



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 8, 2021

Process Name/Title:

Validity Date:

n/a

Product Name/Code: **096D / 7L0119-7020**

Customer: **TRQSS**

Document No.:

WI-ENG-PDE-242A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

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PARTS:

- Connector 6098-2220 (W)
- AVSSf 0.3 Y/OR wires L=713±2mm

JIG:

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

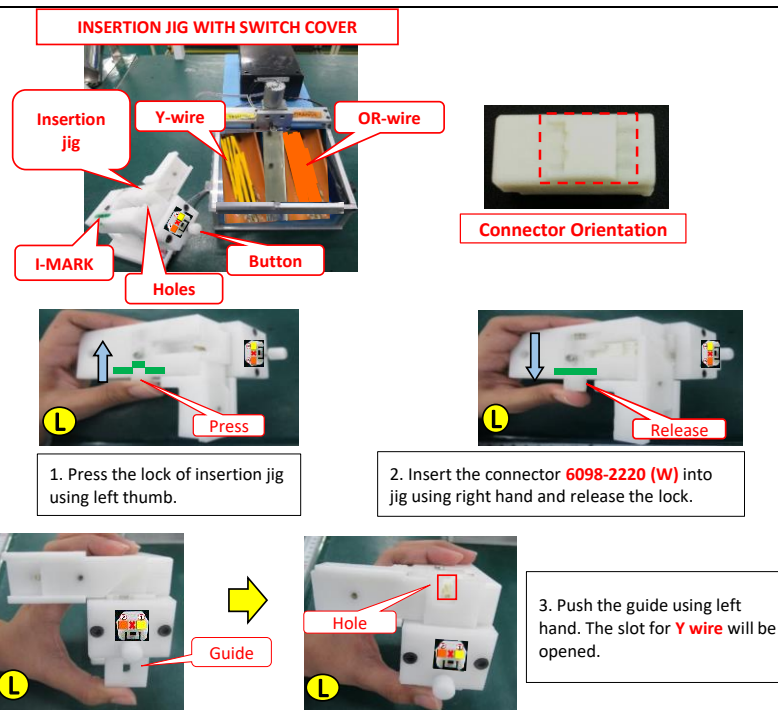
TOOLS/PPE

QUALITY POINTERS

1

P1

Connector setting to insertion jig 6098-2220 (W)



Safety Instruction

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

- Maintain and always practice 5's.
- Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Connector Orientation Illustration

I-mark was align

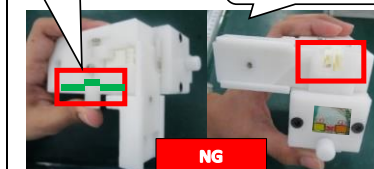
1 hole is open



GOOD

I-mark was not align

All holes were open



NG

- Use the provided jig per model
- No wrong orientation of connector
- No wrong use of connector
- No damaged connector

Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/08/21	1	Change purpose from Pre-launch to Mass pro	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes
02/27/21	0	Initial issue	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes

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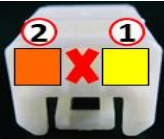
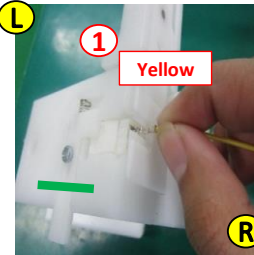
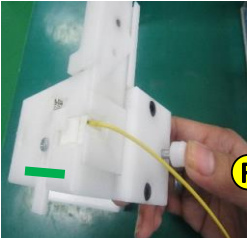
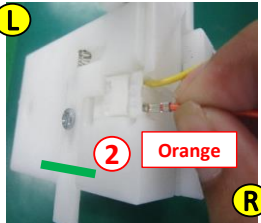
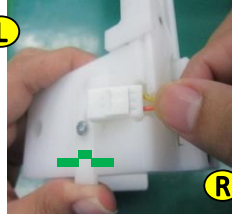
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PARTS:	n/a			JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to connector 6098-2220 (W)		n/a	<div>1. No loose insertion</div> <div>2. No wrong insertion</div> <div>3. 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>
		<div>WIRE FACING</div> <div>VISUAL REFERENCE</div> <div>1 Yellow 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>2 Orange 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>			

