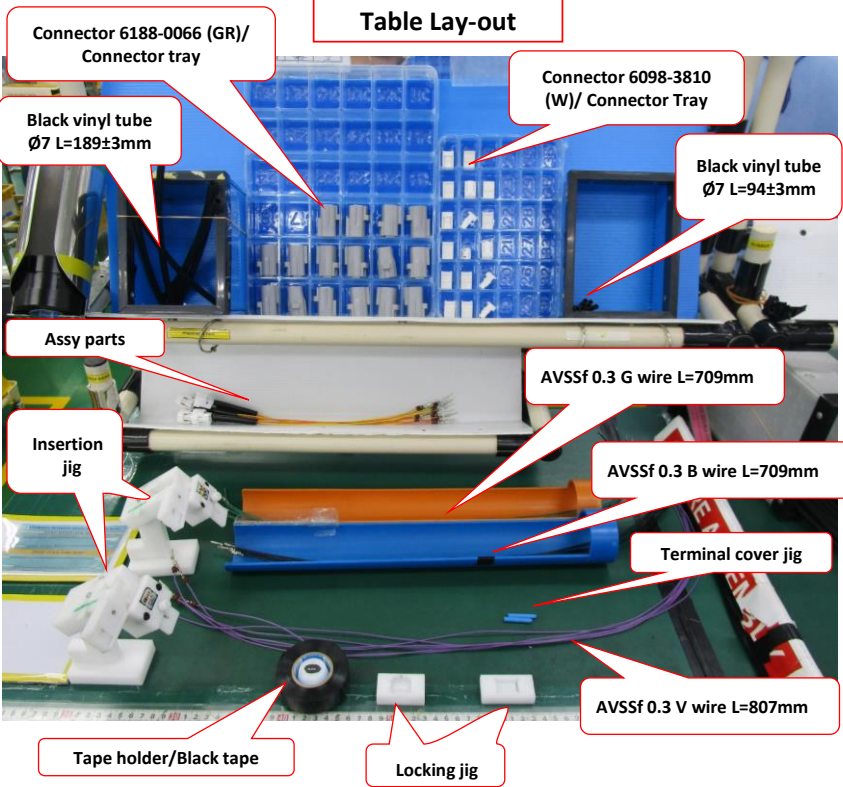
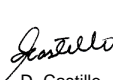
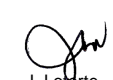


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	Process Name/Title: TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 910B / 1 7L0126-7022	Customer: TRQSS	Document No.:	WI-ENG-PDE-272A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:

PARTS:		1. Pre-assy from Kitting (Connector 6189-0451 (W); AVSSf 0.3 Y-OR wires L=329±2mm; Black vinyl tube Ø7 L=56±3mm); Connector 6188-0066 (GR); Connector 6098-3810 (W); AVSSf 0.3 G-B wires L=709±2mm; AVSSf 0.3 V wire L=807±2mm; Black vinyl tube Ø7 L=189±3mm; Black vinyl tube Ø7 L=94±3mm; Black tape [1pc]		JIG	1. Insertion jig 2. Locking jig 3. Terminal cover jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
1	P1 Table Lay-out			<p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level 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 3. No wrong position of parts/tools		
Revision History							
10/22/21	1	Change part number due to design change. Change from pre-launch to masspro. Add table lay-out and note for Wire and Strip Length Tolerance.		D.Castillo	J.Loterte	C.Villanueva	A. Arañes
09/17/21	0	Initial issue.		D.Castillo	J.Loterte	C.Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted
				Prepared by	Reviewed by	Approved by	Noted by
				 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes
				Est. Date:	September 17, 2021		

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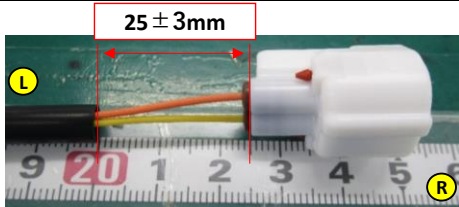

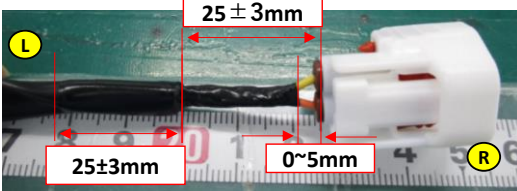






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PARTS:		1. Black vinyl tube Ø7 L=189±3mm 2. Black tape [1pc]		JIG	1. Cover jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Taping 1 Black Vinyl tube to wire near connector	<div><p>25 ± 3mm</p></div> <div><p>Start of taping</p></div> <div><p>25 ± 3mm</p></div> <div><p>25 ± 3mm 0~5mm</p></div> <div><p>1. Measure from end of vinyl tube up to edge of connector 25±3mm using both hands.</p></div> <div><p>2. Get the Black tape using right hand then start taping process using both hands. Note: Please refer to WI-PRO-ASY-001 for taping procedure.</p></div> <div><p>3. After taping, check the measurement, wire alignment and taping condition.</p></div> <div><p>Measuring Tape</p></div> <div><p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p></div> <div><p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p></div>			
3		Wire insertion to Black Vinyl tube Ø7 L=189±3mm	<div><p>1. Get the cover jig then insert to Y-OR wires using right hand.</p></div> <div><p>2. Get the vinyl tube Ø7 L=189±3mm using right hand then insert the Y-OR wires using left hand.</p></div> <div><p>3. After insertion, remove the cover jig using right hand.</p></div> <div><p>Terminal Cover jig</p></div> <div><p>1. No wrong usage of parts 2. No damaged rubber seal</p></div>			

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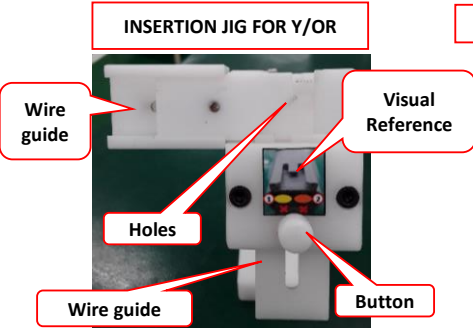
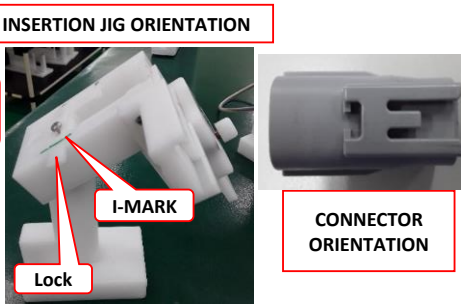

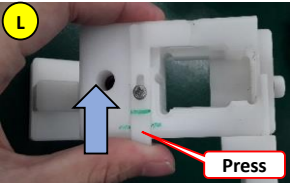
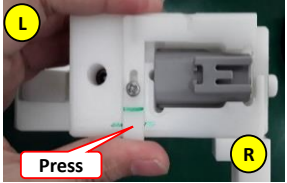
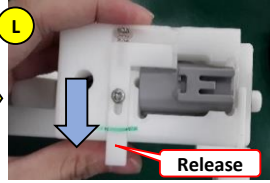


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PARTS:

1. Connector 6188-0066 (GR)

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Connector setting to insertion jig 6188-0066 (GR)	<div><div><p>INSERTION JIG FOR Y/OR</p></div><div><p>INSERTION JIG ORIENTATION</p></div><div></div></div> <div><div><p>1. Press the lock of insertion jig using left thumb.</p></div><div><p>2. Insert the connector 6188-0066 (GR) into jig using right hand then release the lock. <i>Note: Follow the connector orientation.</i></p></div><div><p>3. Push the guide using right thumb. The slot for Y wire will be opened.</p></div></div>	n/a	<div><p>Connector Orientation Illustration</p><div><p>GOOD</p></div><div><p>NG</p></div></div> <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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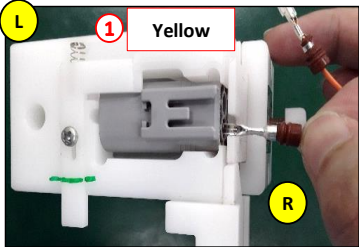
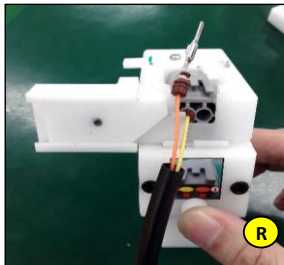
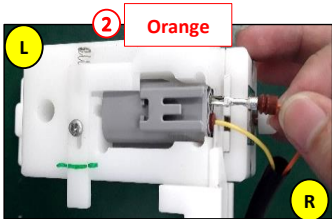
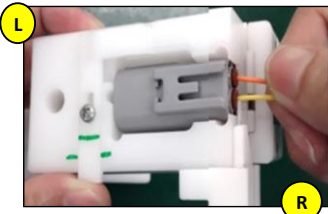
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PARTS:		1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	P1	<div><p>WIRE FACING</p></div> <div><p>1. Hold the insertion jig using left hand. Get the assy parts, insert the Yellow wire to connector slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb, slot for Orange wire will be opened.</p></div> <div><p>3. Get Orange wire then insert to connector slot 2 using right hand.</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>			n/a	<p>Note: Please hold the wire near terminal during insertion.</p> <ol style="list-style-type: none">No loose insertionNo wrong insertionOne by one insertionNo deformed terminalNo wrong wire facing <p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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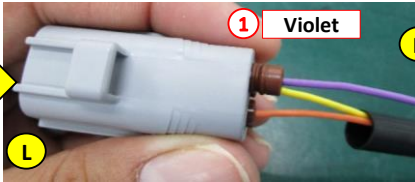
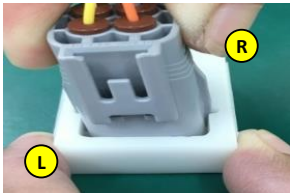








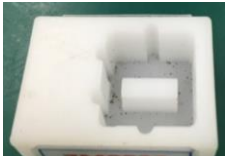



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PARTS:		1. Assy parts 2. AVSSf 0.3 V wire L=807±2mm		JIG	1. Locking jig									
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS									
6	P1	Wire insertion to connector 6188-0066 (GR)	<div><p>WIRE FACING</p></div> <div><p>CONNECTOR ORIENTATION</p></div> <div><p>1 Violet R L</p></div> <div><p>1. Get the Violet wire then insert to empty slot using right hand. Note: Folow the connector orientation.</p></div>	n/a	<p>Note: Please hold the wire near terminal during insertion.</p> <ol style="list-style-type: none">No loose insertionNo wrong insertionOne by one insertionNo deformed terminalNo wrong wire facing <p>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1 Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>									
7		Connector Lock	<div><p>L R</p></div> <div><p>1. Put the connector into locking jig using right hand then press 2x. Touch the connector lock if properly locked.</p></div> <div><p>BEFORE PRESSING</p></div> <div><p>AFTER PRESSING</p></div> <div><p>Connector Cross Sectional View</p><table><tr><td>NG</td><td>NG</td><td>GOOD</td></tr><tr><td></td><td></td><td></td></tr><tr><td>Unlock Condition</td><td>Half Lock Condition</td><td>Full Lock Condition</td></tr></table></div>	NG	NG	GOOD				Unlock Condition	Half Lock Condition	Full Lock Condition	<div><p>Locking jig</p></div> 	<p>Note: Use provided jig tool per model to avoid damaged lock.</p> <ol style="list-style-type: none">Use the provided locking jig per modelNo unlock/half-lock connector <p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p>
NG	NG	GOOD												
														
Unlock Condition	Half Lock Condition	Full Lock Condition												

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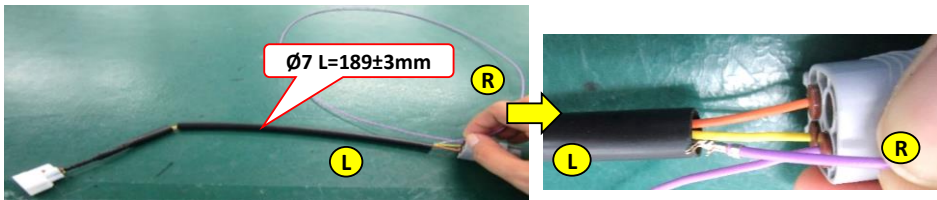
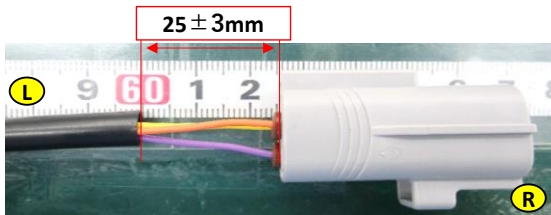
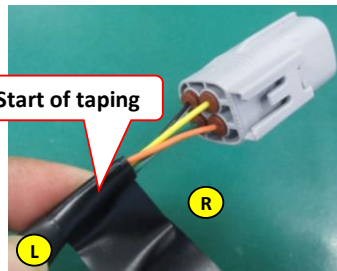
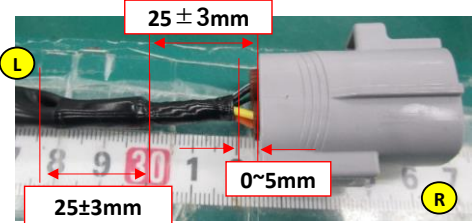

