

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

**January 28, 2022**

Process Name/Title:

Model code/Part number: **780B / 7R0106-7021**

Customer:

**TRMX**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-381A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

1 of 6

**PARTS:**

1. All parts; Connector 6188-0407 (W); TVSSf 0.3 wire B/W-G L=398±2mm; Clip type clamp 82711-60270 (L); Black Corrugated tube Ø5 L=203±3mm (no slit); Black Sunprene tube Ø5 L=125±3mm;

JIG:

1. Insertion jig with Switch cover  
2. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<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 work place 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><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History

Prepared by:

Checked by:

Approved by:

Noted by:

01/28/22	0	Initial Issue	M. Ariola	J. Loterte	C. Villanueva	A. Arañes		
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	November 27, 2020

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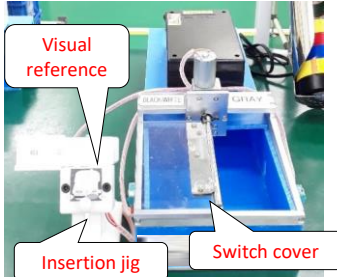
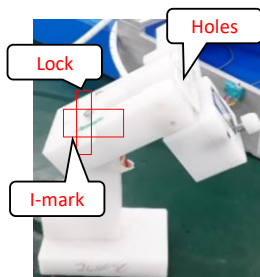



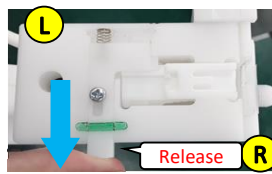


☒ MASSPRO

Revision No.:

0

Page No.:

2 of 6

PARTS:		1. Connector 6188-0407 (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 6188-0407 (W)	<div><div><p>Insertion jig with switch cover</p></div><div><p>Lock</p><p>Holes</p><p>I-mark</p></div><div><p>Connector orientation</p></div></div> <div><div><p><b>L</b></p></div><div><p><b>L</b></p></div><div><p><b>L</b></p></div></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6188-0407 (W) 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></div>	n/a	<div><p>Connector Orientation Illustration</p><div><p>I-mark is align</p></div><div><p>I-mark is not align</p></div></div> <p>1. Use the provided jig per model 2. No wrong orientation of connector</p>

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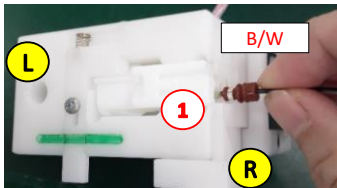
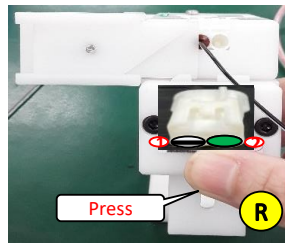
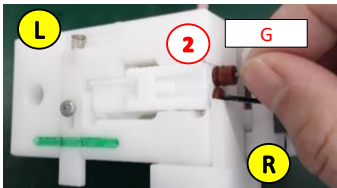
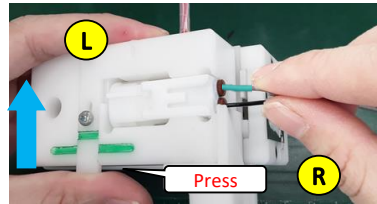
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Revision No.:

0

Page No.:

3 of 6

PARTS:		1. TVSSf 0.3 wire B/W L=398±2mm 2. TVSSf 0.3 wire G L=398±2mm	JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Wire Insertion to connector 6188-0407 (W)	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the <b>Black/White wire</b> and insert to terminal slot ① using right hand.</p></div> <div><p>2. Press the button using right hand. Slot for <b>Green wire</b> will be open.</p></div> <div><p>3. Get the <b>Green wire</b> then insert to terminal slot ② using right hand.</p></div> <div><p>4. After insertion, push the lock button using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>	n/a	<p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></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>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p> <p><i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p>

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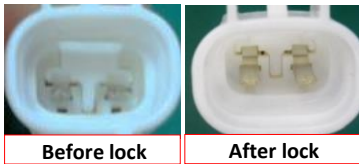
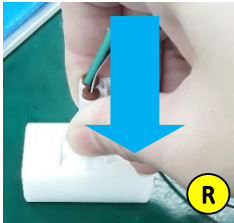
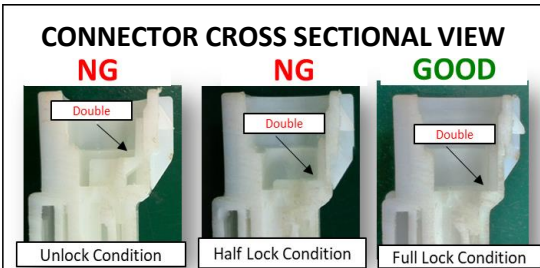

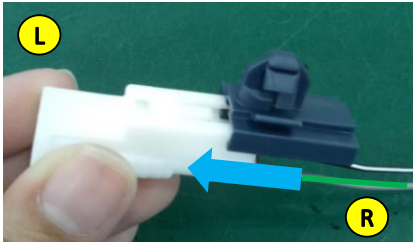


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Revision No.:

0

Page No.:

4 of 6

PARTS:		1. Assy parts 2. Clip type clamp 82711-60270 (L)			JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P1 Connector lock	 <p>Before lock After lock</p>  <p><b>CONNECTOR CROSS SECTIONAL VIEW</b></p>  <p>Unlock Condition Half Lock Condition Full Lock Condition</p> <p>Put the connector into locking jig using right hand then press <b>2x</b>. Check the connector if properly lock.</p>			<p><b>Locking jig</b></p> 	<p><b>NOTE:</b> MANUAL LOCKING MAY CAUSED DAMAGED LOCK</p> <p>1. Use the provided locking per model 2. No unlock/half-locked connector</p>
5	Clamp attachment (Clip type Clamp)	   <p>Hold the connector using left hand, get the clip type clamp <b>82711-60270 (L)</b> then insert the clamp using right hand. <i>Note: Sound will be heard if properly inserted.</i></p>			N/A	<p>1. No damaged clamp 2. No wrong use of clamp</p>

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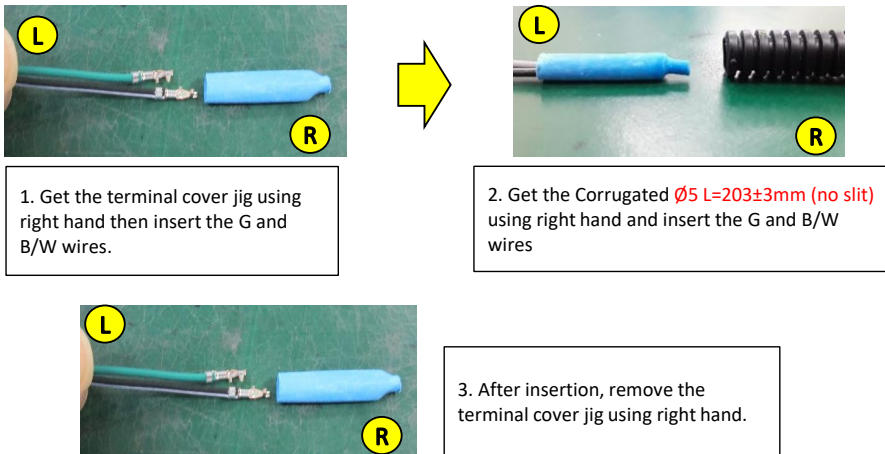


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Revision No.:

0

Page No.:

5 of 6

PARTS:		1. Black Corrugated tube Ø5 L=203±3mm (no slit) 2. Black Sunprene tube Ø5 L=125±3mm			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
6	P1	Wire insertion to Corrugated tube Ø5 L=203±3mm (no slit)	 <div>1. Get the terminal cover jig using right hand then insert the G and B/W wires.</div> <div>2. Get the Corrugated Ø5 L=203±3mm (no slit) using right hand and insert the G and B/W wires</div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>	Terminal Cover jig 		1. No wrong use of parts 2. No deformed terminal
7		Wire insertion to Sunprene tube Ø5 L=125±3mm	 <div>1. Get the Black Sunprene tube Ø5 L=125±3mm using right hand and insert the G and B/W wires</div>	n/a		1. No wrong use of parts 2. No deformed terminal

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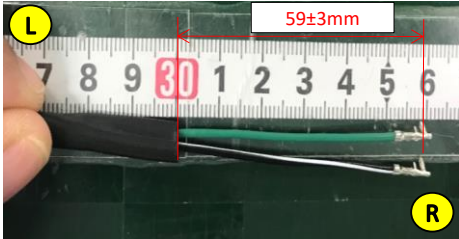
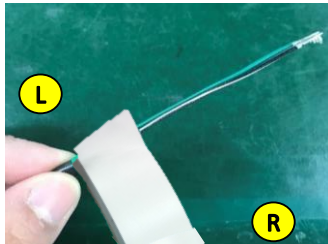
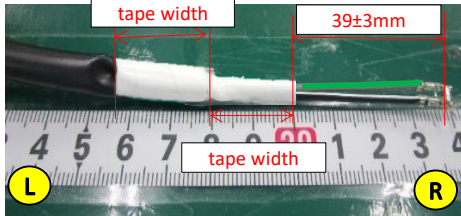

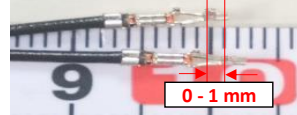
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Revision No.:

0

Page No.:

6 of 6

PARTS:		JIG			N/A	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
8	P1 Taping Sunprene to wire near terminal	<div><p>1. Hold the Sunprene tube using left hand. Measure from end of Sunprene up to the terminal pointed tip <b>59±3mm</b>.</p></div> <div><p>2. Hold the Sunprene tube using left hand. Get <b>White tape</b> using right hand and start taping using both hands. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p></div> <div><p>3. After taping, check the measurement, wire alignment and taping condition.</p></div>			<p>Measuring tape</p> 	<p><i>Note:</i> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p> <ul 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 use of tape</li><li>5. No wrong dimension</li><li>6. No missig tape</li></ul> <div><p>Wire alignment tolerance</p></div>

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