



## WORK INSTRUCTION

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

Product Name/Code: **370B / 7L0044-7022A**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

August 5, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-292A

Revision No.:

2

Page No.:

1 of 4

PARTS:

1. Connector 6098-5677 (W)

JIG:

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Connector Setting to Insertion jig 6098-5677 (W)	<p><b>INSERTION JIG</b></p> <p>Holes</p> <p>Lock</p> <p>I-mark</p> <p>Connector lock</p> <p>I-mark</p> <p>Lock</p> <p>Holes</p> <p><b>INSERTION JIG ORIENTATION</b></p> <p><b>CONNECTOR ORIENTATION</b></p> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the Connector 6098-5677 (W) into jig using right hand and release the lock.</p> <p>3. Check the holes/terminal slot for 2 Black wires.</p>	<p><b>Safety Instruction</b></p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b></p> <p>1. Maintain and always practice 5's.</p> <p>2. Personal things on the work place is prohibited. Keep it in your locker.</p> <p><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>Connector Orientation Illustration</b></p> <p>I-mark is align</p> <p>2 Holes are widely open</p> <p>GOOD</p> <p>I-mark is not align</p> <p>No holes are open</p> <p>NG</p> <p>1. Use the provided jig per model</p> <p>2. No wrong orientation of connector</p>

### Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by	Reviewed by	Approved by	Noted by
08/05/21	2	Transfer process owner from Production WI (WI-PRO-ASY-071A) to Engineering WI (WI-ENG-PDE-292A). Improve all process illustration and quality pointers.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
05/25/19	1	Include distribution of process/Include hang of tape	J. Silang	A. Morcozo/W. Carbillon	O. Merin	n/a				
12/01/17	n/a	Previously established Engineering Instruction (EI-ENG-PDE-005). Initial issue.	J. Loterte	R. Alcantara	A. Arañes	T. Sugiyama	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
							Est. Date:	September 24, 2018		

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp



## WORK INSTRUCTION

### TAPING ASSEMBLY PROCESS

Effectivity Date:

August 5, 2021

Process Name/Title:

Product Name/Code: **370B / 7L0044-7022A**Customer: **TRQSS**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-292A

Purpose:


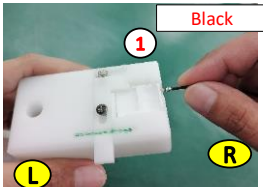
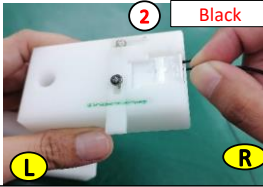

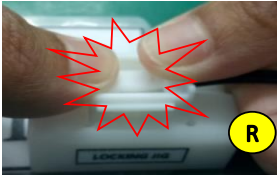
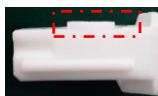




☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

2 of 4

PARTS:		1. Wires AVSSf 0.3 Black L=378mm (2pcs)		JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the black wire and insert to terminal slot ① using right hand. Conduct one by one insertion from left to right.</p></div> <div><p>2. Get the 2nd black wire then insert to terminal slot ② using right hand.</p></div> <div><p>3. 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> <p>Wire insertion to connector 6098-5677 (W)</p>		n/a	<ul style="list-style-type: none"><li>1. No loose insertion</li><li>2. No wrong insertion</li><li>3. One by one insertion</li><li>4. No deform terminal</li><li>5. No wrong wire facing</li></ul> <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>
3	Connector lock	<div><p>1. Put the connector into locking jig using both hand then press to lock 2x. Touch the connector if it is properly locked.</p><p><i>Refer to GL-PRO-ASY-017 for verification of connector lock.</i></p></div> <div><p>Before Pressing</p></div> <div><p>After Pressing</p></div> <div><p>GOOD Fully Locked</p></div> <div><p>NG Unlocked</p></div>		<b>LOCKING JIG</b> 	<p><i>Note: Use provided jig tool per model to avoid damaged lock.</i></p> <ul style="list-style-type: none"><li>1. Use the provided jig per connector</li><li>2. No unlock/half-locked connector</li></ul> <p><b>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</b></p>

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp



## WORK INSTRUCTION

Effectivity Date:

August 5, 2021

Process Name/Title:

### TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Product Name/Code:

**370B / 7L0044-7022A**

Customer:

**TRQSS**

Document No.:

WI-ENG-PDE-292A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH






☒ MASSPRO

Revision No.:

2

Page No.:

3 of 4

PARTS:		1. Black corrugated tube $\phi 5$ , L=287 $\pm$ 3 (no slit) 2. Black vinyl tube $\phi 4$ , L=35 $\pm$ 3mm			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P1	<div>    </div> <div> <p>1. Get the terminal cover jig using right hand then insert to wires.</p> <p>2. Get the Corrugated tube <math>\phi 5</math>, L=287<math>\pm</math>3mm using right hand and insert to wires.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p> </div>			<b>TERMINAL COVER JIG</b> 	1. No deformed terminal 2. No wrong usage of parts
5		<div>  </div> <div> <p>1. Get the Black Vinyl tube <math>\phi 4</math>, L=35<math>\pm</math>3mm using right hand then insert the black wires.</p> </div>			n/a	

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp



## WORK INSTRUCTION

### TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **370B / 7L0044-7022A**

Customer:

**TRQSS**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

August 5, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-292A

Revision No.:

2

Page No.:

4 of 4

**PARTS:**

1. Black tape

**JIG**

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 Vinyl tube to wire near terminal	<p><b>NOTE:</b> USED YELLOW TAPE FOR EASY VISUALIZATION OF TAPE SHIFTING BUT ACTUAL SHOULD BE BLACK.</p> <p>1. Measure the end of the vinyl tube up to the end of the terminal pointed tip <b>55mm</b>.</p> <p>2. Get the black tape, conduct pre-taping between vinyl tube and wires. Make 1/3 shifting going to Vinyl tube then make 2 winds (must be tape width).</p> <p>3. Make 1/3 shifting to wire. <b>Note: No folding required for Vinyl tube with ø4.</b> Make 3 winds on wire before cutting the tape.</p> <p>4. After taping, check the measurement, wire alignment and taping condition.</p>	<p><b>MEASURING TAPE</b></p>	<p>Wire alignment tolerance <b>0 - 1 mm</b></p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape</p> <p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p>

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp