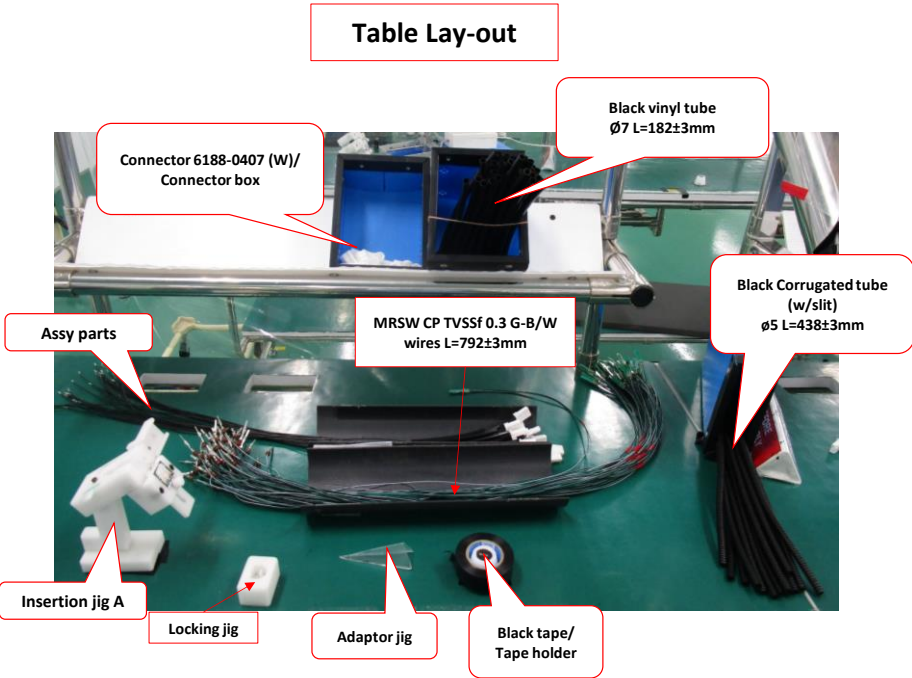
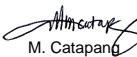



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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 1		Page No.: 1 of 6	

PARTS: 1. Assy parts: Connector 6188-0407 (W); MRSW CP TVSSf 0.3 G-B/W wires L=792±3mm; Black vinyl tube Ø7 L=182±3mm; Black Corrugated tube (w/slit) Ø5 L=438±3mm; Black tape [1pc.]		JIG: 1. Insertion jig 2. Adaptor jig 3. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P1 Table Lay-out		<div> Safety Instruction Be sure to wear required 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>
		QUALITY POINTERS <i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i> 1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by	Reviewed by	Approved by	Noted by
04/21/22	1	Change document purpose from pre-launch to masspro. Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
04/08/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	April 08, 2022			


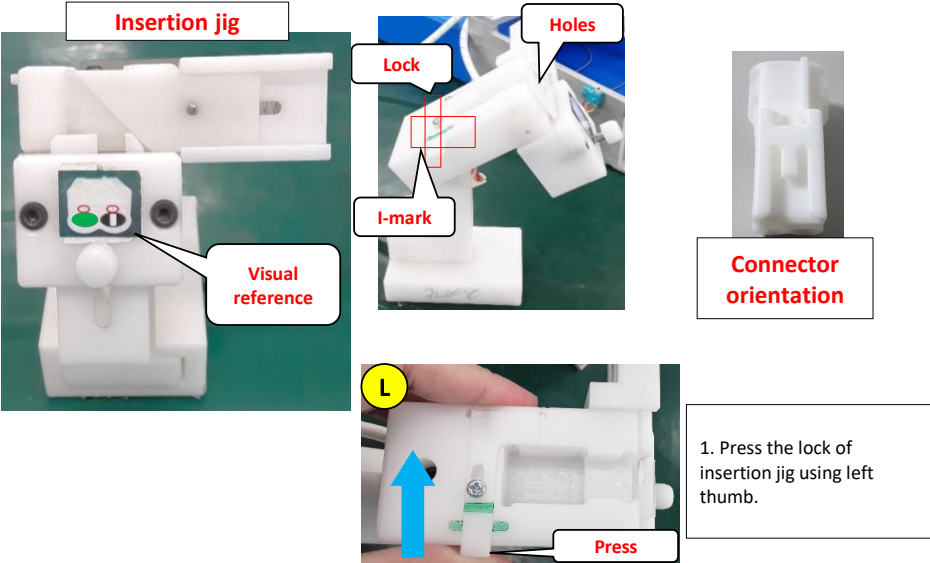
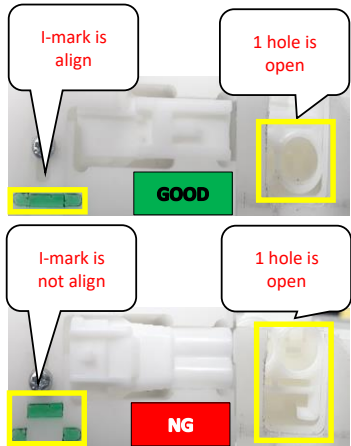
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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

