

	WORK INSTRUCTION						Effectivity Date:		December 3, 2022	
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:				Model Code/Part Number: 920B / 7R0120-7020		Customer: TRMX		Document No.: WI-ENG-PDE-547A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		1	Page No.:

PARTS:	1. Connector 6188-0407 (W); Black Vinyl Tube Ø5 L=143±3mm; Black Sunprene tube Ø5 L=125±3mm; Black tape; TVSSf 0.3 B/W-G wires L=341±2mm				JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
1	P1	<div style="border: 1px solid black; padding: 5px; margin-bottom: 5px;">TABLE LAY-OUT</div>			<div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1. No missing parts/tools 2. No excess parts/tools Documents reference/s: 1 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
12/03/22	1	Change purpose from pre-launch to masspro. Change SV tube from L=146±2mm to L=143±2mm due to encountered pulling of wire during assembly. Additional Table lay-out. Improve Quality pointers; Reminders/notes and references on pages no.1,3,5 and 6. Inclusion of Quality checkpoints.						M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
06/16/22	0	Initial issue						M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:	June 16, 2022		

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920B / 7R0120-7020

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TRMX

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. Connector 6188-0407 (W)

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

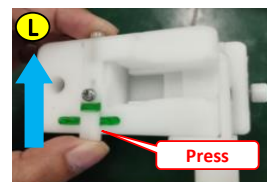
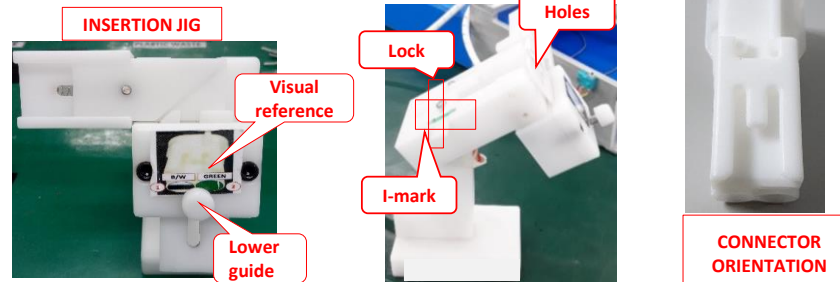
TOOLS/PPE

QUALITY POINTERS

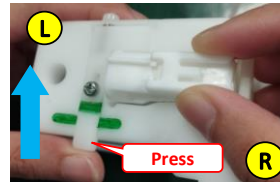
2

P1

Connector setting to
insertion jig
6188-0407(W)

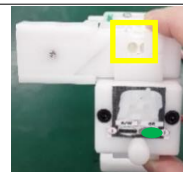


1. Press the lock of insertion jig using left thumb.



2. Insert the connector **6188-0407 (W)** into jig using right hand and release the lock.

Note: Refer to above illustration for correct setting.



3. Press the lower wire guide using right thumb. Terminal slot for **B/W wire** will be open.

n/a

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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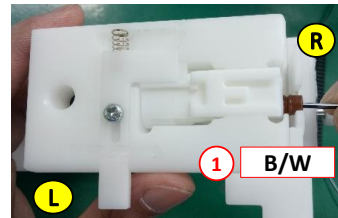
Page No.:

3 of 7**PARTS:**

1. TVSSf 0.3 B/W-G wires L=341±2mm

JIG

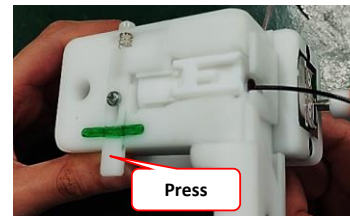
1. Insertion jig with switch cover

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****3****P1**Wire insertion to connector
6188-0407(W)

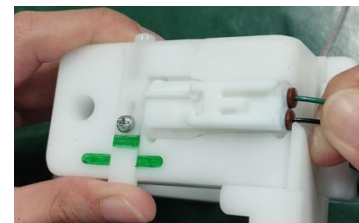
1. Hold the Insertion jig using left hand. Get **Black/White wire** then insert to terminal **slot 1** using right hand.



3. Get **Green wire** then insert to terminal **slot 2** using right hand.



2. Push the button using right hand. The slot for **Green wire** will be opened.



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

**Important reminders/ Note/s:**

1. Please hold the wire near terminal during insertion.
 2. Insertion must be from left to right.
 3. Make sure wire are properly inserted.
- Conduct Pull-Push-Push after insertion.
Do not exert extra force.

**Document reference/s:**

1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
2. Please Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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4 of 7**PARTS:****1**

1. Assy parts
2. Black Vinyl Tube Ø5 L=143±3mm

3. Black Sunprene tube Ø5 L=101±3mm

JIG**n/a**

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	1 Wire insertion to Black Vinyl Tube Ø5 L=143±3mm	 1 1. Get the Viny tube Ø5 L=143±3mm using right hand then insert the Green and Black/White wire.	n/a	1 1. No wrong use of parts 2. No deformed terminal
5	P1 Wire Insertion to Black Sunprene tube Ø5 L=101±3mm	 1. Get the Sunprene tube Ø5 L=101±3mm using right hand then insert the Green and Black/White wire.	n/a	1 1. No wrong use of parts 2. No deformed terminal

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

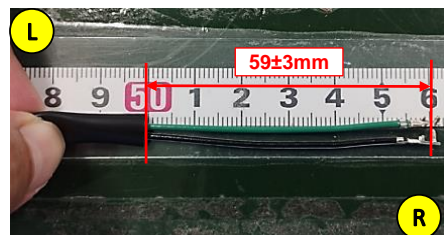
TOOLS/PPE

QUALITY POINTERS

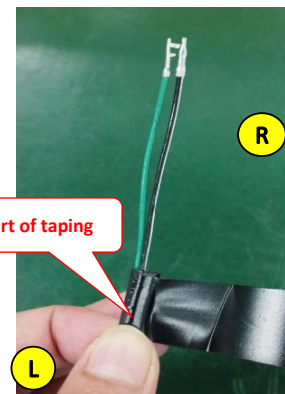
6

n/a

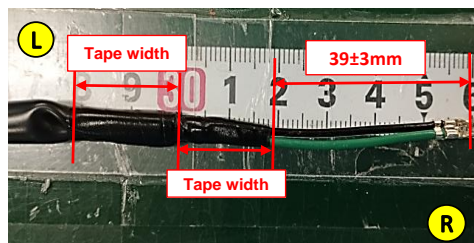
Taping 1
Black Sunprene tube to
Wire near terminal



1. Measure the end of the sunprene tube up to the end of the terminal pointed tip 59mm using both hands.



2. Hold the sunprene tube using left hand then start taping using right hand.

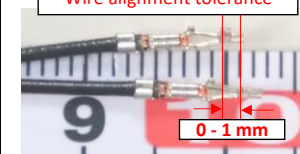


3. After taping, check the measurement, alignment and tape condition.

MEASURING TAPE



Wire alignment tolerance



1. No loose tape
2. No peel-off tape
3. No flip-out tape
4. No wrong use of tape
5. No wrong dimension

1 Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

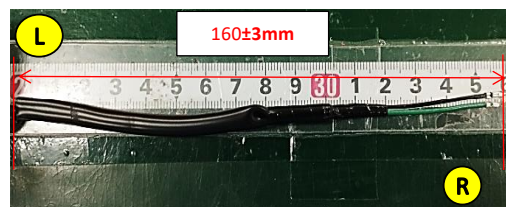
TOOLS/PPE

QUALITY POINTERS

7

P1

Taping 2
Vinyl tube to Sunprene
tube

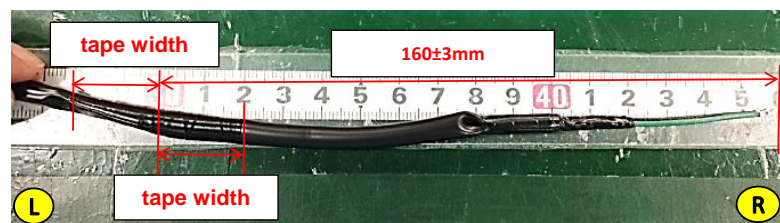


1. Measure the end of the corrugated tube up to the end of the terminal pointed tip 184mm.

Start of taping



2. Fix the Sunprene tube and the Vinyl tube using then start taping using right hand.



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

MEASURING TAPE



1

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
1. Make sure no gap between the terminals and Vinyl tube.

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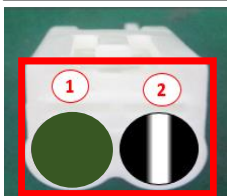
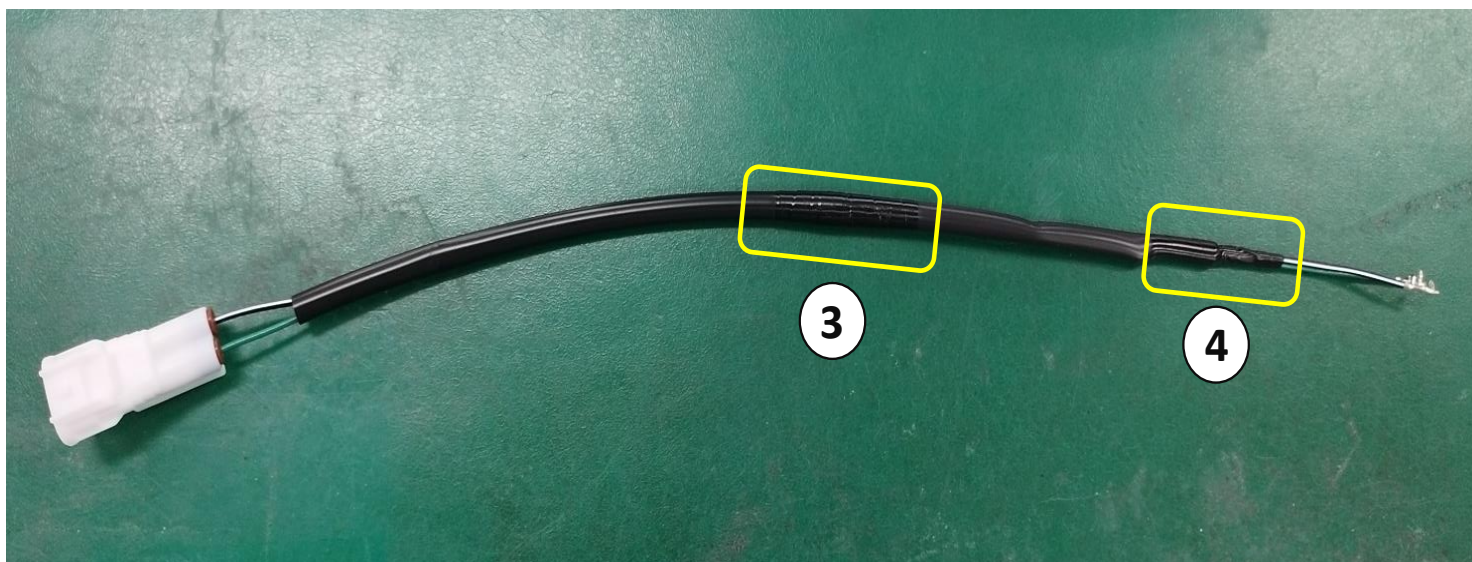
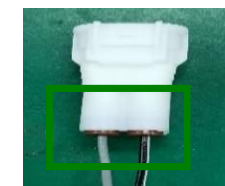
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7 of 7**PARTS:****n/a****JIG****n/a****QUALITY CHECKPOINTS****P1****7R0120-7020****GOOD****NO GOOD****4****GOOD****NO GOOD****1** No Wrong Insert**2 3** No Missing Tape**4** No Terminal Backing Out

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