

**WORK INSTRUCTION**

Effectivity Date:

May 5, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

C11**/****7H0382W7020A**

Customer:

NBS

Document No.:

WI-ENG-PDE-478A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

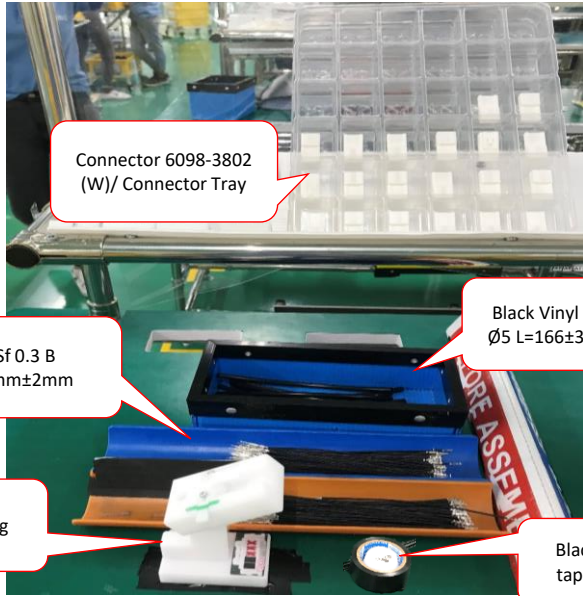
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PARTS:





1. All parts: Connector 6098-3802 (W); AVSSf 0.3 B L=233mm±2mm; Black Vinyl tube Ø5 L=166±3mm; Black tape

JIG:

1. Insertion jig

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 work place is prohibited. Keep it in your locker. Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	Note: 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	Revise	Check	Approve	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/5/22	1	Change Pre-launch to Masspro.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
04/19/22	0	Initial Issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	April 19, 2022		

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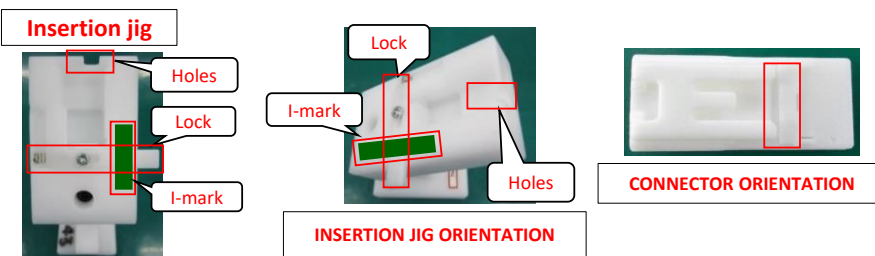
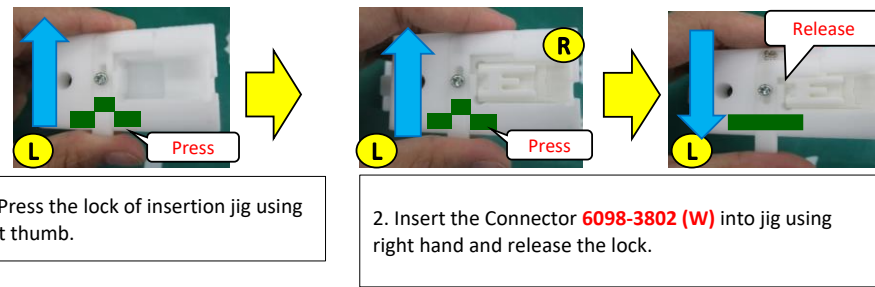
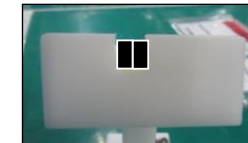
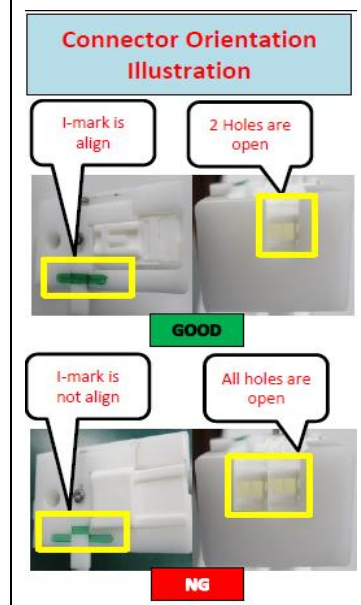
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PARTS:		1. Connector 6098-3802 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a Connector Setting to Insertion jig 6098-3802 (W)	<div><p>INSERTION JIG ORIENTATION</p></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the Connector 6098-3802 (W) into jig using right hand and release the lock.</p><p>3. Check the holes/terminal slot for 2 Black wires.</p></div> <div></div>		n/a	<div><p>Connector Orientation Illustration</p><p>GOOD</p><p>I-mark is align 2 Holes are open</p><p>NG</p><p>I-mark is not align All holes are open</p></div> <p>1. Use the provided jig per model 2. No wrong orientation of connector</p>

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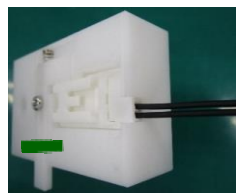
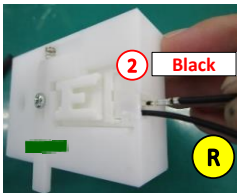
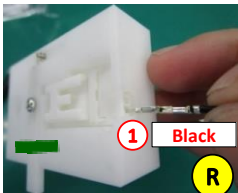
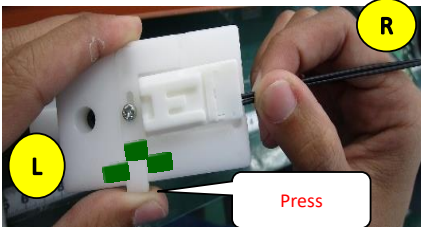
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PARTS:		1. AVSSf 0.3 B L=233mm±2mm [2pcs.]			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	n/a	<div><div>Wire facing</div></div> <div></div> <div><div>Press</div></div>			n/a	<div>Note: Refer to WI-PRO-CNC-017 for Wire and Strip length Tolerance</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>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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PARTS:

1. Assy parts
2. Black Vinyl tube Ø5 L=166±3mm

3. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

Wire insertion to
Black Vinyl tube Ø5
L=166±3mm



1. Get the Black Vinyl tube **Ø5 L=166±3mm** using right hand then insert the **B-B wires** using left hand.

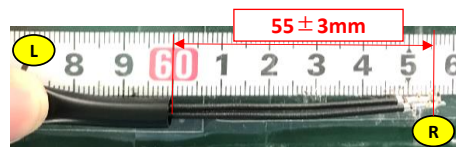
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1. No wrong usage of parts
2. No deformed terminal tip

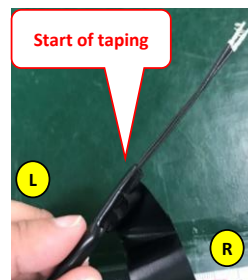
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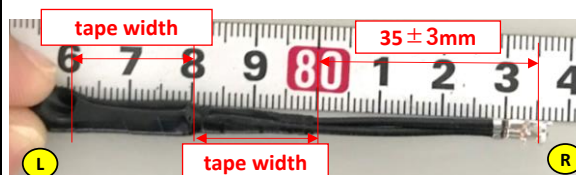
Taping 1
Black Vinyl tube to wire
near terminal



1. Measure from end of Vinyl tube up to terminal pointed tip **55±3mm** then continue the taping process using both hands.



2. Get the **Black tape** using right hand then start the taping process using both hands.
Note: Please refer to WI-PRO-ASY-001 for taping procedure.



4. After taping, check the measurement, terminal appearance and taping condition.

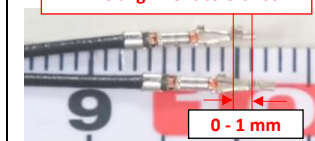
MEASURING TAPE



Note:
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

Wire alignment tolerance



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