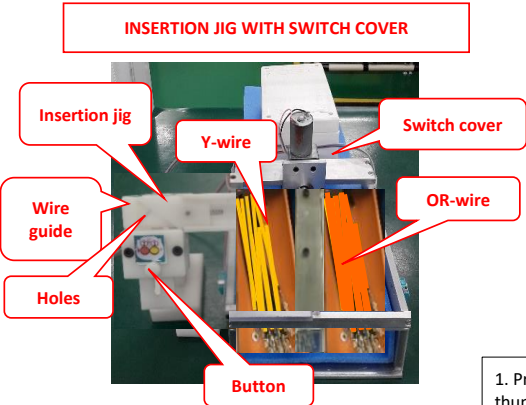
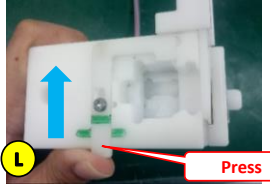
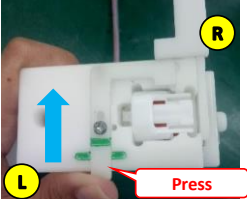
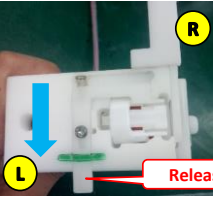
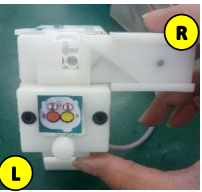






WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	May 18, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-193A		
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Process Name/Title:	TAPING ASSEMBLY PROCESS		
Product Name/Code:	011B / 7M0365-7020A	Customer:	TRJ
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Connector 6189-0451 (W) 2. AVSSf 0.3 wires Y, L=387±2mm 3. AVSSf 0.3 wires OR, L=387±2mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 Connector setting to insertion jig 6189-0451 (W)	<div><div>INSERTION JIG WITH SWITCH COVER</div><div>CONNECTOR ORIENTATION</div><div>1. Press the lock of insertion jig using left thumb.</div><div><div>Press</div><div><div>Release</div><div><div>Push</div><div>2. Insert the connector 6189-0451 (W) into jig using right hand and release the lock.</div><div>3. Push the wire guide upward, slot for Y wire will be opened.</div></div></div></div></div>		<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>Connector Orientation Illustration</div> <div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div><div><div>I-mark is NOT align</div><div>1 hole is open</div><div>NG</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></div>

Revision History				Prepared by		Reviewed by	Approved by	Noted by
05/18/21	4	Removal of validity date. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes		
11/11/20	3	Transfer process owner from Production (WI-PRO-ASY-019A) to Engineering (WI-ENG-PDE-193A). Apply some improvements/update pictures.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes		
07/10/17	0	Previously established as Production work instruction (WI-PRO-ASY-019). Initial issue	J. Montañez L. Brogas	O. Merin	T. Sugiyama	n/a		
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	July 10, 2017

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Effectivity Date:

May 18, 2021

Process Name/Title:

Validity Date:

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Product Name/Code: 011B / 7M0365-7020A

Customer: TRJ

Document No.:

WI-ENG-PDE-193A

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH


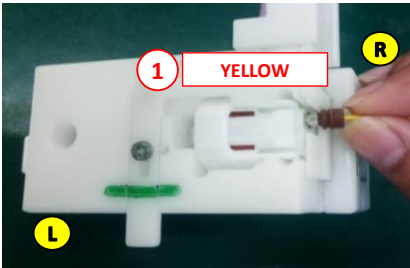
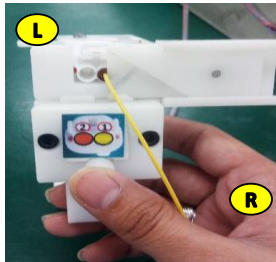
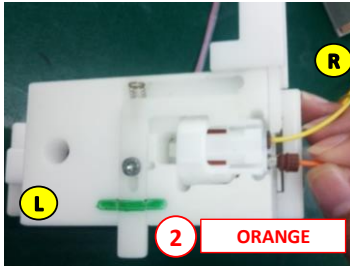
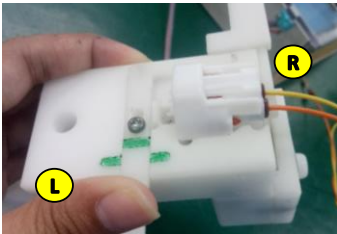
☒ MASSPRO