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PARTS:		1. Assy parts 2. Black tape [1pc]	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	Wire insertion to assy parts Black vinyl tube Ø7 L=189±3mm	 1. Hold the Violet wire using right hand, hold the vinyl tube Ø7 L=189±3mm using left hand then insert the Violet wire using right hand.	n/a	1. No wrong insertion of parts 2. No deformed terminal
9	Taping 2 Black vinyl tube to wire near connector	 1. Measure from end of vinyl tube up to edge of connector 25±3mm using both hands.  2. Get the Black tape using right hand then start taping process using both hands. Note: Please refer to WI-PRO-ASY-001 for taping procedure.  3. After taping, check the measurement and taping condition.	 Measuring Tape	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension Note: Please use calibrated/verified measuring tape when getting the measurement.

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PARTS:

1. Connector 6098-3810 (W)

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

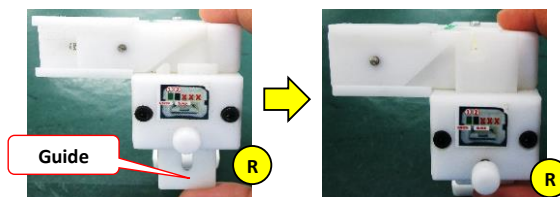
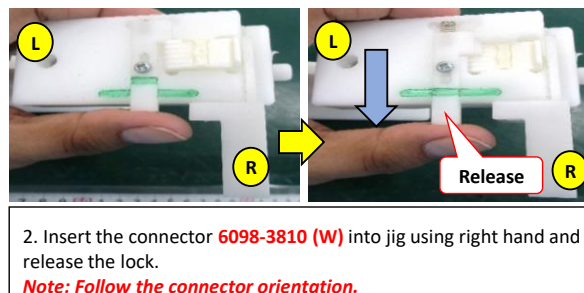
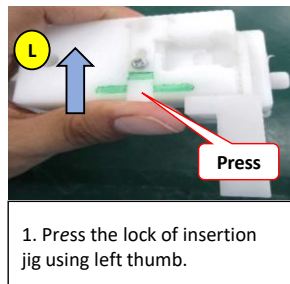
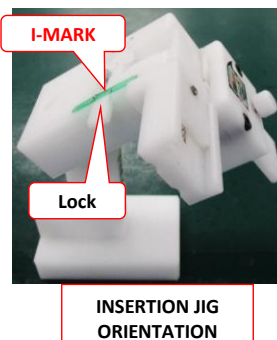
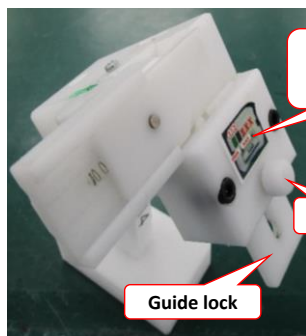
TOOLS/PPE

QUALITY POINTERS

10

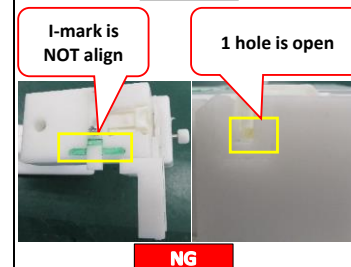
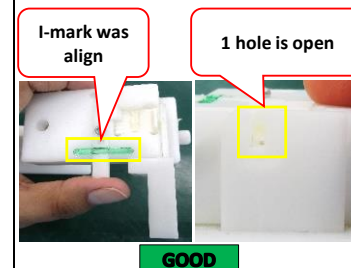
P1

