

**WORK INSTRUCTION**

Process Name/Title:

**OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

May 9, 2023

Validity Date:

n/a

Model Code/Part Number:

**380D / 7L0140-7020A**

Customer:

**TRQSS**

Document No.:

**WI-ENG-PDE-669**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

1 of 5

**PARTS:**1. Connector 6189-1142 (W); Black VM tube (Sunprene)  $\phi 5$  L=106 $\pm$ 3mm; MR SW CP GR-B/W wires L=692 $\pm$ 3mm; Black Corrugated tube  $\phi 7$  L=497 $\pm$ 3mm

JIG:

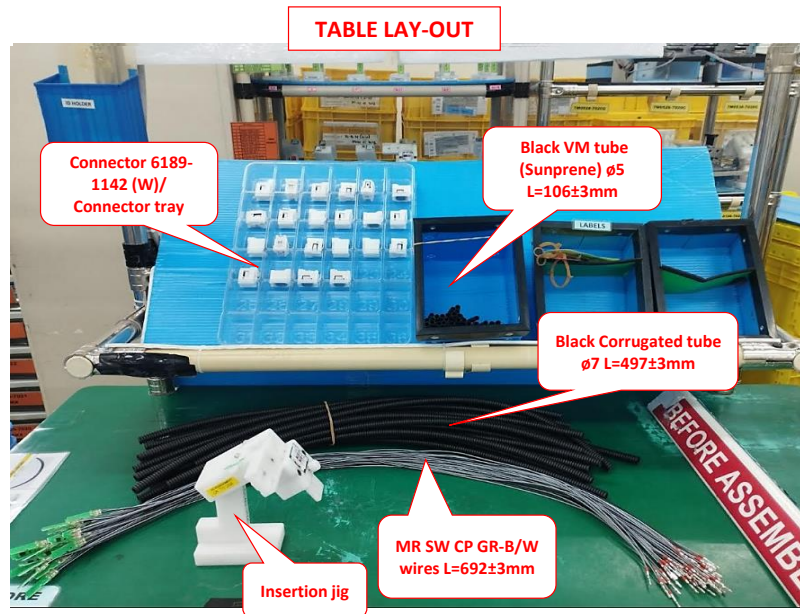
1. Insertion jig

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

n/a

Table Lay-out

**Safety Instruction**

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

**Housekeeping**

1. Maintain and always practice 5's.
2. 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.

1. No Missing parts/tools.
2. No excess parts/tools.

**Document reference/s:**

1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.

**Revision History**

| Eff. Date | Rev. No | Details of Change   | Prepared  | Reviewed   | Approved      | Noted     | Prepared by | Reviewed by | Approved by   | Noted by  |
|-----------|---------|---|-----------|------------|---------------|-----------|-------------|-------------|---------------|-----------|
| 05/09/23  | 0       | Initial Issue.<br>Excluded from WI-ENG-PDE-648; Change Process Name/Title from TAPING ASSEMBLY PROCESS to OFFLINE ASSEMBLY PROCESS due to new process distribution. Additional table lay-out. Inclusion of Quality Checkpoints. | M. Ariola | J. Loterte | C. Villanueva | A. Arañes | M. Ariola   | J. Loterte  | C. Villanueva | A. Arañes |

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Page No.:

**2 of 5****PARTS:**

1. Black VM VM tube (Sunprene)  $\varnothing 5$  L= 106 $\pm$ 3mm  
2. MR SW CP GR-B/W wires L=692 $\pm$ 3mm

3. Black Corrugated tube  $\varnothing 7$  L=497 $\pm$ 3mm**JIG****n/a****NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****2**

Wire insertion to Black VM  
tube (Sunprene)  
 $\varnothing 5$  L= 106 $\pm$ 3mm



1. Get the VM Tube (Sunprene)  $\varnothing 5$  L= 106 $\pm$ 3mm using right hand then insert the GR-B/W hotmelted wires using left hand.

**n/a**

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

**Document reference/s:**

**1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.**

**3**

Wire insertion to Black  
Corrugated tube  
 $\varnothing 7$  L=497 $\pm$ 3mm



1. Get the Black Corrugated tube  $\varnothing 7$  L= 497 $\pm$ 3mm using right hand then insert the GR-B/W hotmelted wires using left hand.

**n/a**

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

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**0**

Page No.:

**3 of 5****PARTS:**

1. Connector 6189-1142(W)

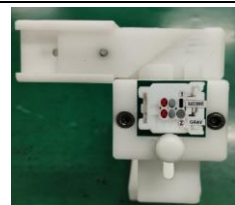
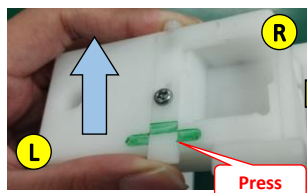
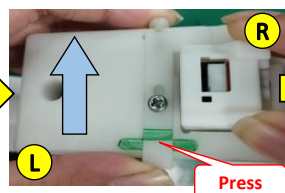
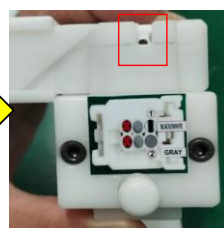
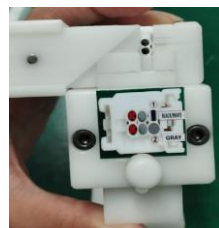
**JIG**

1. insertion jig

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

n/a

Connector setting to  
insertion jig  
6189-1142 (W)**INSERTION JIG ORIENTATION****CONNECTOR  
ORIENTATION**1. Press the lock of insertion jig  
using left thumb.2. Insert the connector **6189-1142 (W)** into jig using right hand and  
release the lock.**Release**3. Press the guide using left thumb.  
The slot for **B/W wire** will be  
opened.

n/a

1. No wrong orientation of connector
2. No wrong use of connector
3. No damaged connector
4. No wrong insertion of wires
5. No loose insertion
6. No wrong insertion
7. One by one insertion
8. No deformed terminal
9. No wrong wire facing

**Important reminders/Note/s:**

1. Please hold the wire near terminal.
  2. Make sure wires are properly inserted.
- Conduct Pull-Push-Pull-Push after insertion.  
Do not exert extra force.

**Document references:**

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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**4 of 5****PARTS:**

1. Assy parts
2. MR SW CP GR-B/W wires L=692±3mm

**JIG**

1. Insertion jig

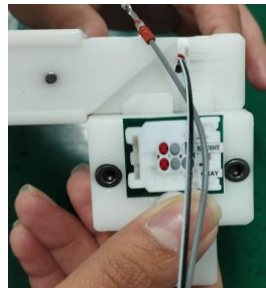
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

n/a

Wire Insertion to  
Connector 6189-1142 (W)

1. Hold the insertion jig using left hand. Get the **B/W wire** and insert to connector using right hand.



2. Press the button using right thumb. The slot for **Gray wire** will be opened.



3. Get the **Gray wire** and insert to connector 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

1. No wrong orientation of connector
2. No wrong use of connector
3. No damaged connector
4. No wrong insertion of wires
5. No loose insertion
6. No wrong insertion
7. One by one insertion
8. No deformed terminal
9. No wrong wire facing

**Important reminders/Note/s:**

1. Please hold the wire near terminal.
  2. Make sure wires are properly inserted.
- Conduct Pull-Push-Pull-Push after insertion.  
Do not exert extra force.

**Document references:**

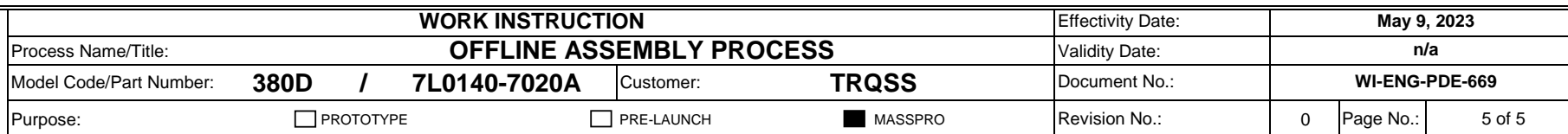
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