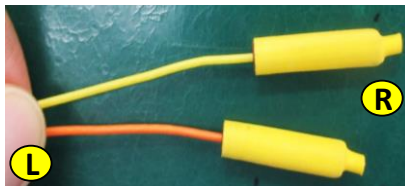


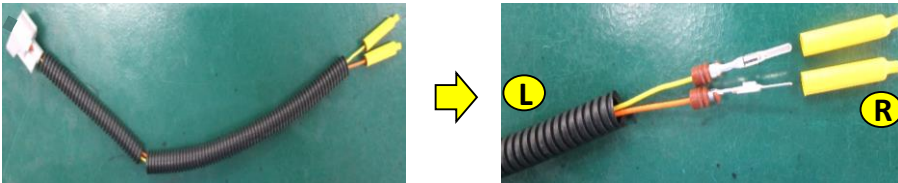

☒ MASSPRO

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PARTS:		1. Assy parts 2. Black Corrugated tube (no slit) $\phi 7$ L=113 \pm 3mm 3. Black Corrugated tube (no slit) $\phi 7$ L=211 \pm 3mm		JIG	1. Terminal cover jig 
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black Corrugated tube (no slit) $\phi 7$ L=113 \pm 3mm $\phi 7$ L=211 \pm 3mm	<div><p>1. Hold the Y-OR wires using left hand, get the terminal cover jig using right hand then insert to both terminals (Y-OR wires).</p></div> <div><p>COT $\phi 7$ L=113\pm3mm</p><p>2. Get the COT $\phi 7$ L=113\pm3mm using right hand then insert the Y-OR wires using left hand.</p></div> <div><p>COT $\phi 7$ L=211\pm3mm</p><p>3. Get the COT $\phi 7$ L=211\pm3mm using right hand then insert the Y-OR wires using left hand.</p></div> <div><p>4. After insertion, remove the terminal cover jig using right hand.</p></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No damaged rubber seal

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PARTS:	n/a				JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	Visual/By Two's Inspection	<div>1. Check the connector lock.</div> <div>2. Check COT (no slit) $\phi 7$ L=113\pm3mm</div> <div>3. Check COT (no slit) $\phi 7$ L=211\pm3mm</div> <div>4. Check if no damaged rubber seal.</div> <div>5. Compare to master sample.</div> 			n/a	1. No wrong use of parts

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