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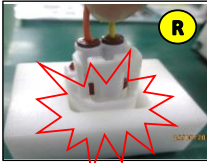








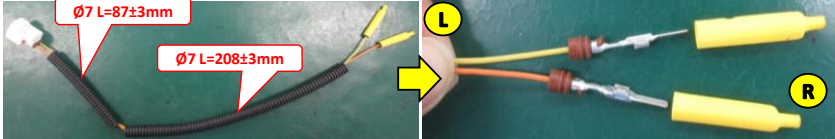

PARTS:		n/a	JIG	1. Insertion jig w/switch cover
NO.	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div>4</div> <div>Wire insertion to Connector 6189-0451 (W)</div> <div><p>WIRE FACING</p><p>1. Get the Y wire using right hand then insert to slot 1 of connector.</p><p>2. Press the button using right thumb after insertion. The slot for OR wire will be opened.</p><p>3. Get the OR wire using right hand then insert to slot 2 of connector.</p><p>4. Press the insertion jig lock using left hand and slowly remove the harness from jig using right hand.</p></div>	n/a	<div>Note: Please hold the wire near terminal during insertion.</div> <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing.</div> <div>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div>

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	Process Name/Title: TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Product Name/Code: 011B / 7M0365-7020A	Customer: TRJ	Document No.:	WI-ENG-PDE-193A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	4	Page No.:

PARTS:	1. Assy parts 2. Black corrugated tube (no slit) Ø7 L=87±3mm 3. Black corrugated tube (no slit) Ø7 L=208±3mm			JIG	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	Connector Lock	 <p>1. Put the connector into locking jig using right hand then push 2x. Check the connector if properly locked.</p> <div>  BEFORE PRESSING  AFTER PRESSING </div> <div>  GOOD  NG </div> <p>Check the double lock deformation</p>	 <p>LOCKING JIG</p>	2. Use the provided locking jig per model 2. No unlock/half-locked connector	
4	P1 Wire insertion to Black corrugated tube (no slit) Ø7 L=87±3mm Ø7 L=208±3mm	<div>  <p>1. Get the terminal cover jig using right hand then insert to both terminals (Y-OR wires) using right hand.</p> </div> <div>  <p>2. Hold the COT φ7 L=87±3mm using right hand then insert the Y-OR wires using left hand.</p> </div> <div>  <p>3. Hold the COT φ7 L=208±3mm using right hand then insert the Y-OR wires using left hand.</p> </div> <div>  <p>4. After insertion, remove the cover jig using right hand.</p> </div>	 <p>TERMINAL COVER JIG</p>	1. No wrong usage of parts 2. No damaged rubber seal	

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TAPING ASSEMBLY PROCESS

Validity Date:

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Product Name/Code:

011B / 7M0365-7020A

Customer:

TRJ

Document No.:

WI-ENG-PDE-193A

Purpose:

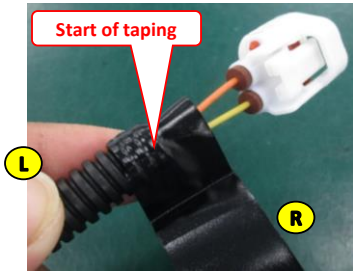
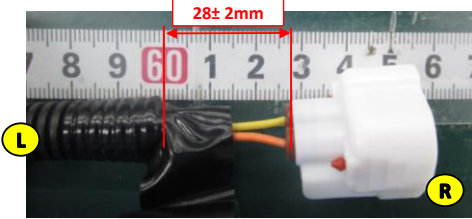
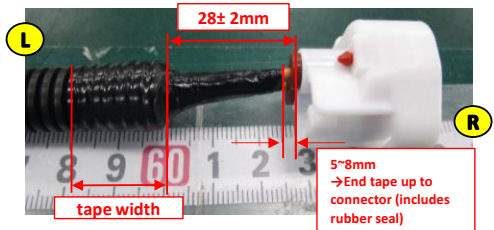

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 Taping 1 Black corrugated tube to wire near connector	<div><p>1. Hold the corrugated tube using left hand and start taping using right hand.</p></div> <div><p>2. Measure the end of the corrugated tube up to the edge of connector 28±2mm and then continue the taping process. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<div>MEASURING TAPE</div> 	<div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div> <div>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</div>

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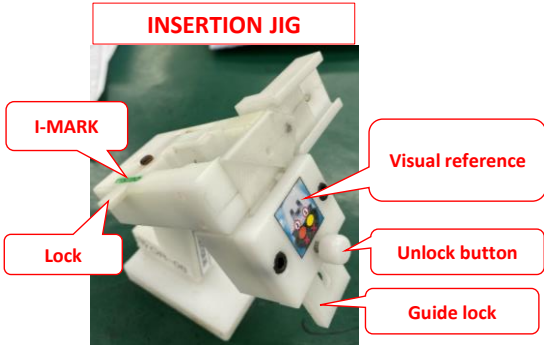
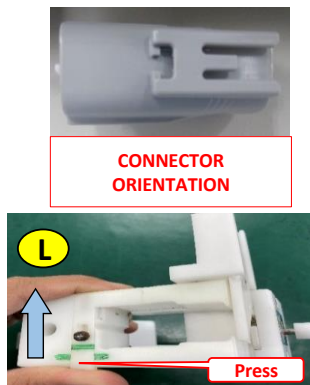
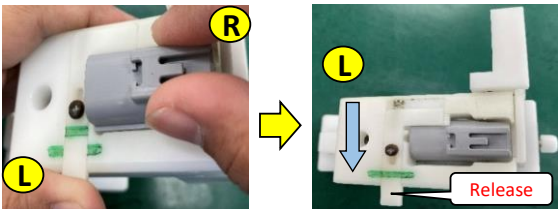
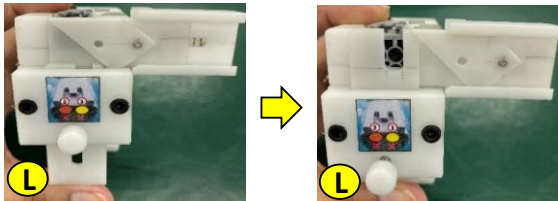
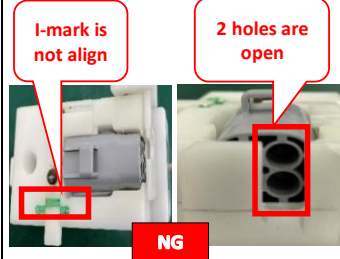
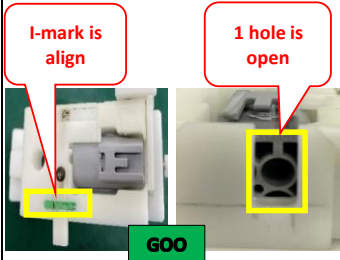
WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	May 18, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-193A		
Revision No.:	4	Page No.:	5 of 9

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

Product Name/Code: **011B / 7M0365-7020A** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Connector 6188-0066 (GR)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Connector setting to insertion jig 6188-0066 (GR)	<div><p>INSERTION JIG</p><p>CONNECTOR ORIENTATION</p><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6188-0066 (GR) into jig using right hand and release the lock.</p><p>3. Push the guide using left hand. The slot for Y wire will be opened.</p></div>		n/a	<div><p>Connector Orientation Illustration</p><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></div>

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TAPING ASSEMBLY PROCESS

Validity Date:

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Product Name/Code:

011B / 7M0365-7020A

Customer:

TRJ

Document No.:

WI-ENG-PDE-193A

Purpose:


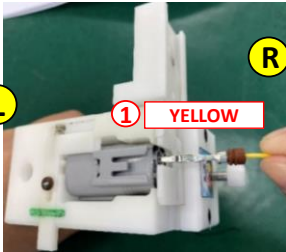
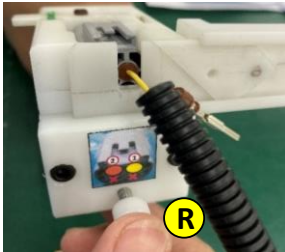
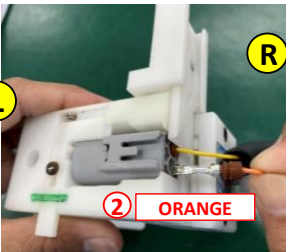
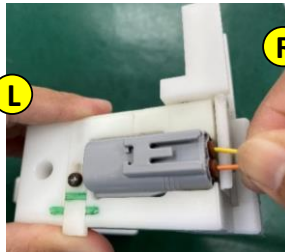
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:	1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1	Wire insertion to connector 6188-0066 (GR) (Assy parts)	<div><div>WIRE FACING</div></div> <div><div><div>① YELLOW</div></div><div><div>②</div></div></div> <div><div><div>③ ORANGE</div></div><div><div>④</div></div></div> <div><div>1. Get the Y wire then insert to terminal slot 1 using right hand.</div><div>2. After insertion of Y wire press the button using right thumb. The slot for OR wire will be opened.</div><div>3. Get the OR wire then insert to terminal slot 2 using right hand.</div><div>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.</div></div> <td>n/a</td> <td><div>1. No loose insertion</div><div>2. No wrong insertion</div><div>3. One by one insertion</div><div>4. No deformed terminal</div><div>5. No wrong wire facing</div><div>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div></td>	n/a	<div>1. No loose insertion</div> <div>2. No wrong insertion</div> <div>3. One by one insertion</div> <div>4. No deformed terminal</div> <div>5. No wrong wire facing</div> <div>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div>

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WORK INSTRUCTION

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Product Name/Code: 011B / 7M0365-7020A

Customer:

TRJ

Document No.:

WI-ENG-PDE-193A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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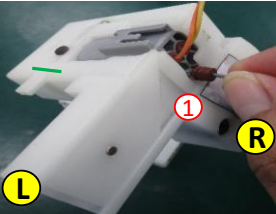
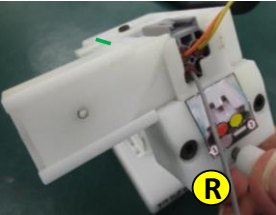
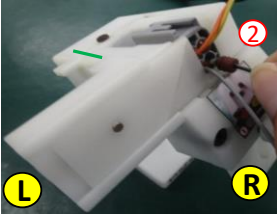

