



# WORK INSTRUCTION KITTING ASSEMBLY PROCESS

Effectivity Date:

November 05, 2021

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number:

240B/ 7M0514-7020B

Customer:

TRJ

Document No.:

WI-ENG-PDE-355

Purpose:

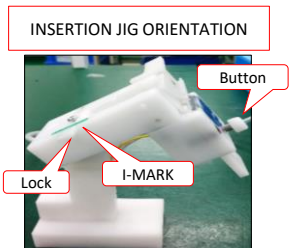

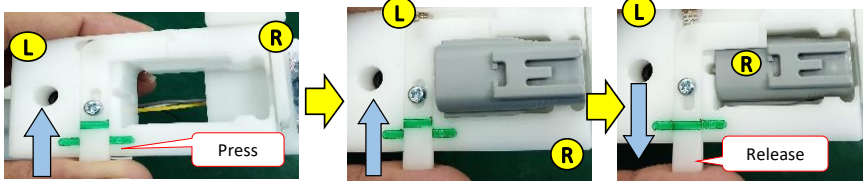
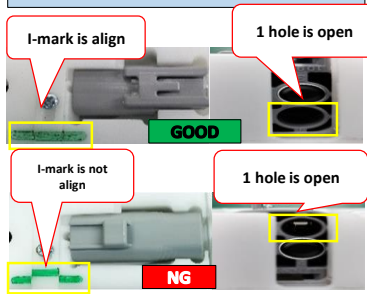




☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

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<b>PARTS:</b>	1. Connector 6188-0066 (GR)				<b>JIG:</b>	1. Insertion Jig							
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>						
1	Connector Setting 6188-0066 (GR)	<div><div><b>INSERTION JIG ORIENTATION</b> </div><div><b>CONNECTOR ORIENTATION</b> </div><div></div></div> <p>1. Press the lock of insertion jig using left thumb.</p> <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><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div> <div><b>Connector Orientation</b> </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> <p>Note: Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p> <p><i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p>				<b>Revision History</b>				<b>Prepared by</b>	<b>Reviewed by</b>	<b>Approved by</b>	<b>Noted by</b>
11/05/21	0	Initial issue	K. Doria	J. Loterte	C. Villanueva	A. Arañes							
Eff. Date	Rev. No	Details of Change	Prepared	Checked	Approved	Noted	Est. Date:	November 05, 2021					

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### PARTS:

1. AVSSf 0.3 Black wire L=825±3mm [2pcs.]

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

Wire insertion to  
Connector  
6188-0066 (GR)



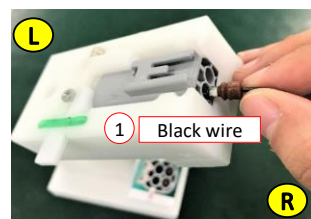
CONNECTOR  
ORIENTATION



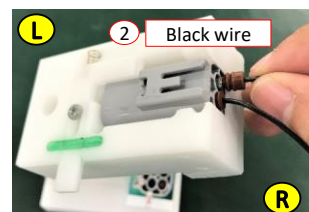
VISUAL REFERENCE



WIRE FACING



1. Get the **first Black wire** then insert to terminal slot **1** using right hand.  
*(Note: Insertion of wires must be from left to right.)*



2. Get the **2nd Black wire** then insert to terminal slot **2** using right hand.



3. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from the 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

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

*Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.*

*Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance*

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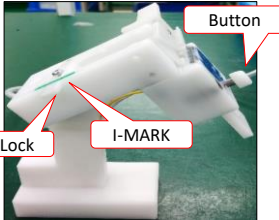

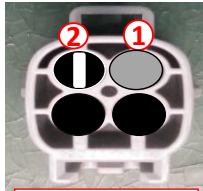
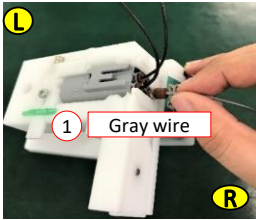
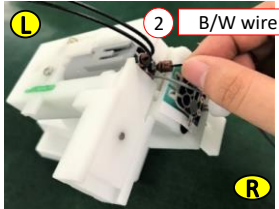
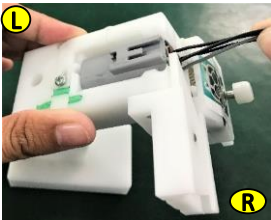
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## PARTS:

1. MRSW CP 7M0365-M040 (TVSSf 0.3 GR-B/W wire L=830±3mm)

**JIG**

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Connector 6188-0066 (GR)	<p><b>INSERTION JIG ORIENTATION</b></p>    <p><b>VISUAL REFERENCE</b></p>  <p><b>1 Gray wire</b></p> <p>1. Get the <b>Gray wire</b> then insert to terminal <b>slot 1</b> using right hand. After insertion, press the button using right thumb and slot for B/W will be opened.</p>  <p><b>2 B/W wire</b></p> <p>2. Get the <b>Black/white wire</b> then insert to terminal slot <b>2</b> using right hand.</p>  <p>3. 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	<p>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</p> <p>Note: Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p> <p><i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p> <p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p>

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**PARTS:**

1. Assy parts
2. Black Corrugated tube (with slit) Ø5 L=670±6mm

**JIG**

1. Locking Jig
2. Adaptor Jig

NO.

PROCESS NAME

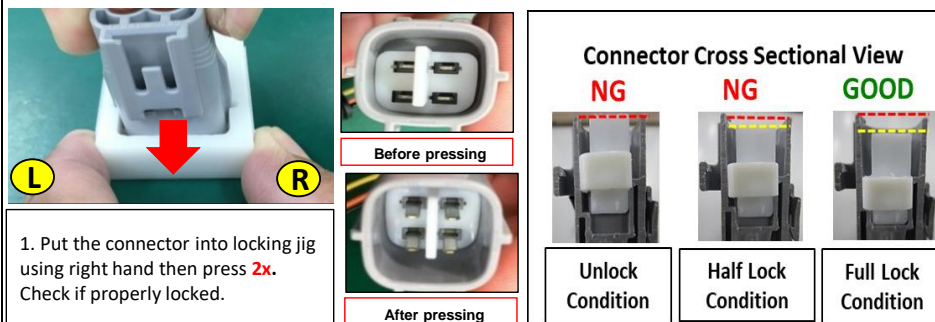
### WORK PROCEDURE/ ILLUSTRATION

**TOOLS/PPE**

## QUALITY POINTERS

4

### Connector Lock



### Locking Jig

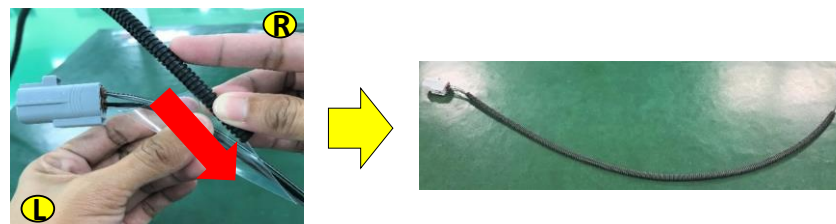


**NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK**

1. Use the provided locking jig per model
2. No unlock/half-locked connector

5

Wire insertion to  
Black Corrugated tube  
(with slit)  
Ø5 L=670±6mm



1. Get the adaptor jig using left hand then insert the **B/B** and **GR-B/W** wires using right hand. Get the corrugated tube  $\varnothing 5 \text{ L}=670 \pm 6 \text{ mm}$  (with slit) using right hand then start the insertion using both hand.

## COT Adaptor



1. No wrong usage of parts
2. No wires left in between the COT with slit

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