



WORK INSTRUCTION

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

Product Name/Code: **164B / 7M0531-7020A**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 23, 2021

Validity Date:

n/a

Document No.:

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Revision No.:

5

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PARTS: **5**

1. Connector 6189-0451 (W)

JIG:

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Connector setting to insertion jig 6189-0451 (W)	<p>INSERTION JIG WITH SWITCH COVER</p> <p>Connector orientation</p> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 6189-0451 (W) into jig using right hand and release the lock.</p> <p>3. Push the guide using left hand. The slot for B/W wire will be open.</p>	<p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Connector Orientation Illustration</p> <p>GOOD</p> <p>NG</p> <p>1. Use the provided jig per model 2. No wrong orientation of connector</p>


Revision History

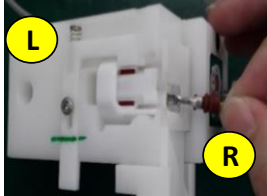

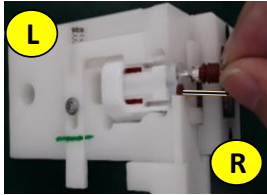
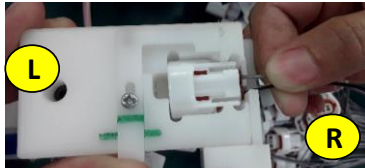
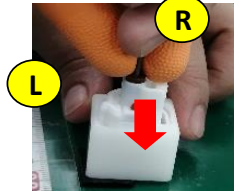





Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/23/21	5	Change connector colors in accordance with color standardization for plastic parts refer to GL-COM-003	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
10/29/20	4	Remove cycle time, apply some improvements	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
02/01/18	n/a	Previously established Engineering instruction (EI-ENG-PDE-011). Initial issue.	S. Manalo	R. Alcantara	A. Arañes	n/a	J. Loterte	C. Villanueva	S. Shimamura	A. Arañes

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PARTS:	1. TVSSf 0.3 Wires GR L=544mm; B/W L=544mm			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	Wire insertion to Connector 6189-0451 (W) P1	 <p>1. Get the B/W wire then insert to terminal slot ① using right hand.</p>  <p>2. After insertion of B/W wire press the button using right hand. The slot for GR wire will be open.</p>  <p>3. Get the GR wire then insert to terminal slot ② using right hand.</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>	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.	
3	Connector Lock	 <p>Put the connector into locking jig then press 2x.</p>  <p>BEFORE PRESSING</p>  <p>AFTER PRESSING</p>  <p>GOOD</p>  <p>NG</p> <p>Check the double lock deformation</p>	LOCKING JIG 	<p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p> 1. Must be fully inserted 2. No double lock deformation 3. No Unlock/Half-locked of connector	

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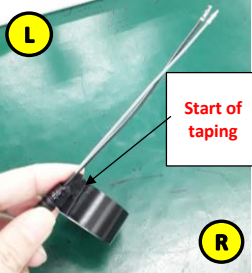
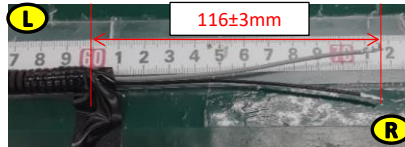
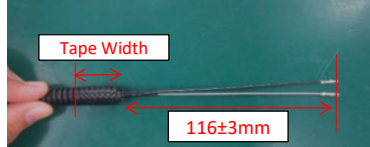


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PARTS:		1. Black Corrugated tube $\phi 5$, L= 392 \pm 3mm (no slit) 2.Black tape 3. Assy parts			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4		 <p>1. Get the terminal cover jig using right hand then insert to GR and B/W wires.</p>  <p>2. Get the corrugated tube $\phi 5$, L= 392\pm3mm (no slit) using right hand and insert the GR and B/W wires using left hand.</p>  <p>3. After insertion, remove the terminal cover jig using right hand.</p>			<p>TERMINAL COVER JIG</p> 	<p>1.No wrong use of corrugated tube 2. No deformed terminal</p>
5	P1	 <p>1. Get Black tape using right hand. Conduct pre-taping between COT and wire using both hands.</p>  <p>2. Measure the end of COT up to the terminal pointed tip L= 116 \pm3mm. Continue taping process. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>3. After taping, check the dimension, taping condition and wire alignment</p>			<p>MEASURING TAPE</p> 	<p>Wire alignment tolerance</p>  <p>0 - 1 mm</p> <p>1. No loose tape 2.No flip-out tape 3. No peel-off tape 4. No wrong dimension</p> <p><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></p>

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PARTS:

1. Black tape
2. Assy parts

JIG

N/A

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

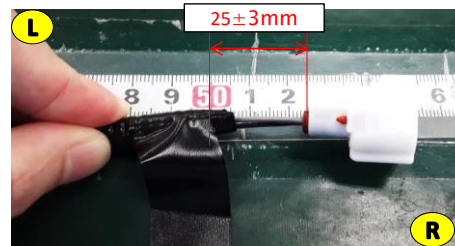
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P1

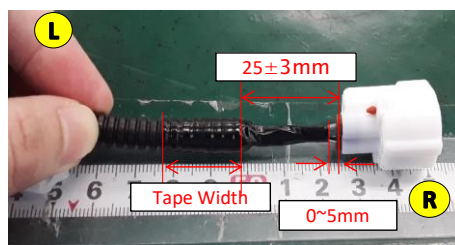
Taping 2
COT to wire near
connector



1. Hold the corrugated using left hand. Get Black tape using right hand and start pre-taping using both hands.



2. Measure the corrugated tube up to connector $25\pm 3\text{mm}$ using left hand then proceed to taping.
Note: Refer to WI-PRO-ASY-001 for taping procedure.



Note:
0 - 5mm
→ End tape up to connector
(includes rubber seal)

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

MEASURING TAPE



- Note:*
Please use calibrated/verified measuring tape when getting the measurement.
1. No loose tape
 2. No flip-out tape
 3. No peel-off tape
 4. No wrong dimension

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