

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 21, 2022

Model Code/Part Number:

011B / 7M0364-7021

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-420A

Revision No.:

1

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PARTS:

1. All parts: Connector 6189-0451 (W); TVSSf 0.3 G-B/W L=610±3mm; Black COT ø5 L=435±4mm (no slit); Black tape [1pc.]

JIG:

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

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****1 QUALITY POINTERS**

1

P1

Table Lay-out

Connector 6189-0451 (W)/
Connector tray

Table Lay-out

Insertion jig A

TVSSf 0.3 G-B/W
L=610±3mmBlack COT
ø5 L=435±4mm
(no slit)

Locking jig

Terminal
cover jigBlack tape/Tape
holder**Safety Instruction**

Be sure to wear required 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

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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
12/21/22	1	Improve quality pointers: Reminders/notes and references. Inclusion of Quality checkpoints	M. Catapang	J. Loterte	C. Villanueva	A. Arañes		M. Catapang	J. Loterte	C. Villanueva	A. Arañes
02/21/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes		M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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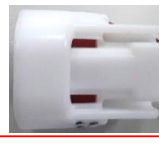
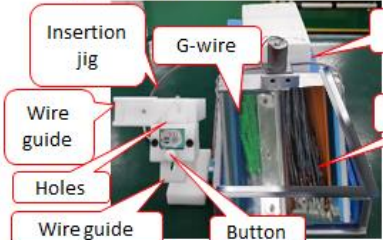
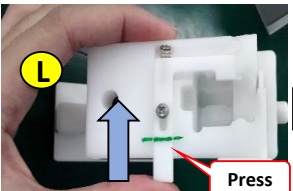
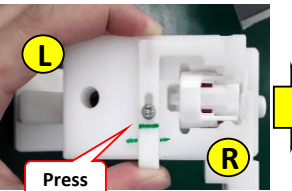



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PARTS:	1. Connector 6189-0451 (W)			JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6189-0451 (W)	<div data-bbox="593 422 1518 1284"><p>INSERTION JIG WITH SWITCH COVER</p><p>Wire facing</p><p>Press</p><p>Release</p><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6189-0451 (W) into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></p><p>Push the guide</p><p>3. Push the guide using left hand. The slot for B/W wire will be opened.</p></div>		n/a	<div data-bbox="1780 422 2139 1013"><p>Connector Orientation Illustration</p><p>GOOD</p><p>NG</p></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>

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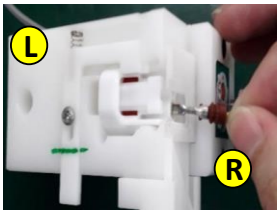
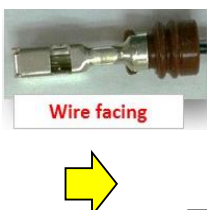
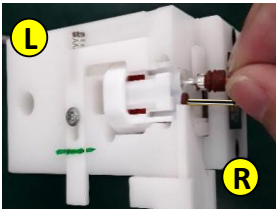

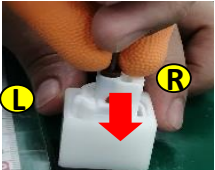
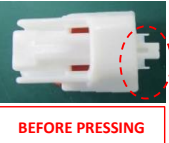



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PARTS:	1. TVSSf 0.3 G-B/W L=610±3mm			JIG	1. Insertion jig with switch cover 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
3	P1 Wire insertion to connector 6189-0451 (W)	 1. Get the B/W wire then insert to terminal slot ① using right hand.  2. After insertion of B/W wire press the button using right hand. The slot for G wire will be opened.  3. Get the G wire then insert to terminal slot ② using right hand.  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	Important reminders/Note/s: 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing 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. Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
4	Connector Lock	 1. Put the connector into locking jig then press 2x using both hands. Check the lock if properly locked.  BEFORE PRESSING  AFTER PRESSING  Check the double lock deformation		LOCKING JIG 	Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR 1. No half-locked and unlock 2. No lock deformation 3. Use provided jig tool to lock the connector

