



WORK INSTRUCTION

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

Model Code/Part Number: **920B / 7R0118-7020B** Customer: **TRMX**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

December 06, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-552A

Revision No.:

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PARTS:

1. All parts: Connector 6189-1142 (W); AVSSf 0.3 wires Y-OR L=695±3mm; Black COT (no slit) ø5 L=516±3mm; Black COT (no slit) ø5 L=130±3mm; Connector 6189-1161 (B); Black sunprene tube ø5 L=125±3mm; Black COT (no slit) ø5 L=247±3mm; MRSW CP TVSSf 0.3 wires G-B/W L=961±3mm; Black tape; Green tape

JIG:

1. Insertion jig with switch cover
2. Insertion jig
3. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

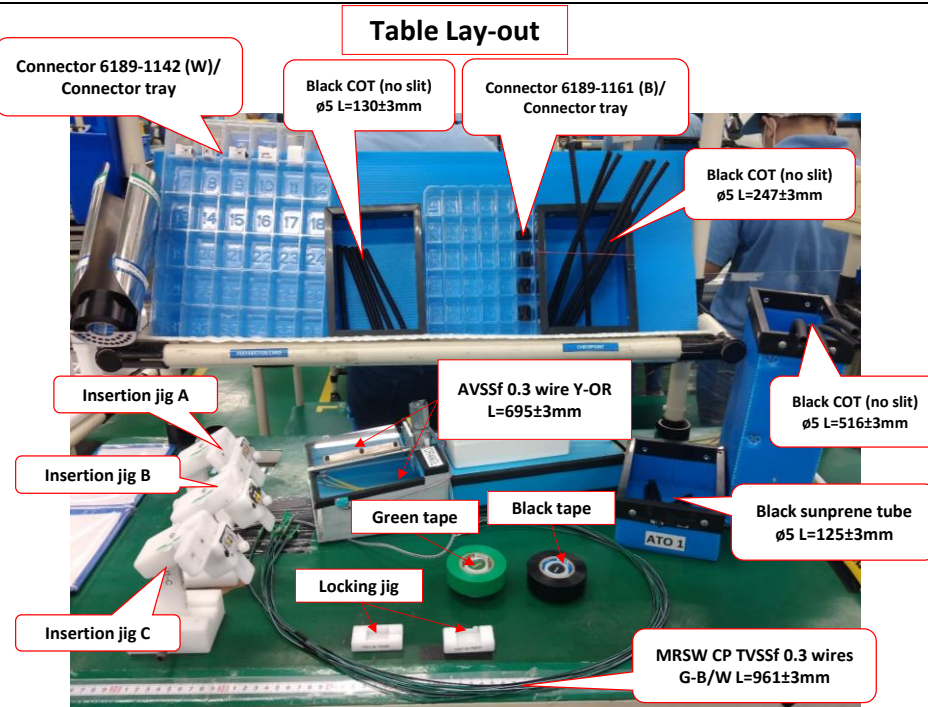
TOOLS/PPE

1 QUALITY POINTERS

1

P1

Table Lay-out



Safety Instruction

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
2. WI-PRO-KIT-005 Wire Taping without Vinyl Tube

1. No missing parts/tools
2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
12/06/22	1	Additional table lay-out ; Quality checkpoints - as improvement of documentation and process. Improve work procedure/illustration/quality pointers in all process. Provide tools: Insertion and locking jig	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
06/29/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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PARTS:

1. Connector 6189-1142 (W)

JIG

1. Insertion jig with switch cover

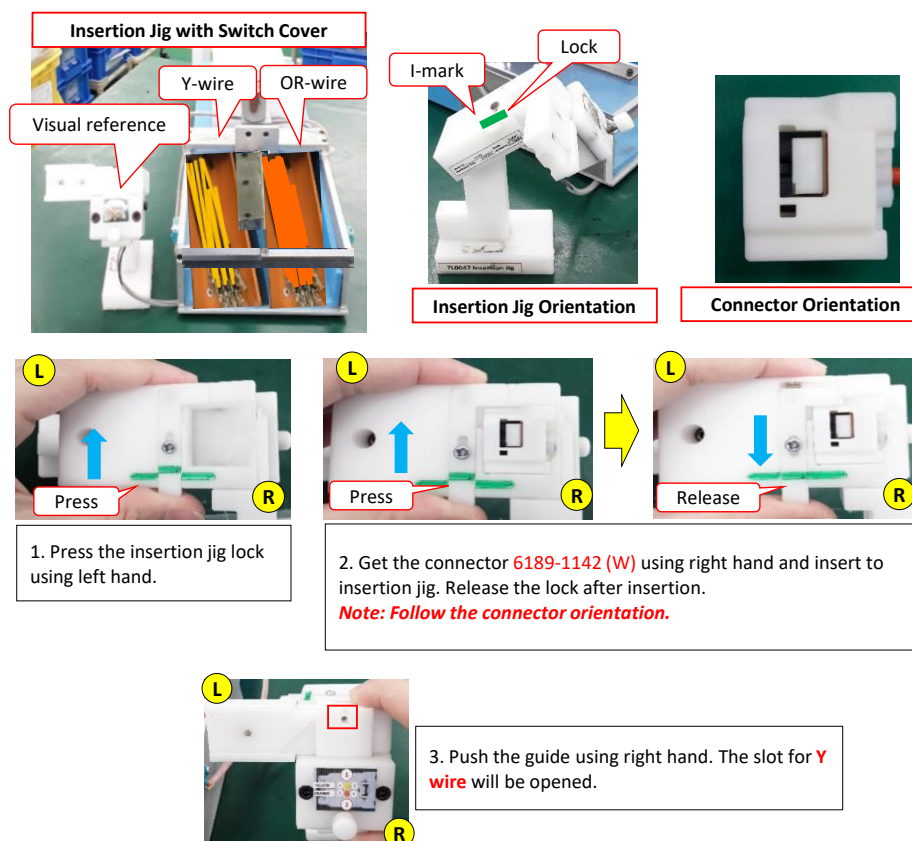
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

2

P1

Connector setting to
Insertion jig
6189-1142 (W)

1



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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PROTOTYPE



PRE-LAUNCH



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PARTS:


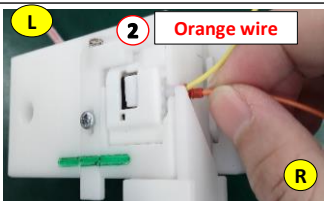
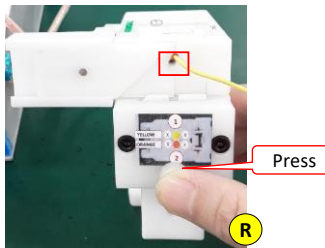
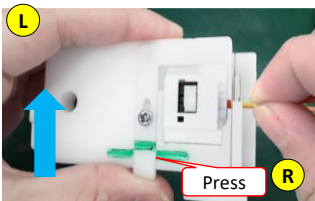
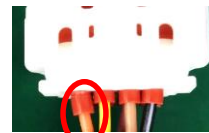


1. AVSSf 0.3 wire Y-OR L=695±3mm

2. Black Corrugated tube ø5 L=516±3mm (no slit)

3. Black Corrugated tube ø5 L=130±3mm (no slit)

JIG

1. Insertion jig with switch cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Wire Insertion to connector 6189-1142 (W)	<p>1 Yellow wire</p>  <p>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</p> <p>2 Orange wire</p>  <p>3. Get the Orange wire then insert to terminal slot 2 using right hand.</p> <p>Press</p>  <p>2. Press the button using right thumb. Slot for Orange wire will be opened.</p> <p>4</p>  <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>	n/a	<p>Note: During insertion, hold the wire not rubber seal to prevent sagging.</p>  <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>
4	Wire insertion to COT (no slit) ø5 L=516±3mm ø5 L=130±3mm	<p>1</p>  <p>1. Get the Corrugated tube ø5 L=516±3mm (no slit) using right hand then insert the Y-OR wires.</p> <p>2</p>  <p>2. Get the Corrugated tube ø5 L=130±3mm (no slit) using right hand then insert the Y-OR wires.</p>	n/a	<p>1. No wrong use of parts 2. No deformed terminal</p>

