

	WORK INSTRUCTION						Effectivity Date:		February 03, 2023	
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:				Model Code/Part Number: 922B / 7L0123-7022		Customer: TRQSS		Document No.: WI-ENG-PDE-429B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		1	Page No.: 1 of 9

PARTS:	1. All parts: Connector 6098-3810 (W); B-B wires L=709±3mm; Black vinyl tube Ø7 L=95±3mm; Black tape [1pc.]; Red tape [1pc.]					JIG:	1. Insertion jig 2. Locking jig 3. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS	
1	P2	<div style="text-align: center;"> <p>TABLE LAY-OUT</p> </div>				<div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> <p>Housekeeping</p> <ol style="list-style-type: none"> Maintain and always practice 5's. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<ol style="list-style-type: none"> No missing parts/tools No excess parts/tools No wrong position of parts/tools 	

Revision History								Prepared by	Reviewed by	Reviewed by	Noted by
02/03/23	1	Inclusion of quality checkpoints. Improvements on quality pointers	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
02/19/22	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	Checked	Checked	Approved	Est. Date:	Feb 19, 2022			

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PARTS:

1. Connector 6098-3810 (W)

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P2

Connector setting to
Insertion jig
6098-3810 (W)

INSERTION JIG

Holes

Lock

INSERTION JIG ORIENTATION

I-MARK

CONNECTOR ORIENTATION

L

R

Press

Press

Release

1. Press the lock of insertion jig using left thumb.

2. Insert the connector **6098-3810 (W)** into jig using right hand and release the lock.
Note: Follow the connector orientation.

3. Check the holes/terminal slot for **B-B wires**.

n/a

Connector Orientation Illustration



CONNECTOR ILLUSTRATION



1. Use provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

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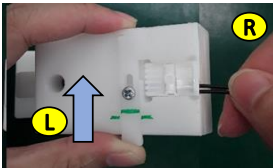

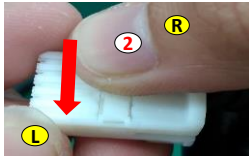
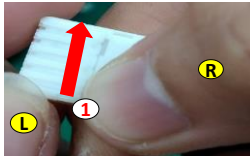



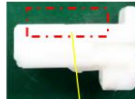
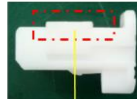
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PARTS:		1. AVSSf 0.3 wires B L=709±3mm [2pcs.]		JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
3	P2	Wire insertion to connector 6098-3810 (W)	<div><p>WIRE FACING</p><p>1. Get the 1st Black wire then insert to connector slot 1 using right hand. <i>Note: insertion process must be from left to right.</i></p><p>2. Get the 2nd Black wire then insert to connector slot 2 using right hand.</p><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>	n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 3. Insertion of wires must be from left to right</p> <p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>
4		Connector lock	<div><p>Put the connector into locking jig using both thumb then press to lock 2x. Check the connector lock if properly locked. <i>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</i></p><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p><p>Before Pressing</p><p>After Pressing</p></div>	LOCKING JIG 	<p>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p> <p>CONNECTOR LOCK CONDITION</p> <div><div><p>GOOD</p><p>Fully Locked</p></div><div><p>NG</p><p>UnLocked</p></div></div>

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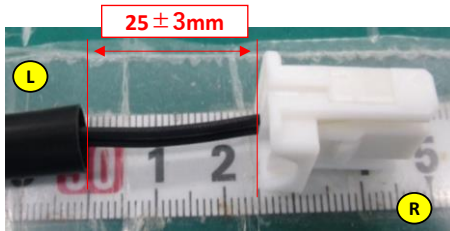
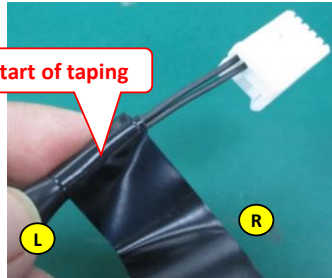
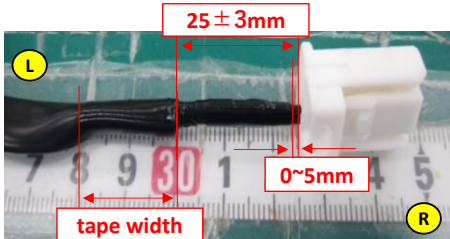

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PARTS:		1. Assy parts 2. Black vinyl tube Ø7 L=95±3mm 3. Black tape		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
5	P2	Wire insertion to Black vinyl tube Ø7 L=95±3mm	<div></div> <div>1. Get the black vinyl tube $\varnothing 7 L=95 \pm 3mm$ using right hand and insert the wires.</div>	n/a	1. No wrong usage of parts 2. No deformed terminal
6		Taping 1 Vinyl tube to wire near connector	<div><div></div><div>1. Measure from end of vinyl tube up to edge of connector $25 \pm 3mm$ using both hands.</div></div> <div><div></div><div>2. Get the Black tape using right hand then start taping process using both hands.</div></div> <div><div></div><div>3. After taping, check the measurement and taping condition.</div></div>	<div>MEASURING TAPE</div> 	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension

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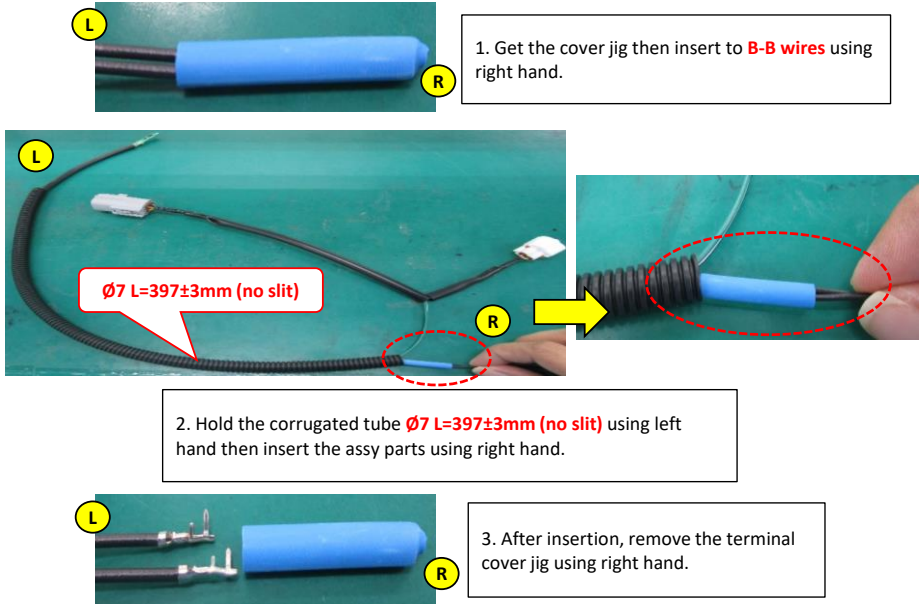

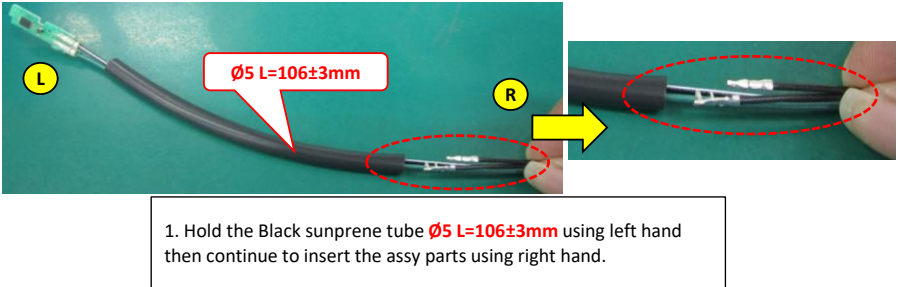
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PARTS:

1. Assy parts

JIG

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P2 Wire insertion to assy parts (Black corrugated tube Ø7 L=397±3mm) (no slit)	 <p>1. Get the cover jig then insert to B-B wires using right hand.</p> <p>2. Hold the corrugated tube Ø7 L=397±3mm (no slit) using left hand then insert the assy parts using right hand.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>	 TERMINAL COVER JIG	1. No wrong usage of parts 2. No wrong insertion
8	Wire insertion to assy parts (Black sunprene tube Ø5 L=106±3mm)	 <p>1. Hold the Black sunprene tube Ø5 L=106±3mm using left hand then continue to insert the assy parts using right hand.</p>	n/a	1. No wrong usage of parts 2. No wrong insertion

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PARTS:

1. Assy parts
2. Red tape

JIG

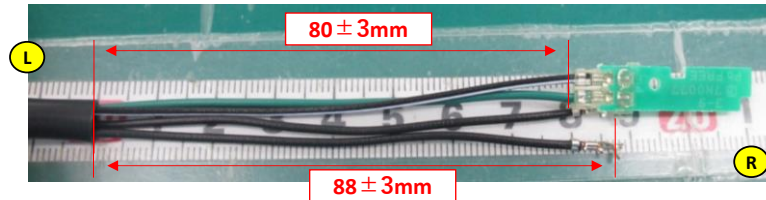
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****1 QUALITY POINTERS**

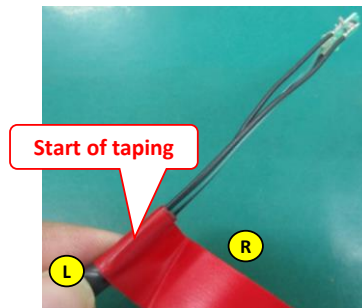
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P2

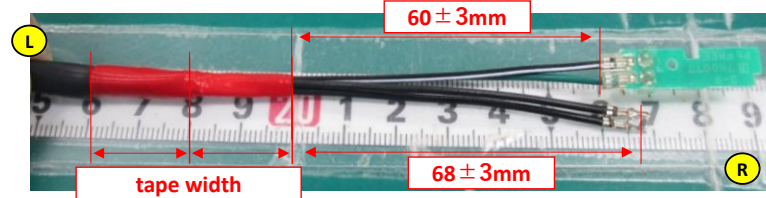
Taping 2
Black sunprene tube to wire
near hotmelted wires and
terminal pointed tip



1. Measure from end of sunprene tube up to edge of hotmelted wire **80±3mm** and up to terminal pointed tip **88±3mm** using both hands.

**Start of taping**

2. Get the **Red tape** using right hand then start taping process using both hands.



3. After taping, check the measurement and taping condition.

MEASURING TAPE

Important reminders/Note/s:
1. Use RED TAPE only
2. Please use calibrated/verified measuring tape when getting the measurement.

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

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

10

P2

Y-Taping



n/a

Important reminders/Note/s:

1. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

1 QUALITY POINTERS

11

P2

Y-Taping
(Continuation)

4. Make **1/3 shifting** going to vinyl tube until tape width then make **1 winding** of tape before shifting.

5. Make **1/2 shifting** going to COT until tape width then make **1 winding** of tape before shifting.

6. Make **1/2 shifting** going to vinyl tube until tape width then make **2 windings** of tape before final shifting.

7. Make **1/2 shifting** going to COT until tape width then make **2 windings** of tape then cut the tape.

8. After taping, check the measurement and taping condition.

MEASURING TAPE



Important reminders/Note/s:
1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.
2. Please use calibrated/verified measuring tape when getting the measurement.

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

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PARTS:

1. Assy parts

JIG

n/a



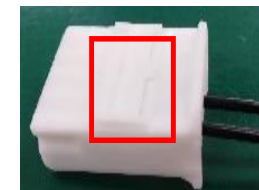
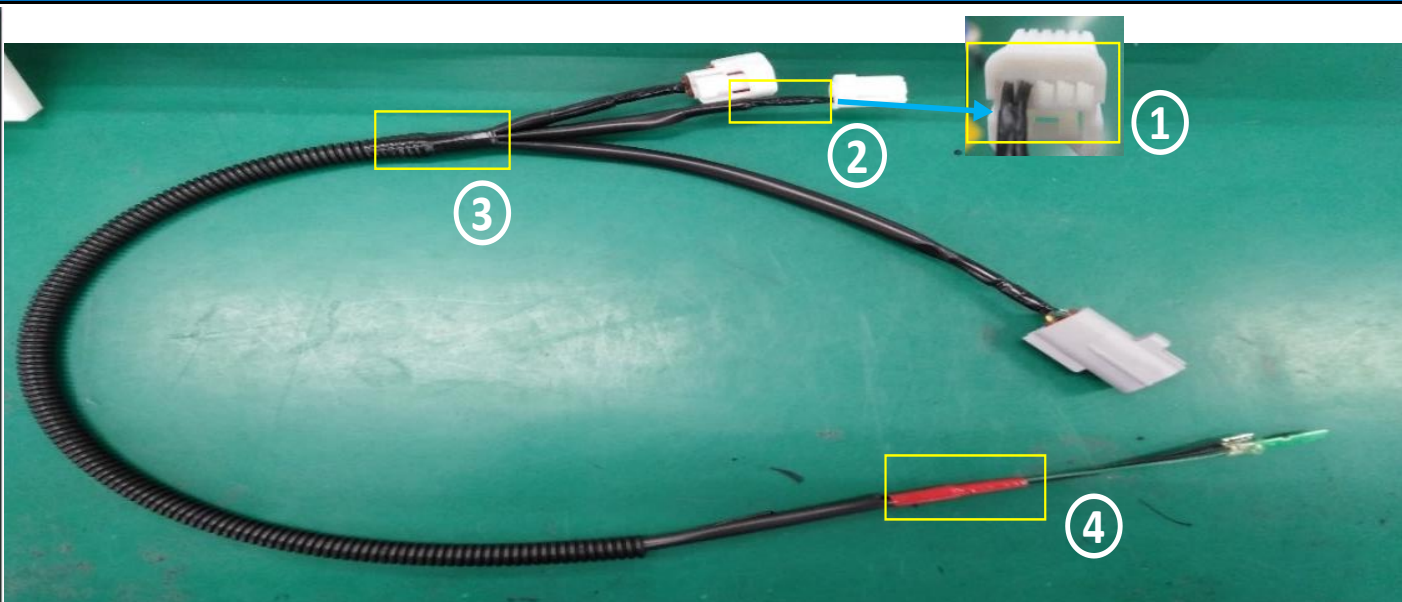
QUALITY CHECKPOINTS

P2

7L0123-7022



Proper alignment of B-
B wires and hotmelt



NO GOOD



GOOD

①

No **WRONG INSERT**
No **TERMINAL BACKING OUT**

②

③

④

No **MISSING TAPE**

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