



WORK INSTRUCTION KITTING ASSEMBLY PROCESS

Effectivity Date:

July 21, 2021

Process Name/Title:

Validity Date:

n/a

Product Name/Code:

480A / A7040E

Customer:

TRQSS

Document No.:

WI-ENG-PDE-304

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO





Revision No.:

1

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PARTS:		1. Pre-assembled parts (Connector 6188-0407(W), Clip type clamp 82711-1E360(W)) 2. AVSSf wires GR-B/W L=216±2mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	<div>Connector setting to Insertion jig 1 6188-0407 (W)</div>	<div><div><div>INSERTION JIG WITH SWITCH COVER</div><div><div>Insertion jig</div><div>B/W wire</div><div>Switch cover</div><div>GR wire</div><div>I-mark</div><div>Lock</div><div>Holes</div><div>Wire guide</div><div>Holes</div><div>Wire guide</div><div>Button</div></div><div><div>Lock</div><div>Holes</div><div>I-mark</div></div><div>CONNECTOR ORIENTATION</div><div>INSERTION JIG ORIENTATION</div></div><div><div><div>1</div><div>Press</div></div><div><div>2</div><div>Insert the connector 6188-0407 (W) into jig using right hand and release the lock. Note: Follow the connector orientation.</div></div><div><div>3</div><div>Push the guide using right thumb. The slot for B/W wire will be opened.</div></div></div></div>		<div><div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in</div><div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>	<div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div><div><div>1</div><div>Note: Refer to WI-PRO-ASY-180B for the process of Clip Clamp Attachment</div></div></div>

Revision History								Prepared by	Reviewed by	Approved by	Noted by		
07/21/21	1	Transfer process owner from Production WI (WI-PRO-ASY-098) to Engineering WI (WI-ENG-PDE-304). Improve process illustration and quality pointers. Change connector color in accordance with color standardization for plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts).				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
10/23/18	0	Initial issue				C. Ricafort	W. Carbillon	O. Merin	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted	Est. Date:	October 23, 2018		

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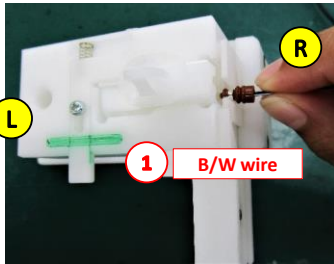
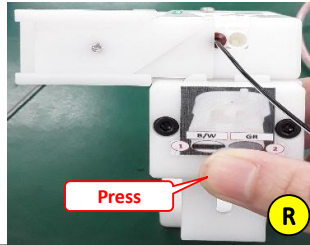
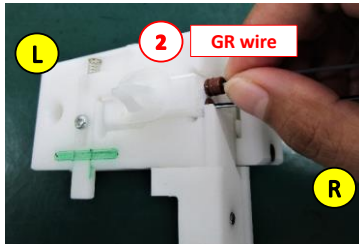
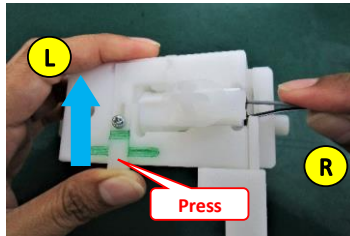
☒ MASSPRO

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PARTS:	n/a	JIG	1. Insertion jig with switch cover	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire Insertion to connector 6188-0407 (W)	<div><div><p>WIRE FACING</p></div><div><p>1. Hold the insertion jig using left hand. Get the Black/White wire and insert to terminal slot ① using right hand.</p></div><div><p>2. Press the button using right thumb. Slot for Gray wire will be opened.</p></div><div><p>3. Get the Gray wire then insert to terminal slot ② 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></div> <div>n/a</div> <div><div>①</div><div><p>Note: Please hold the wire near terminal during insertion.</p></div><div><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p></div><div><p>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p></div></div>		

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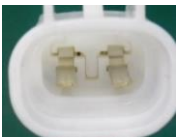

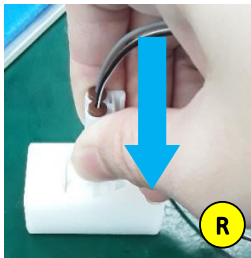
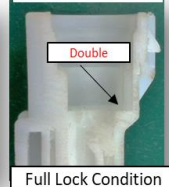
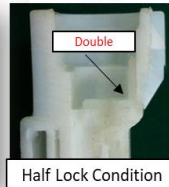
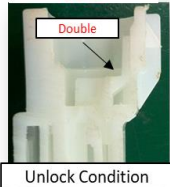



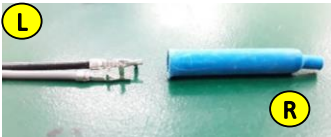

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PARTS:

1. Assy parts
2. Black Corrugated tube (no slit) Ø7 L=125±3mm

JIG

1. Locking jig
2. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Connector lock	<div></div> <div></div> <div>CONNECTOR CROSS SECTIONAL VIEW  Unlock Condition Half Lock Condition Full Lock Condition</div> <div>1. Put the connector into locking jig using right hand then press 2x. Touch the connector lock if properly locked.</div>	<div>Locking Jig</div> 	<div>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</div> <ol style="list-style-type: none">1. Use the provided locking jig per model2. No unlock/half-lock connector
4	Wire insertion to Black Corrugated tube Ø7 L=125±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 Ø7 L=125±3mm (no slit) using right hand and insert the GR-B/W wires.</div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>	<div>Terminal Cover Jig</div> 	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal

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