

	WORK INSTRUCTION				Effectivity Date:		July 19, 2021	
	KITTING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Product Name/Code: 310B / 7M0522-7020C		Customer: TRJ		Document No.: WI-ENG-PDE-165	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		5	Page No.: 1 of 3

PARTS:	1. Connector 6189-0451 (W) 2. AVSSF 0.3 wires Y L=333mm; OR L=333mm	JIG:	1. Insertion jig w/ switch cover
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Connector setting to insertion jig 6189-0451 (W)	<div style="text-align: center;"> </div> <div style="text-align: center;"> <p>CONNECTOR ORIENTATION</p> <p>1. Press the lock of insertion jig using left thumb.</p> </div> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <p>Press</p> </div> <div style="text-align: center;"> <p>Release</p> </div> <div style="text-align: center;"> <p>Push</p> </div> </div> <p>2. Insert the connector 6189-0451 (W) into jig using right hand and release the lock.</p> <p>3. Push the wire guide upward, slot for Yellow wire will be open.</p>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p style="color: red; text-align: center;">Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p style="color: red; text-align: center;">Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p style="color: red; text-align: center;">Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<div style="text-align: center; background-color: #ADD8E6; padding: 5px; margin-bottom: 10px;"> Connector Orientation Illustration </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <p>GOOD</p> </div> <div style="text-align: center;"> <p>NG</p> </div> </div> <p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>

Revision History				Prepared by:		Checked by:	Approved by:	Noted by:
07/19/21	5	Remove validity date.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes		
01/20/21	4	Change part number due to design change. Change connector color in accordance with color standardization for plastic parts. Change from 2x pulling to Pull-Push-Pull-Push insertion quality pointers. Remove cycle time.	D. Castillo	R. Peñaloza	A. Shimamura	A. Arañes		
09/08/20	3	Change Process owner from Production to Engineering. Improved process and add cycle time. Updated pictures. Changed part number. Transferred some process to Taping assembly process.	D. Castillo	R. Peñaloza	A. Shimamura	A. Arañes		
10/23/18	0	Initial issue.	A. Roxas	C. Diaz/ W. Carbillon	O. Merin	n/a		
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	October 23, 2018

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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5

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PARTS:

N/A

JIG

1. Insertion jig w/switch cover

NO.

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

Wire Insertion to
Connector
6189-0451 (W)

WIRE FACING

Note: Please hold the wire near terminal during insertion.

Yellow

1

Orange

2

1. Hold the insertion jig using left hand, get **Yellow wire** using right hand and insert to connector. Press the button after insertion. Slot for **Orange wire** will be open.

2. Hold the insertion jig using left hand, get **Orange wire** using right hand and insert to connector. Press the insertion jig lock using left hand and slowly remove the harness from jig using right hand.

N/A


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

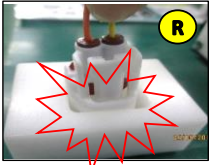




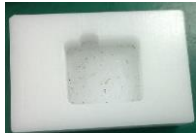




Make sure wires are properly inserted.
Conduct **Pull-Push-Pull-Push** after insertion.
Do not exert extra force.


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PARTS:	1. Black Vinyl tube Ø7 L=57±3mm 2. Black Vinyl tube Ø7 L=207±3mm				JIG	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	Connector Lock	<div>   <p>BEFORE PRESSING</p>  <p>AFTER PRESSING</p>  <p>GOOD</p>  <p>NG</p> <p>Check the double lock deformation</p> </div> <p>Put the connector into locking jig using right hand then press 2x to lock. Touch the connector lock to confirm if properly pressed.</p>			<div> <p>LOCKING JIG</p>  </div>	<div> <p>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK</p> <p>1. No unlock/half-locked connector 2. No damage connector</p> </div>
4	Wire Insertion to Vinyl tube Ø7 L=57±3mm and Ø7 L=207±3mm	<div>   <p>1. Hold the wires using left hand, put on terminal cover jigs for both wires (Y and OR) using right hand.</p> <p>2. Hold the wires using left hand. Get the 1st Vinyl tube Ø7 L=57±3mm then insert the wires, get the 2nd Vinyl tube Ø7 L=207±3mm and insert the wires using right hand.</p>  <p>3. Remove the terminal cover jig after insertion.</p> </div>			<div> <p>TERMINAL COVER JIG</p>  </div>	<div> <p>Note: Use terminal cover jig to avoid damaged rubber seal.</p> <p>1. No wrong use of parts 2. No wrong insertion</p> </div>

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