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☐ PROTOTYPE

☐ PRE-LAUNCH

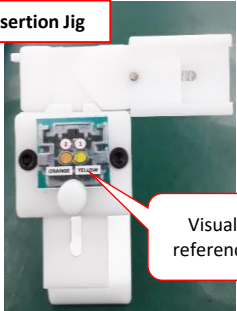
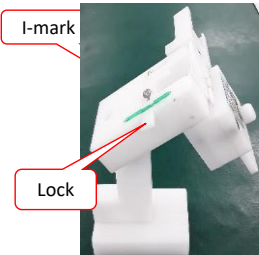
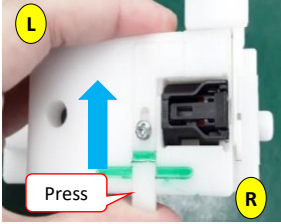

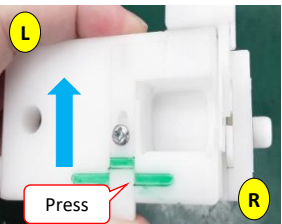
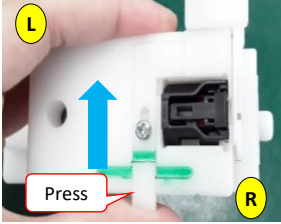
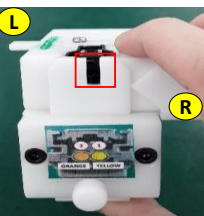


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PARTS:		1. Connector 6189-1161 (B)		JIG	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
5	P1	<div><div><div>Insertion Jig</div><div>Visual reference</div></div><div><div>I-mark</div><div>Lock</div></div><div><div>Insertion Jig Orientation</div><div>Press</div></div><div><div>Connector Orientation</div><div>Release</div></div><div><div>1. Press the insertion jig lock using left hand.</div><div>2. Get the connector 6189-1161 (B) using right hand and insert to insertion jig. Release the lock after insertion. Note: Follow the connector orientation.</div><div>3. Push the guide using right hand. The slot for Y wire will be opened.</div></div></div>		n/a	<div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>1 hole is open</div><div>NG</div></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>

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7R0118-7020B

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☐ PROTOTYPE

☐ PRE-LAUNCH


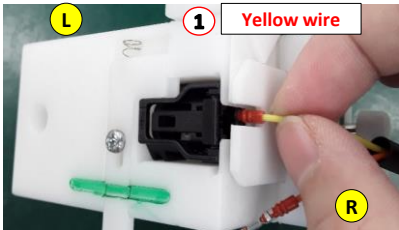

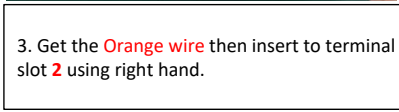
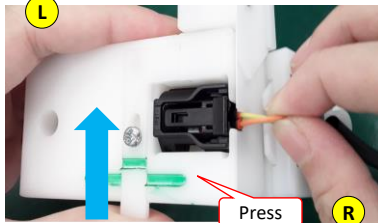
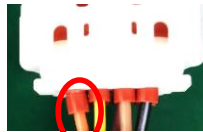
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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
6	P1 Wire insertion to connector 6189-1161 (B)	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb. Slot for Orange wire will be opened.</p></div> <div><p>3. Get the Orange 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>		n/a	<div><p>Note: During insertion, hold the wire not rubber seal to prevent sagging.</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>Important reminders/Note/s:</p><p>1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p><p>Document references:</p><p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p></div>

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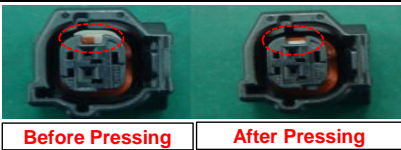


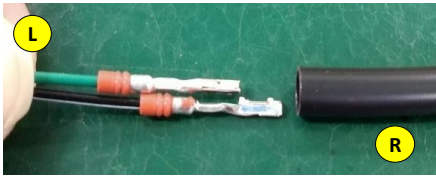

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black Sunprene tube $\phi 5$ L=125 \pm 3mm		3. MRSW CP TVSSf 0.3 wires G-B/W L=961 \pm 3mm 4. Black COT (no slit) $\phi 5$ L=247 \pm 3mm	JIG	1. Locking jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		1 QUALITY POINTERS
7	P1	Connector lock	 <div>Put the connector into locking jig using right hand then press 2x using both hands. Check the connector lock if properly lock.</div>  	LOCKING JIG 		Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR 2. SET ASIDE THE ASSY PARTS 1. Use the provided jig per connector 2. No unlock/half-locked connector
8		Wire insertion to Black sunprene tube $\phi 5$ L=125 \pm 3mm	 <div>1. Get the sunprene tube $\phi 5$ L=125\pm3mm using right hand then insert the MRSW CP TVSSf 0.3 wires G-B/W L=961\pm3mm using left hand.</div>	n/a		Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No wrong usage of parts
9		Wire insertion to COT (no slit) $\phi 5$ L=247 \pm 3mm	 <div>1. Get the corrugated tube (no slit) $\phi 5$ L=247\pm3mm using right hand then insert the G-B/W wires using left hand.</div>	n/a		1. No wrong use of parts 2. No deformed terminal

