

**WORK INSTRUCTION**

Process Name/Title:

**OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

February 18, 2022

Validity Date:

n/a

Model Code/Part number: **587B / 7M0533-7021**

Customer:

**TRJ**

Document No.:

WI-ENG-PDE-411

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

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**PARTS:**

1. All parts; Connector 6188-0066 (GR); TVSSf 0.3 wires G L=826±3mm; B/W L=826±3mm; Black Corrugated tube Ø7 L=650±4mm (no slit)

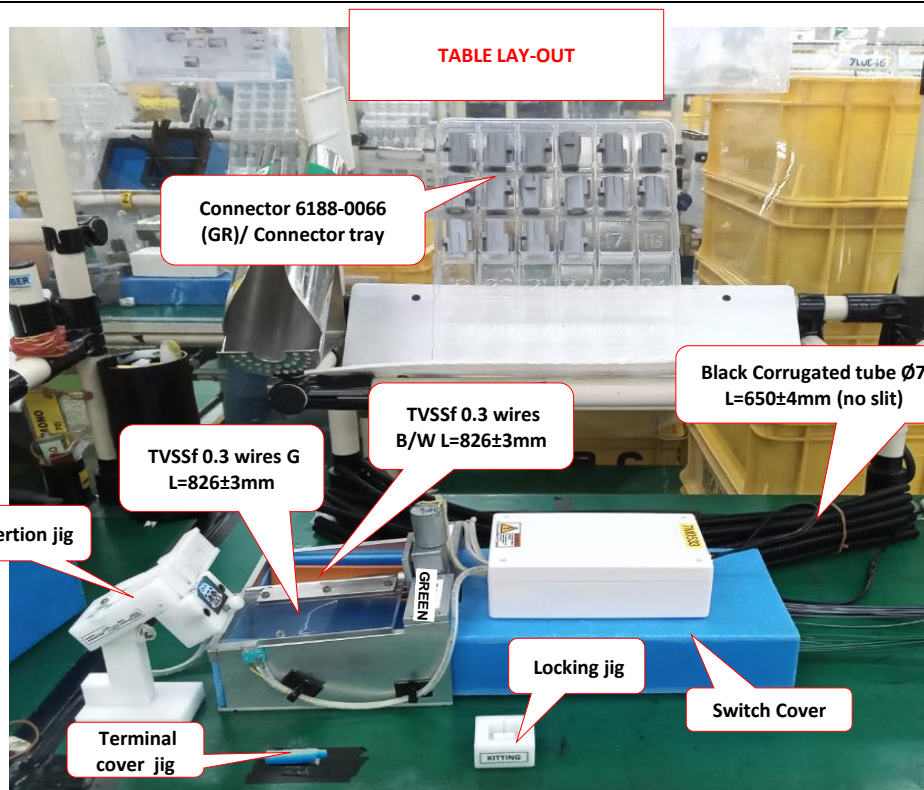
JIG:

1. Insertion jig w/ switch cover
2. Locking jig
3. Terminal cover jig

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

1

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.

**Note: Please 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	Prepared by	Reviewed by	Approved by	A. Arañes
02/18/22	0	Initial Issue	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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### PARTS:

1. Connector 6188-0066 (GR)  
With inserted dummy seal P/N: 7160-9465 (B) [2pcs]

### JIG

1. Insertion jig w/ switch cover

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

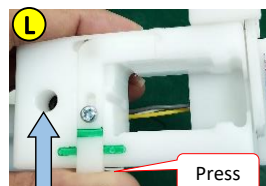
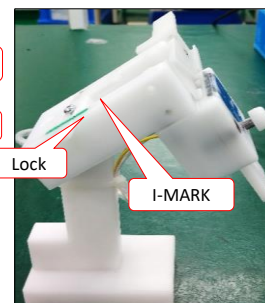
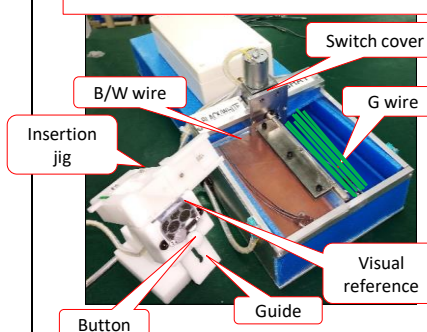
### TOOLS/PPE

### QUALITY POINTERS

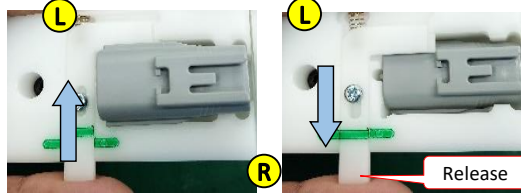
2

Wire insertion to  
Connector  
6188-0066 (GR)