Connector setting to
insertion jig
6098-3810 (W)



n/a

Connector Orientation Illustration



1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

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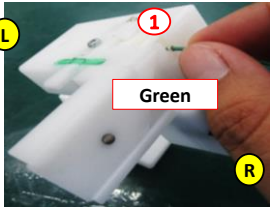

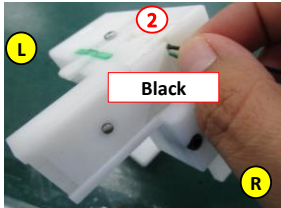
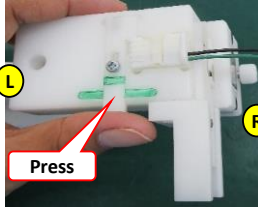



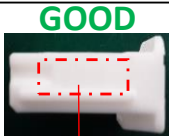
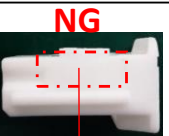

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PARTS:		1. AVSSf wires G wire L=709±2mm 2. AVSSf wires B wire L=709±2mm		JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1 Wire insertion to Connector 6098-3810 (W)	<div><p>WIRE FACING</p></div> <div><p>1. Hold the insertion jig using left hand, get Green wire and insert to connector slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb, slot for Black wire will be opened.</p></div> <div><p>3. Hold the insertion jig using left hand, get Black wire and insert to connector slot 2 using right hand.</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>		n/a	<div><p>Note: Please hold the wire near terminal during insertion.</p></div> <div><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p></div> <div><p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p></div> <div><p>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p></div> <div><p>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p></div>
12	Connector lock	<div><p>Put the connector into locking jig using both thumb then press to lock 2x. Touch the connector lock to confirm if properly pressed.</p><p>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</p></div> <div><p>Before Pressing</p></div> <div><p>After Pressing</p></div> <div><p>GOOD Fully Locked</p></div> <div><p>NG Unlocked</p></div>		<div><p>Locking jig</p></div> 	<div><p>Note: Use provided jig tool per model to avoid damaged lock.</p></div> <div><p>1. Use the provided locking jig per model 2. No unlock/half-lock connector</p></div> <div><p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p></div>

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☐ PRE-LAUNCH


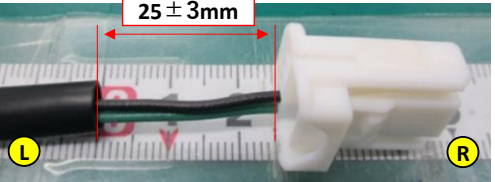
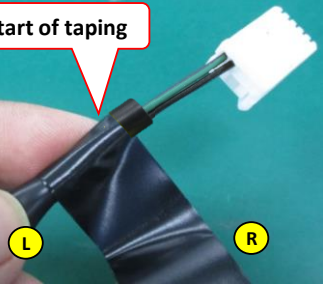
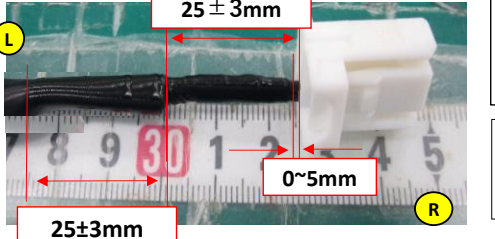

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PARTS:		1. Assy parts 2. Black vinyl tube Ø7 L=94±3mm 3. Black tape [1pc]	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
13		 <p>1. Get the vinyl tube $\varnothing 7$ L=94±3mm using right hand then insert the G-B wires using left hand.</p>	n/a	1. No wrong usage of parts 2. No deformed terminal
14	P1 Taping 3 Black vinyl tube to wire near Connector	 <p>1. Measure from end of vinyl tube up to edge of connector 25 ± 3mm using both hands.</p>  <p>2. Get the Black tape using right hand then start taping process using both hands. Note: Please refer to WI-PRO-ASY-001 for taping procedure.</p>  <p>3. After taping, check the measurement and taping condition.</p>	 <p>Measuring Tape</p>	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p>

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