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Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. MRSW CP TVSSf 0.3 G-B/W wires L=792±3mm 2. Black vinyl tube Ø7 L=182±3mm 3. Connector 6188-0407 (W)			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2		<div>Wire insertion to Black Vinyl tube Ø7 L=182±3mm</div> <div></div>			n/a	1. No wrong use of parts 2. No deformed terminal
3	P1	<div>Connector setting to Insertion jig 6188-0407 (W)</div> <div></div>			n/a	<div>Connector Orientation Illustration</div> <div></div>

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WORK INSTRUCTION TAPING ASSEMBLY PROCESS

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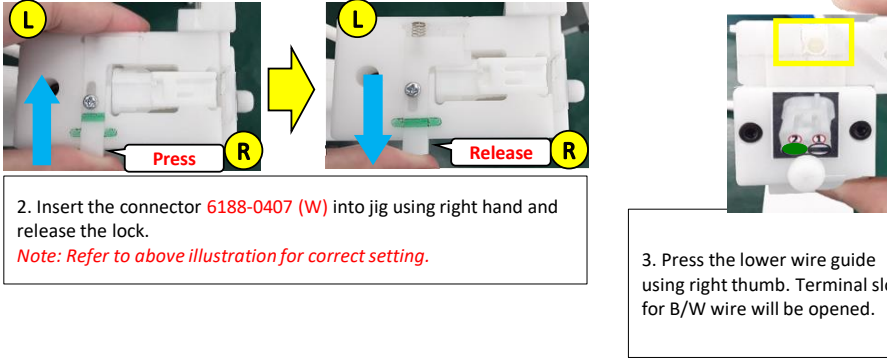
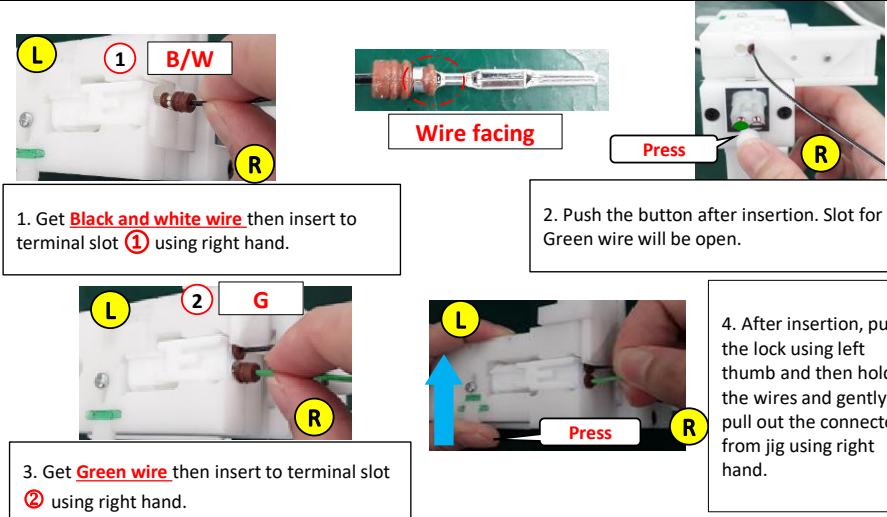
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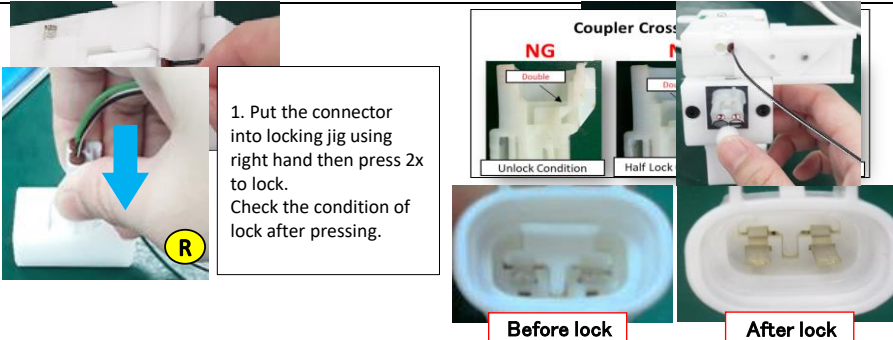

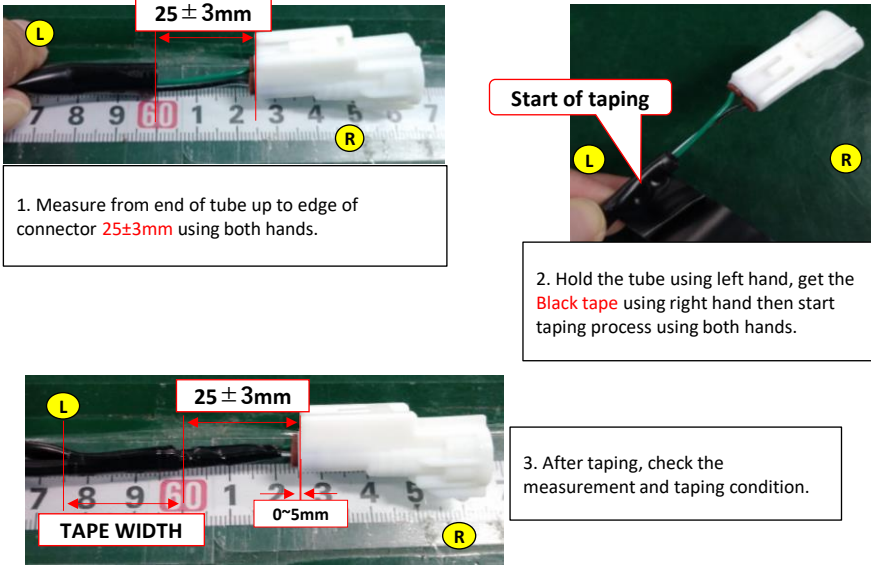

PARTS:		1. Assy parts	JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Connector setting to Insertion jig 6188-0407 (W) (Continuation)	 <p>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></p> <p>3. Press the lower wire guide using right thumb. Terminal slot for B/W wire will be opened.</p>	n/a	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector
4	P1 Wire Insertion to connector 6188-0407 (W)	 <p>1. Get Black and white wire then insert to terminal slot 1 using right hand.</p> <p>2. Push the button after insertion. Slot for Green wire will be open.</p> <p>3. Get Green wire then insert to terminal slot 2 using right hand.</p> <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>	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 Pull-Push-Pull-Push 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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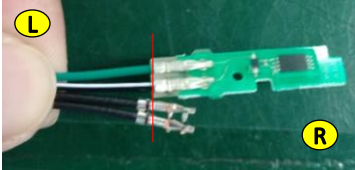
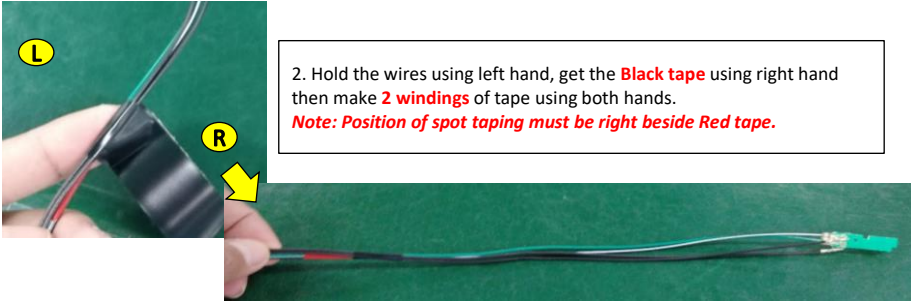
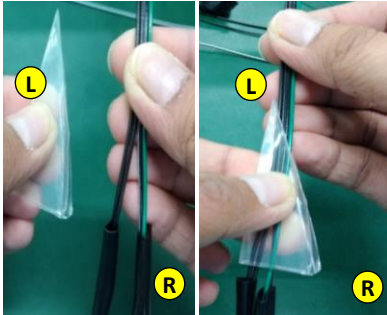
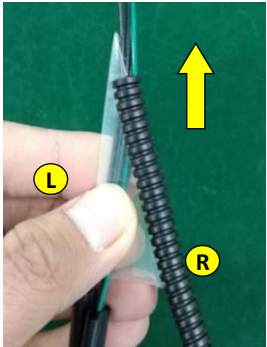

