

**WORK INSTRUCTION**

Process Name/Title:

**KITTING ASSEMBLY PROCESS**

Effectivity Date:

**October 20, 2021**

Model code/Part number:

**910B****7L0126-7022**

Customer:

**TRQSS**

Validity Date:

**n/a**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Document No.:

**WI-ENG-PDE-271**

Revision No.:

**1**

Page No.:

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PARTS:		1. All parts (Connector 6189-0451 (W); AVSSf 0.3 Y-OR wires L=329±2mm; Black vinyl tube Ø7 L=56±3mm)				JIG	1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS		
1	n/a	<div><div>Table Lay-out</div><div>Connector 6189-0451 (W)/ Connector Tray</div><div>Black vinyl tube Ø7 L=56±3mm</div><div>AVSSf 0.3 Y wires L=329±2mm</div><div>AVSSf 0.3 OR wires L=329±2mm</div><div>Insertion jig</div><div>Terminal cover jig</div><div>Switch cover</div><div>Locking jig</div></div>				n/a	1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools		
Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/20/21	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

Est. Date: September 17, 2021

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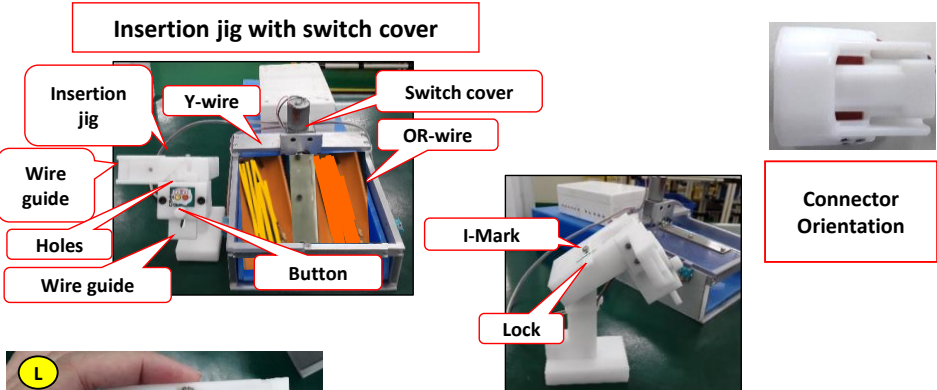
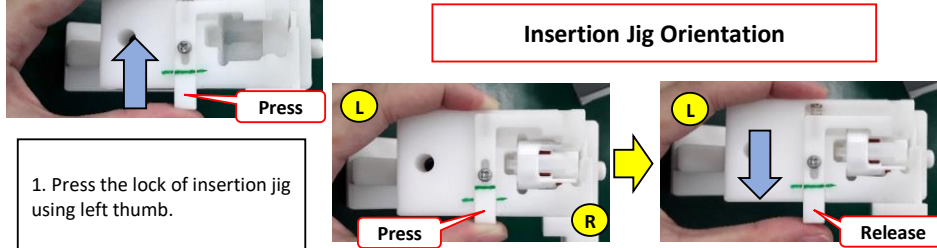
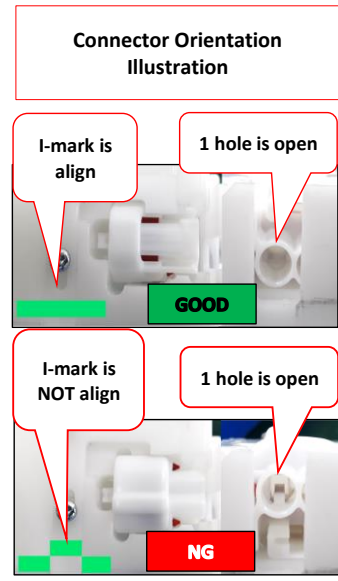
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PARTS:		1. Connector 6189-0451 (W) 2. AVSSf 0.3 Y wires L=329±2mm 3. AVSSf 0.3 OR wires L=329±2mm			JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	n/a	<p>Connector setting to insertion jig 6189-0451 (W)</p>  <p><b>Insertion Jig Orientation</b></p>  <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector <b>6189-0451 (W)</b> into jig using right hand then release the lock using left thumb. <i>Note: Follow the connector orientation.</i></p> <p>3. Push the guide using right thumb. The slot for <b>Yellow wire</b> will be opened.</p>			n/a	<p><b>Connector Orientation Illustration</b></p>  <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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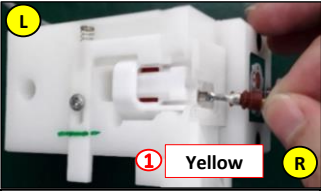
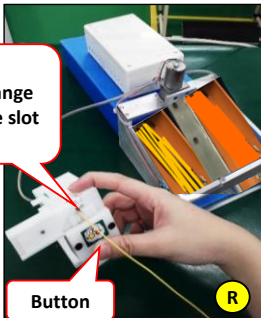
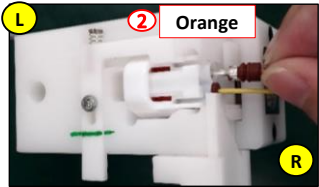
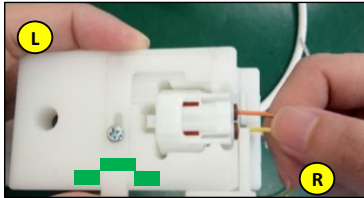