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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
10	Wire insertion to assy parts	<p>1. Get the assy parts using left hand then insert the G-B/W wires to COT (no slit) Ø5 L=516±3mm using right hand.</p>		n/a	1. No wrong insertion 2. No deformed terminal
11	Connector setting to Insertion jig 6189-1142 (W) (Assy parts)	<p>1. Press the lower wire guide using right thumb to make sure connector with inserted wires will be inserted.</p> <p>2. Press the Insertion jig lock using left thumb. Get the assy parts and insert the connector using right hand.</p> <p>3. After insertion, release the insertion jig lock using left thumb.</p>		n/a	CONNECTOR ORIENTATION ILLUSTRATION <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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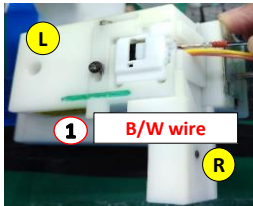

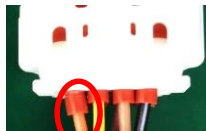
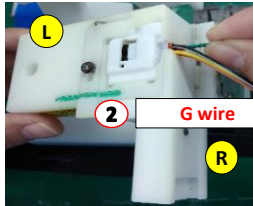
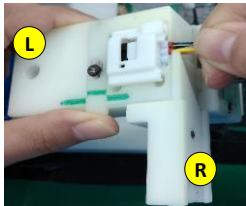
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
12	P1 Wire insertion to Connector (Assy parts)	<div><div></div><div></div></div> <div><p>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</p><p>2. Press the button using right thumb. Slot for Orange wire will be opened.</p></div>		n/a	<div><div></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> <div><p>Important reminders/Note/s:</p><p>1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p><p>Document references:</p><p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p></div>
13		Connector lock	<div><div></div><div></div></div> <div><p>3. Get the Orange wire then insert to terminal slot 2 using right hand.</p><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>		

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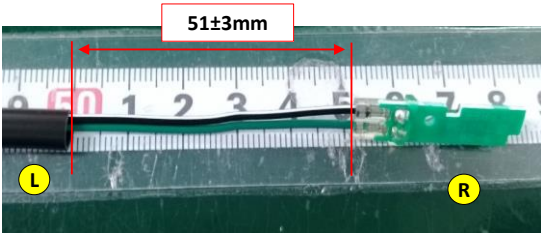
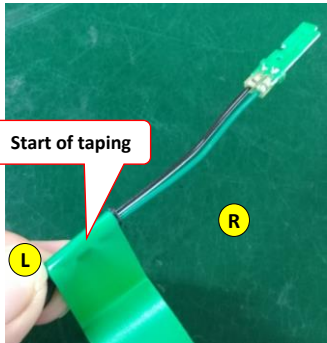
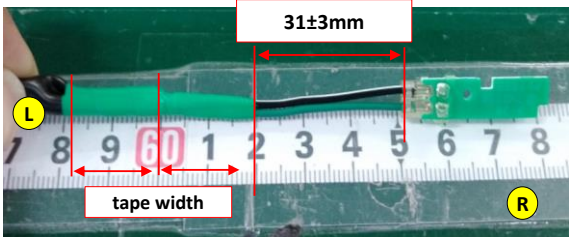

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Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Assy parts 2. Green tape	JIG	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	1 QUALITY POINTERS
14	P1 Taping 1 Black sunprene tube to wire near PCB	<div><p>51±3mm</p><p>1. Hold the sunprene tube using left hand then measure from end of sunprene tube up to edge of PCB 51±3mm using both hands.</p></div> <div><p>Start of taping</p><p>2. Get the Green tape using right hand then start taping process using both hands.</p></div> <div><p>31±3mm</p><p>tape width</p><p>3. After taping, check the measurement and taping condition.</p></div>	<div><p>MEASURING TAPE</p></div>	<p>Important reminders/Note/s:</p> <ul style="list-style-type: none">1. Use GREEN TAPE only2. Please use calibrated/verified measuring tape when getting the measurement. <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension

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☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts

JIG

n/a

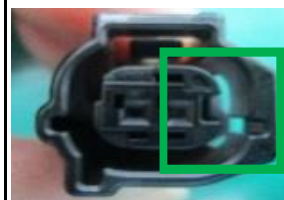
1 QUALITY CHECKPOINTS

P1

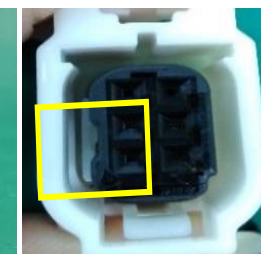
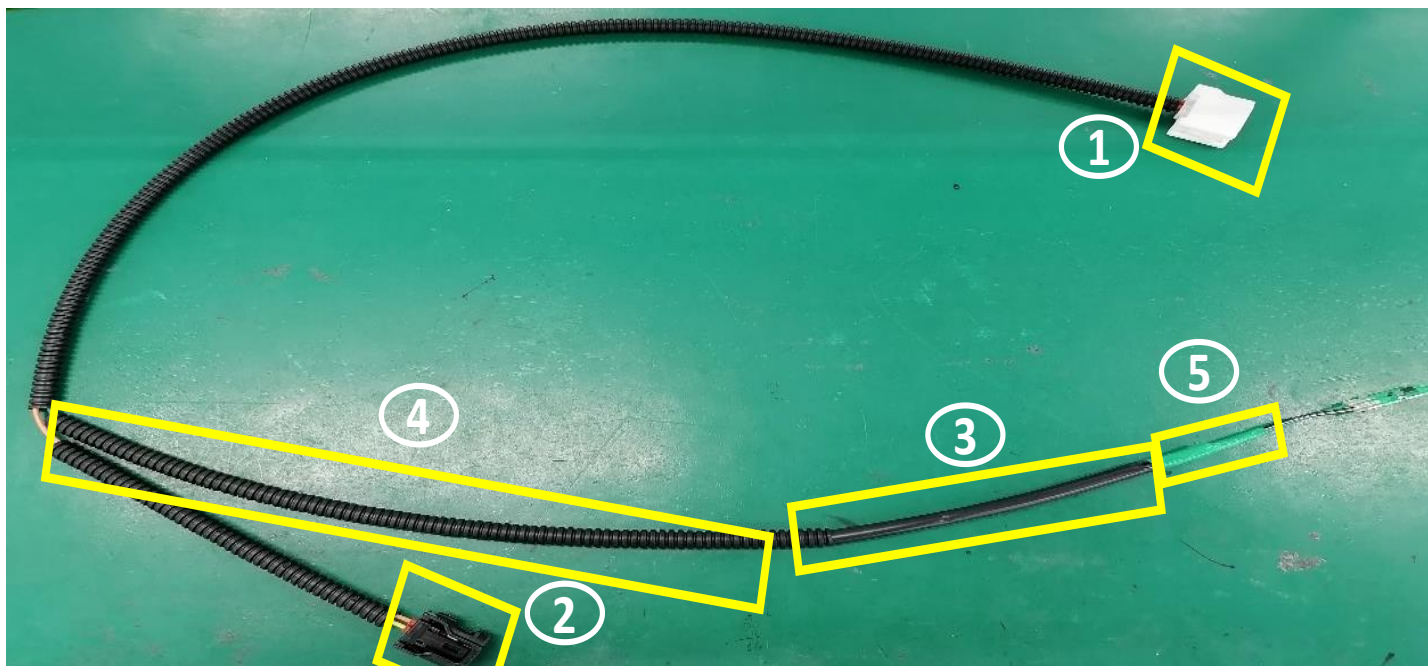
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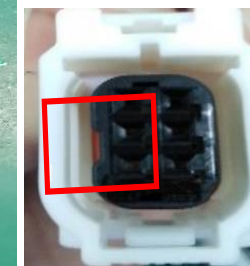
NO GOOD



GOOD



GOOD



NO GOOD

① ② **No WRONG INSERT**
No TERMINAL BACKING OUT

③ **No MISSING VINYL**
⑤ **No MISSING TAPE**

④ **No MISSING COT**

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