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PARTS:		1. Assy parts 2. Black tape			JIG	1. Locking
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	Connector lock	 <p>1. Put the connector into locking jig using right hand then press 2x to lock. Check the condition of lock after pressing.</p> <p>Before lock After lock</p>			 <p>LOCKING JIG</p>	<p>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK</p> <p>1. Use the provided locking per model 2. No unlock/half-locked connector</p>
6	P1 Taping 1 Vinyl tube to wire near Connector	 <p>1. Measure from end of tube up to edge of connector 25±3mm using both hands.</p> <p>Start of taping</p> <p>2. Hold the tube using left hand, get the Black tape using right hand then start taping process using both hands.</p> <p>3. After taping, check the measurement and taping condition.</p> <p>TAPE WIDTH 0~5mm</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: <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p>

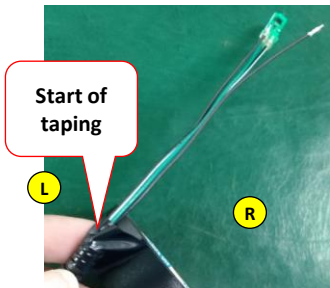
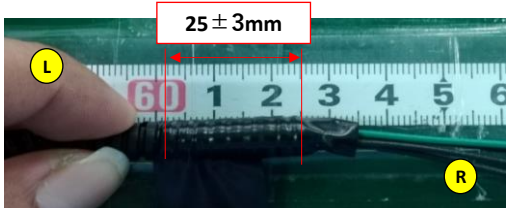
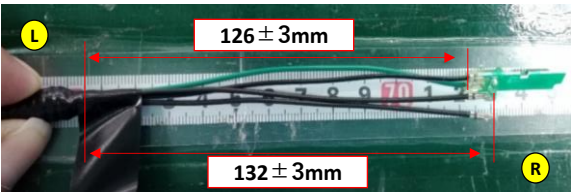
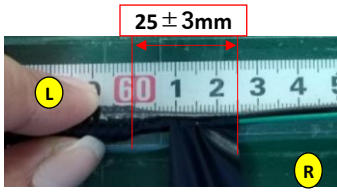
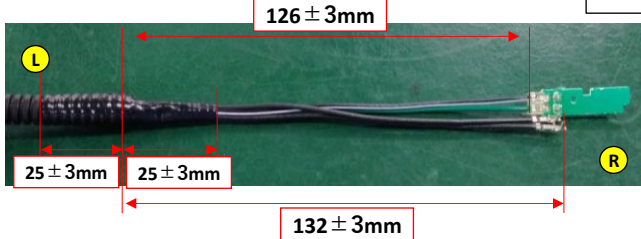

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PARTS: 1. Assy parts 2. Black tape				JIG 1. Adaptor jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 Taping 2 Spot taping	 <p>1. Fix the hotmelted wire and terminal pointed tip using both hands.</p>  <p>2. Hold the wires using left hand, get the Black tape using right hand then make 2 windings of tape using both hands. <i>Note: Position of spot taping must be right beside Red tape.</i></p>	LOCKING JIG	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 <i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i>
8	Wire insertion to Black Corrugated tube (w/slit) ø5 L=438±3mm	 <p>1. Hold the COT adaptor using left hand. Combined the 2 assy parts and put inside the COT adaptor using right hand</p>  <p>2. Hold the COT adaptor with wires using left hand, get the Black Corrugated tube (w/slit) ø5 L=438±3mm using right hand and insert to COT adaptor. Pull the adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted.</p>	COT Adaptor 	1. No wrong use of parts 2. No wires left in between the COT with slit

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PARTS: 1. Assy parts 2. Black tape				JIG n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1 Taping 3 Black Corrugated tube (w/slit) to wire near PCB and terminal tip	<div>  <p>Start of taping</p> <p>1. Hold the corrugated tube using left hand then start taping using right hand.</p> </div> <div>  <p>25 ± 3mm</p> <p>2. Confirm measurement of 25±3mm from end of tape up to COT then continue the taping process using both hands.</p> </div> <div>  <p>126 ± 3mm</p> <p>132 ± 3mm</p> <p>3. Measure from end of COT up to terminal pointed tip L=132±3mm; and COT to PCB L=126±3mm then continue the taping process using both hands.</p> </div> <div>  <p>25 ± 3mm</p> <p>4. Confirm measurement of 25±3mm from COT up to end of tape then continue the taping process using both hands.</p> </div> <div>  <p>126 ± 3mm</p> <p>25 ± 3mm</p> <p>25 ± 3mm</p> <p>132 ± 3mm</p> <p>5. After taping, check the measurement, terminal and PCB appearance and taping condition.</p> </div>	 <p>MEASURING TAPE</p>	<ol style="list-style-type: none"> No flip-out tape No peel-off tape No loose tape No missing tape No wrong dimension No wrong use of tape <p><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p>

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