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PARTS:	n/a			JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	Wire insertion to connector 6189-0451 (W)	<div><p>Wire Facing</p></div> <div><p>1. Hold the insertion jig using left hand, get <b>Yellow wire</b> and insert to connector slot <b>1</b> using right hand.</p></div> <div><p>Orange wire slot</p><p>2. Press the button using right thumb, slot for <b>Orange wire</b> will be opened.</p><p>Button</p></div> <div><p>3. Hold the insertion jig using left hand, get <b>Orange wire</b> and insert to connector slot <b>2</b> 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><b>Note:</b> Please hold the wire near terminal during insertion.</p> <ol style="list-style-type: none"><li>1. No loose insertion</li><li>2. No wrong insertion</li><li>3. One by one insertion</li><li>4. No deformed terminal</li><li>5. No wrong wire facing</li></ol> <p>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p> <p><b>Note:</b> Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p><b>Note:</b> Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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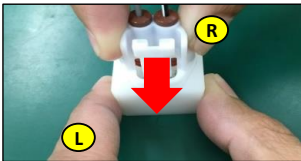





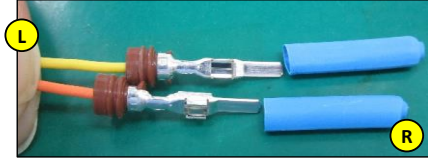

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PARTS:		1. Assy parts 2. Black vinyl tube Ø7 L=56±3mm	JIG	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Connector lock	 <div>1. Put the connector into locking jig using right hand then press <b>2x</b>. Touch the connector lock if properly locked.</div>  <div>Before pressing</div>  <div>After pressing</div>	<div>Locking jig</div> 	<div><b>NOTE:</b> <b>MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</b></div> <div>1. Use the provided locking jig per model 2. No unlock/half-lock connector</div>
5	Wire insertion to Black vinyl tube Ø7 L=56±3mm	 <div>1. Get the cover jig then insert to <b>Y-OR wires</b> using right hand.</div>  <div>2. Get the vinyl tube <b>Ø7 L=56±3mm</b> using right hand then insert the <b>Y-OR wires</b> using left hand.</div>  <div>3. After insertion, remove the cover jig using right hand.</div>	<div>Terminal cover jig</div> 	<div>1. No wrong usage of parts 2. No damaged rubber seal</div>

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