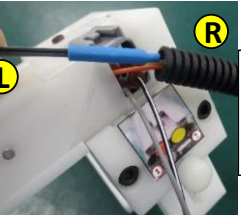

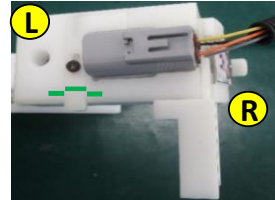
PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	<p>Connector setting to insertion jig 6188-0066 (GR) (Assy parts)</p> <p>INSERTION JIG</p> <p>I-MARK</p> <p>Lock</p> <p>Visual reference</p> <p>Unlock button</p> <p>Guide lock</p> <p>CONNECTOR ORIENTATION</p> <p>1. Push the guide lock using left thumb. The hole for GR wire will be opened.</p> <p>2. Press the lock of insertion jig using left thumb.</p> <p>3. Insert the connector 6188-0066 (GR) into jig using right hand and release the lock.</p>		n/a	<p>Connector Orientation Illustration</p> <p>I-mark is align</p> <p>1 hole is open</p> <p>GOOD</p> <p>I-mark is not align</p> <p>2 holes are open</p> <p>NG</p> <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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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Product Name/Code: 011B / 7M0365-7020A		Customer: TRJ	Document No.:	WI-ENG-PDE-193A		
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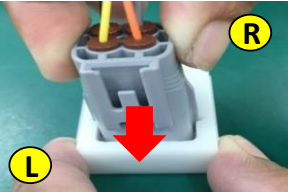






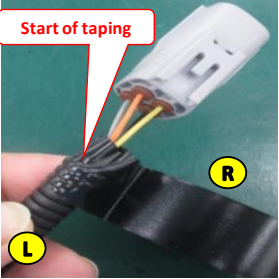
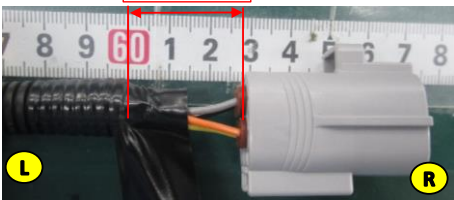
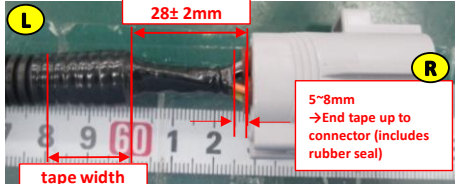

PARTS:		1. Assy parts 2. TVSSf 0.3 GR-B/W wires L=826±3mm			JIG	1. Insertion jig 2. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
9	P1 Wire insertion to connector 6188-0066 (GR)	   <p>WIRE FACING</p> <p>1. Hold the GR wire then insert to terminal slot ① using right hand.</p> <p>2. After insertion of GR wire press the button using right thumb. The slot for B/W wire will be opened.</p> <p>3. Hold the B/W wire then insert to terminal slot ② using right hand.</p>			n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.	
10	P1 Wire insertion to Black corrugated tube (no slit) Ø7 L=208±3mm (Assy parts)	    <p>1. Get the terminal cover jig using right hand then insert to both terminals (GR-B/W wires) using right hand.</p> <p>2. Hold the COT φ7 L=208±3mm using right hand then insert the GR-B/W wires using left hand.</p> <p>3. After insertion, remove the cover jig using right hand.</p> <p>4. Press the insertion jig lock using left hand and slowly remove the harness from jig using right hand.</p> <p>TERMINAL COVER JIG</p>				1. No wrong insertion 2. No deformed terminal	

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	Product Name/Code: 011B / 7M0365-7020A		Customer: TRJ	Document No.:	WI-ENG-PDE-193A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	9 of 9

PARTS:		1. Assy parts 2. Black tape			JIG	1. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
11	Connector Lock	 <p>1. Put the connector into locking jig using right hand then push 2x. Check the connector if properly locked.</p>   <div> <p>Connector Cross Sectional View</p> <p>NG NG GOOD</p>    <p>Unlock Condition Half Lock Condition Full Lock Condition</p> </div>			<p>LOCKING JIG</p> 	<p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p> <p>1. Use the provided jig per model 2. No unlock/half-locked connector</p>	
12	P1 Taping 2 Black corrugated tube to wire near connector	<p>Start of taping</p>  <p>1. Hold the corrugated tube using left hand and start taping using right hand.</p>  <p>2. Measure the end of the corrugated tube up to the edge of connector 28± 2mm and then continue the taping process. Note: Refer to WI-PRO-ASY-001 for taping procedure.</p>  <p>3. After taping, check the measurement and taping condition.</p>			<p>MEASURING TAPE</p> 	<p>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</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>	

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