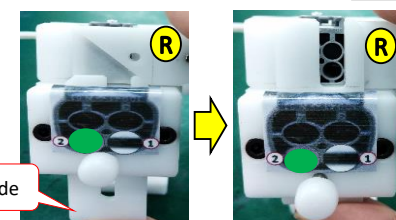
#### INSERTION JIG WITH SWITCH COVER



1. Press the lock of insertion jig using left thumb.



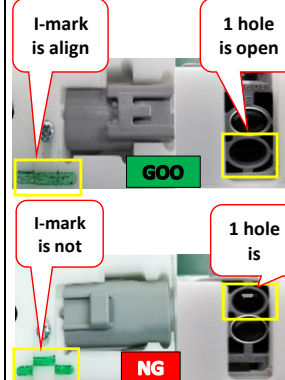
2. Insert the connector **6188-0066 (GR)** into jig using right hand and release the lock.



3. Push the guide upward using right thumb. Check the holes/terminal slot for **B/W wire**.

n/a

#### Connector Orientation



**NOTE:** Refer to WI-PRO-ASY-075  
for dummy seal insertion

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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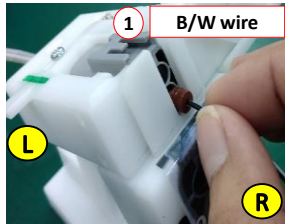

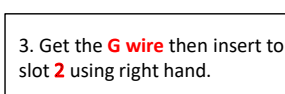
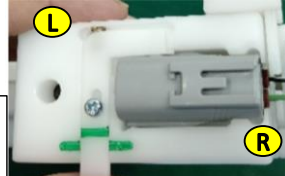

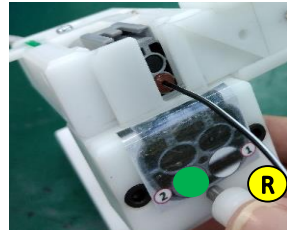



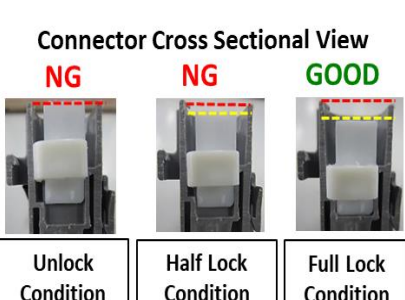
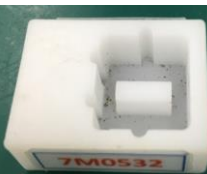
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PARTS:	1. TVSSf 0.3 wires G L=826±3mm; B/W L=826±3mm			JIG	1. Insertion jig w/ switch cover 2. Locking jig								
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS								
3	Wire insertion to connector 6188-0066 (GR)	<div><div><p>1. Get the <b>B/W wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div><div><p>2. After insertion of <b>B/W wire</b>, press the button using right thumb. The slot for <b>G wire</b> will be opened.</p></div><div><p>3. Get the <b>G wire</b> then insert to terminal 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><div><p>WIRE FACING</p></div><div></div></div> <div>n/a</div> <td><div>Note: Please refer to WI-PRO-CNC-017 for Wire and Strip Length tolerance.</div><div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div><div>Note: Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</div><div>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div></td>		<div>Note: Please refer to WI-PRO-CNC-017 for Wire and Strip Length tolerance.</div> <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Note: Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</div> <div>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>									
4	Connector lock	<div><p>1. Put the connector into locking jig using right hand then press <b>2x</b>. Check if properly</p></div> <div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><p>Connector Cross Sectional View</p><table><tr><td>NG</td><td>NG</td><td>GOOD</td></tr><tr><td></td><td></td><td></td></tr><tr><td>Unlock Condition</td><td>Half Lock Condition</td><td>Full Lock Condition</td></tr></table></div> <div>Locking jig</div> <div></div> <td><div>1. No unlock/Half-locked connector 2. No damaged lock</div></td>		NG	NG	GOOD				Unlock Condition	Half Lock Condition	Full Lock Condition	<div>1. No unlock/Half-locked connector 2. No damaged lock</div>
NG	NG	GOOD											
Unlock Condition	Half Lock Condition	Full Lock Condition											

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PARTS:		1. Black Corrugated tube Ø7 L=650±4mm (no slit) 2. Assy parts			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to COT Ø7 L=650±4mm (no slit)	<div><div><p>1. Get the terminal cover jig using right hand and then insert the <b>B/W-G wires</b> using left hand.</p></div><div><p>2. Get the corrugated tube (no slit) <b>Ø7 L=650±4mm (no slit)</b> using right hand and then insert the <b>B/W</b> and <b>G wires</b> using left hand.</p></div><div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div><div><p><b>COT Ø7 L=650±4mm</b></p></div></div>			<div>Terminal cover jig</div> 	1. No wrong use of parts 2. No deformed terminal

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