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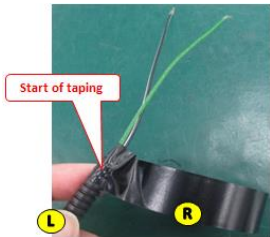



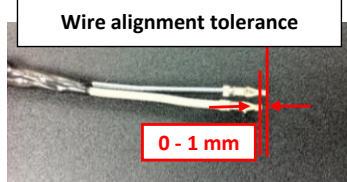
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PARTS:		1. Assy parts 2. Black Corrugated tube $\phi 5$ L=435 \pm 4mm (no slit)	JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	1 QUALITY POINTERS
5	Wire insertion to Black Corrugated tube $\phi 5$ L=435 \pm 3mm (no slit)	 1. Get the terminal cover jig using right hand and insert wires using left hand.  2. Get the black corrugated tube (no slit) $\phi 5$ L=435 \pm 3mm using right hand and insert the wires using left hand.  3. After insertion, remove the terminal cover jig using right hand.	TERMINAL COVER JIG 	1. No wrong usage of parts 2. No deformed terminal
6	P1 Taping 1 Black corrugated tube to wire near terminal	 1. Hold the corrugated tube using left hand and start taping using right hand.  2. Measure from end of the corrugated tube up to terminal tip 139 \pm 3mm and then continue the taping process.  3. After taping, check the measurement, wire alignment and taping condition.	MEASURING TAPE 	 Wire alignment tolerance 0 - 1 mm 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.

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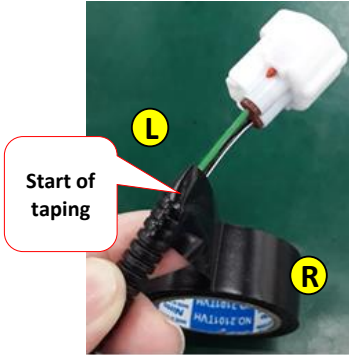
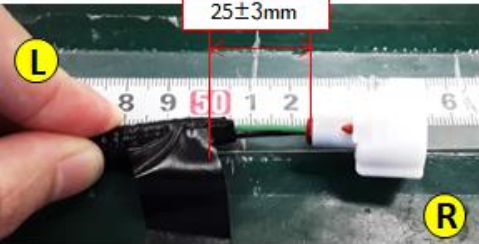
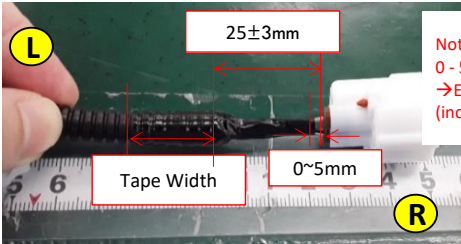

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5 of 6**PARTS:**

1. Assy parts
2. Black tape

JIG**n/a**

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	1 QUALITY POINTERS
7	P1 Taping 2 COT to wire near connector	 <p>1. Hold the corrugated tube using left hand. Get Black tape using right hand and start pre-taping using both hands.</p>  <p>2. Measure the corrugated tube up to connector 25±3mm using left hand then proceed to taping using both hands.</p>  <p>Note: 0 - 5mm → End tape up to connector (includes rubber seal)</p> <p>3. After taping, check the measurement and taping condition.</p>		<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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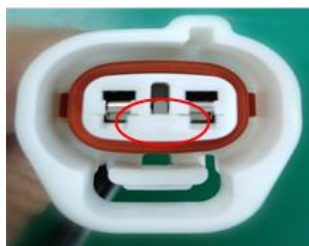
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PARTS:

1. Assy parts

JIG

n/a

1 QUALITY CHECKPOINTS**P1****7M0364-7021****GOOD****NO GOOD****1 No Unlock/ Half Lock Connector****2 No Wrong Insert****3 4 No Missing Tape****5 No Terminal Backing Out****5****GOOD****NO GOOD**

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