

**WORK INSTRUCTION**Process Name/Title: **OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

March 10, 2023Model Code/Part Number: **587B / 7M0532-7021**Customer: **TRJ**

Validity Date:

n/aPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-413

Revision No.:

1

Page No.:

1 of 5**PARTS:** 1. Connector 6188-0066 (GR); TVSSf 0.3 B/W-G wires L=638±3mm; Black corrugated tube (no slit) Ø7 L=462±4mm

JIG:

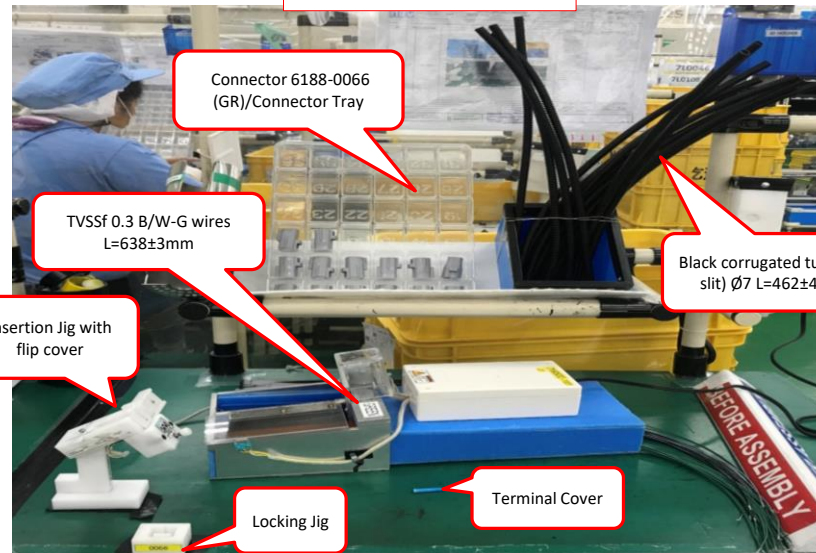
1. Insertion jig with switch cover

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

1

n/a

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.

Important reminders/Note/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	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
03/10/23	1	Improve Quality pointers: Reminders and Notes on page no. 1,3 and 4; Inclusion of Quality Checkpoints	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
02/22/22	0	Initial Issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				

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PARTS:

1. Connector 6188-0066 (GR)

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

n/a

Connector setting to
insertion jig
6188-0066 (GR)

INSERTION JIG WITH SWITCH COVER

LOCK

CONNECTOR ORIENTATION

INSERTION JIG ORIENTATION

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.
Note: Follow the connector orientation.

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

Guide

n/a

Connector Orientation Illustration

I-mark is align

1 hole is open

GOOD

I-mark is not align

1 hole is open

NG

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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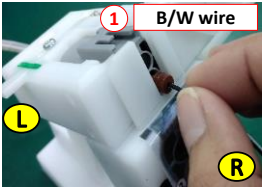

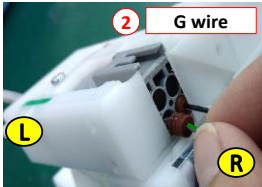
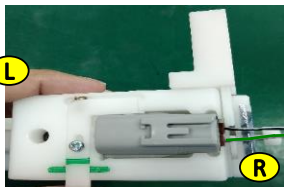
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PARTS:	1. TVSSf 0.3 B/W-G wires L=638±3mm			JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
3	n/a Wire insertion to connector 6188-0066 (GR)	<div data-bbox="913 475 1153 555"><p>WIRE FACING</p></div> <div data-bbox="636 587 896 774"><p>1. Get the B/W wire then insert to terminal slot 1 using right hand.</p></div> <div data-bbox="1167 587 1426 774"><p>2. After insertion of B/W wire, press the button using right thumb. The slot for G wire will be opened.</p></div> <div data-bbox="622 917 882 1104"><p>3. Get the G wire then insert to terminal slot 2 using right hand.</p></div> <div data-bbox="1120 917 1402 1104"><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 data-bbox="1778 454 2119 582"><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 data-bbox="1778 646 2119 877"><p>Important reminders/Note/s</p><p>1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p></div> <div data-bbox="1778 901 2119 1045"><p>Document reference/s:</p><p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p></div>

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PARTS:

1. TVSSf 0.3 B/W-G wires L=638±3mm
2. Assy parts
3. Black corrugated tube (no slit) Ø7 L=462±4mm

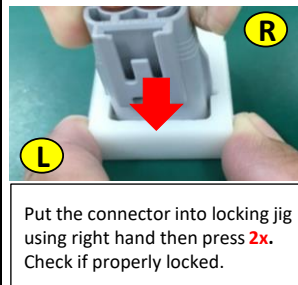
JIG

1. Locking jig

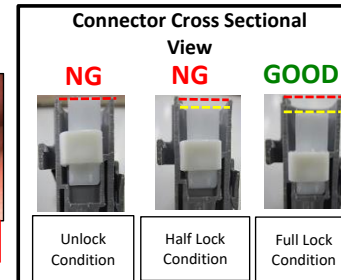
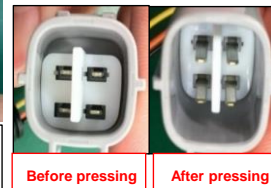
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****1****QUALITY POINTERS**

3

Connector Lock



Put the connector into locking jig using right hand then press **2x**. Check if properly locked.

**LOCKING JIG**

1. Use the provided jig per model
2. No unlock/half-locked connector

Important reminders/Notes/:

1. Manual locking may cause damaged connector lock.

4

n/a

Wire insertion to
Black corrugated tube (no
slit)
Ø7 L=462±4mm



1. Get the terminal cover jig using right hand and then insert the **B/W-G wires** using left hand.



2. Get the corrugated tube (no slit) Ø7 L=462±4mm using right hand and then insert the **B/W-G wires** using left hand.



3. After insertion, remove the terminal cover jig using right hand.

**TERMINAL COVER JIG**

1. No wrong use of parts
2. No deformed terminal

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PARTS:

n/a

JIG

n/a



QUALITY CHECKPOINTS

OFFLINE INSERTION

7M0532-7021

1



GOOD



GOOD



NO GOOD



NO GOOD

2



5

4

3



GOOD



NO GOOD

1

No **Unlock** connector

3

No **Terminal Backing Out**

2

No **Wrong** insert

4

No **Deformed** terminal

5

Check **the Alignment**

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