



# WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

April 23, 2021

Product Name/Code: **101D / 7N0098-7020B**

Customer: **TRJ**

Validity Date:

n/a

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

WI-ENG-PDE-240A

Revision No.:

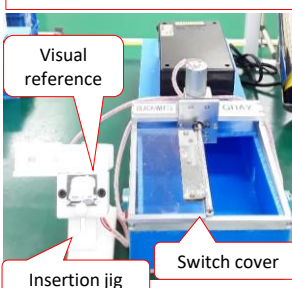
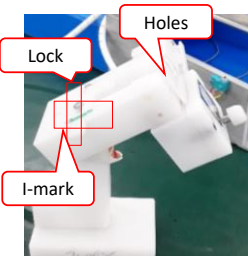



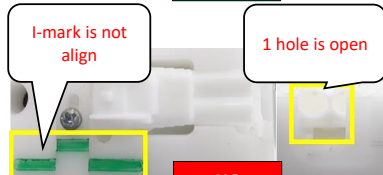
1

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**PARTS:** 1. Connector 6188-0407 (W)

JIG: 1. Insertion jig w/ switch cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Connector setting to insertion jig 6189-0407 (W)	<p><b>Insertion jig with switch cover</b></p>  <p><b>Lock</b> <b>I-mark</b> <b>Holes</b></p>  <p><b>Connector orientation</b></p>  <p><b>L</b> <b>Press</b> <b>R</b> <b>Release</b></p>  <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector <b>6188-0407 (W)</b> into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></p> <p>3. Check the holes/terminal slot for B/W wire.</p>	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>Connector Orientation Illustration</b></p> <p><b>I-mark is align</b> <b>1 hole is open</b> <b>GOOD</b></p>  <p><b>I-mark is not align</b> <b>1 hole is open</b> <b>NG</b></p>  <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

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by:	Checked by:	Approved by:	Noted by:
04/23/21	1	Change part number due to change wire arrangement. Change from pre-launch to masspro.	D.Castillo	C. Villanueva	A. Shimamura	A. Arañes	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes
03/09/21	0	Initial issue.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes

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PROTOTYPE



PRE-LAUNCH



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### PARTS:

1. TVSSf 0.3 wires B/W L=584mm; GR L=584mm

### JIG

1. Insertion jig with switch cover

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### QUALITY POINTERS

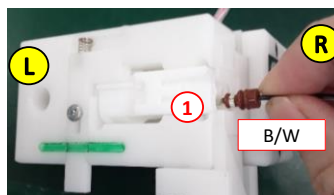
2

P1

Wire Insertion to  
connector  
6188-0407 (W)

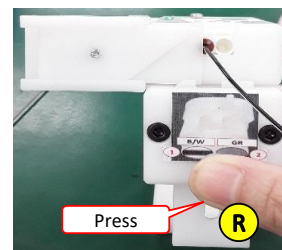


Wire facing



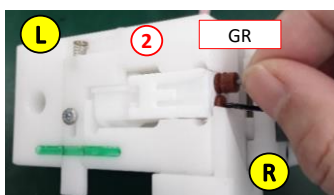
B/W

1. Get **B/W wire** then insert to terminal slot ① using right hand.



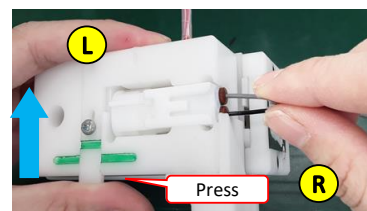
Press

2. Push the button after insertion. Slot for **GR wire** will be open.



GR

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



Press

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 loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed 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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PRE-LAUNCH



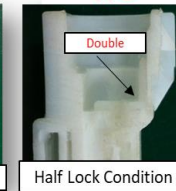
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PARTS:		1. Assy parts 2. Black Corrugated tube Ø5 L=433±3mm (no slit)	JIG	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Connector lock	<div></div> <div></div> <div><b>CONNECTOR CROSS SECTIONAL VIEW</b> </div> <div>Press the connector into locking jig using right hand <b>2x</b>. Check the connector to confirm if properly locked.</div>	<b>LOCKING JIG</b> 	<b>NOTE:</b> MANUAL LOCKING MAY CAUSE DAMAGED LOCK  1. Use the provided locking per model 2. No unlock/half-locked connector
4	Wire insertion to Corrugated tube Ø5 L=433±3mm (no slit)	<div></div> <div>1. Get the terminal cover jig using right hand then insert the GR and B/W wires.</div> <div></div> <div>2. Get the Corrugated Ø5 L=433±3mm (no slit) using right hand and insert the GR and B/W wires</div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>	<b>TERMINAL COVER JIG</b> 	1. No wrong use of parts 2. No deformed terminal

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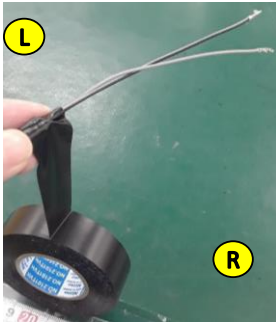

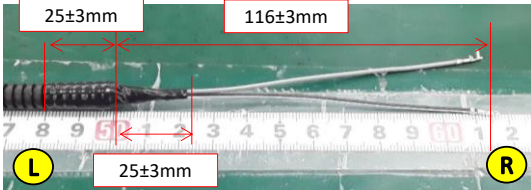

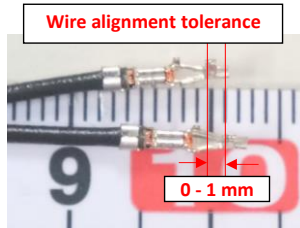

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PARTS:		1. Assy parts 2. Black tape [1pc]	3. Black Sunprene tube Ø9 L=97±3mm	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Taping COT to wire near terminal	  <p>1. Hold the COT using left hand. Get <b>Black tape</b> using right hand and conduct pre taping.</p> <p>2. Measure the end of COT to terminal tip <b>116±3mm</b> and continue taping process. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>3. After taping, check the dimension, taping condition and wire alignment.</p>		MEASURING TAPE 	 <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong dimension 5. No missing tape 6. No wrong use of tape</p> <p><b>Note:</b> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p>
6	Wire insertion to sunprene Ø9 L=97±3mm	 <p>1. Get the Black Sunprene tube <b>Ø9 L=97±3mm</b> using right hand and insert the GR and B/W wires</p>		n/a	1. No wrong use of parts 2. No deformed terminal

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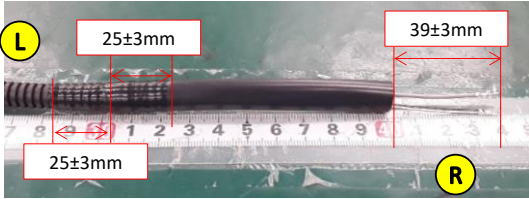

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PARTS:		1. Assy parts 2. Black tape [1pc]	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P2	<p>Taping COT to Sunprene</p>   <p>1. Hold the COT using left hand and check the dimension from Sunprene to terminal tip <b>39±3mm</b>.</p>  <p>2. Hold the assy parts, get <b>Black tape</b> and proceed to taping process. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p> <p>3. After taping, check the dimension and taping condition.</p>	<p>MEASURING TAPE</p> 	<p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none"><li>1. No peel-off tape</li><li>2. No flip out tape</li><li>3. No loose tape</li><li>4. No wrong dimension</li><li>5. No missing tape</li><li>6. No wrong use of tape</li></ol>

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