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P1

Connector lock

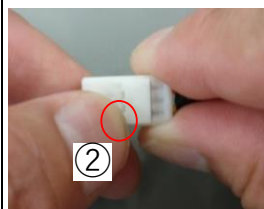
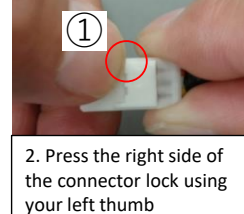
Sequence of Pressing the Double Lock:

① - ② - ③

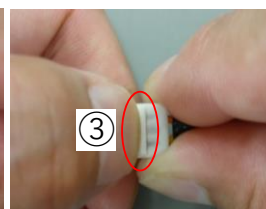
Method: Press one by one using one thumb



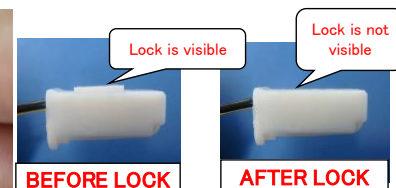
1. Hold the 6098-2220 connector using right hand



3. Press the left side of the connector lock using your left thumb



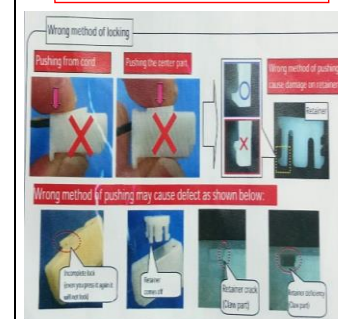
4. Press the terminal insertion side with your left thumb



5. Check the locking condition

n/a

Wrong Locking Method



1. No unlocked/half-locked connector
2. No one time pressing of double lock
3. Make sure not to hit the portion ③ (bottom side) when pressing ① & ②

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PARTS:	1. Assy parts			JIG	n/a
	2. Black corrugated tube (no slit) $\Phi 5$ L=316±3mm 3. Black corrugated tube (no slit) $\Phi 5$ L=172±3mm				
4. Black vinyl tube $\Phi 5$ L=181±3mm					
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Wire insertion to Black corrugated tube (no slit) $\Phi 5$ L=316±3mm $\Phi 5$ L=172±3mm	<div><div>1. Get the corrugated tube $\Phi 5$ L=316±3mm using right hand then insert the Y-OR wire using left hand.</div></div>	n/a	1. No wrong use of parts 2. No deformed terminal
			<div><div>1. Get the corrugated tube $\Phi 5$ L=172±3mm using right hand then insert the Y-OR wire using left hand.</div></div>		
5	P1	Wire insertion to Black vinyl tube $\Phi 5$ L=181±3mm	<div><div>1. Get the vinyl tube $\Phi 5$ L=181±3mm using right hand then insert the Y-OR wire using left hand.</div></div>	n/a	1. No wrong use of parts 2. No deformed terminal

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PARTS:

1. Connector 6098-3802 (W)

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Connector setting to insertion jig 6098-3802 (W)	<p>INSERTION JIG</p> <p>I-MARK Visual reference Lock Button Guide</p> <p>INSERTION JIG ORIENTATION</p> <p>CONNECTOR ORIENTATION</p> <p>GOOD</p> <p>NG</p> <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. Push the guide using left hand. The slot for Y wire will be opened.</p>	n/a	<p>Connector Orientation Illustration</p> <p>I-mark is align 2 Holes are open</p> <p>I-mark is not align All holes are open</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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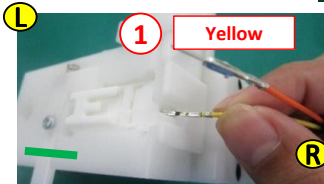
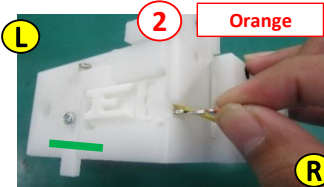
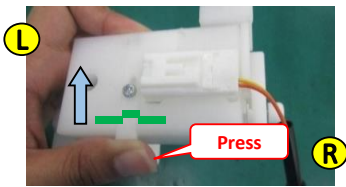
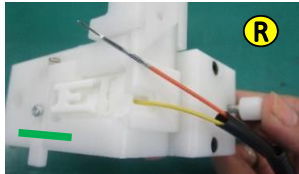

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PARTS:		1. Assy parts 2. AVSSf 0.3 B/B wires L=798±3mm [2pcs.] 3. Black sunprene tube Φ5 L=121±3mm		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Wire insertion to connector 6098-3802 (W)	<div><p>Wire facing</p></div> <div><p>1. Get the assy part and hold the Y wire then insert to terminal slot ① using right hand.</p></div> <div><p>2. Get the OR wire then insert to terminal slot ② using right hand.</p></div> <div><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></div> <div><p>2. After insertion of Y wire press the button using right hand. Slot for OR wire will be opened.</p></div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed 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>
8	Wire insertion to Black sunprene tube Φ5 L=121±3mm	<div><p>1. Get the black sunprene tube Φ5 L=121±3mm using right hand then insert the B/B wires L= 798±3mm (n=2) using left hand.</p></div>		n/a	1. No wrong use of parts

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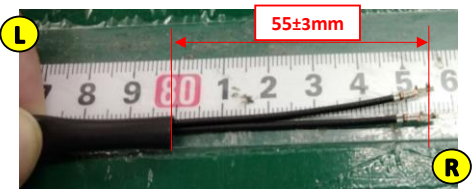
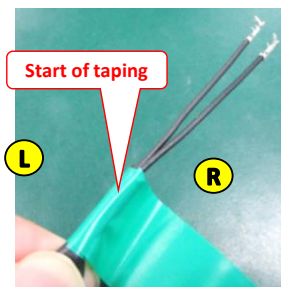
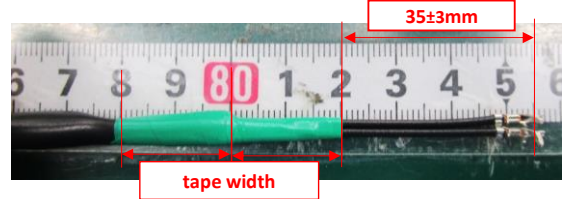

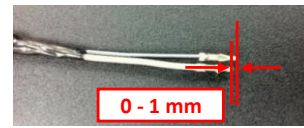

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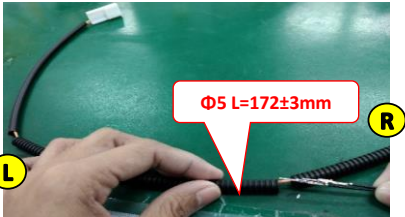
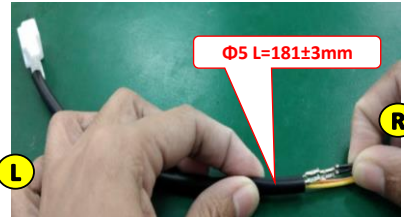
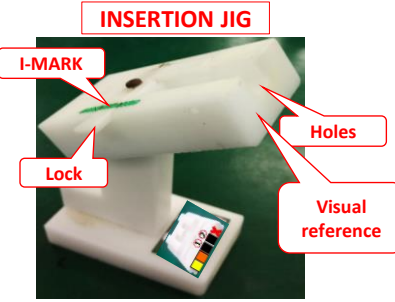
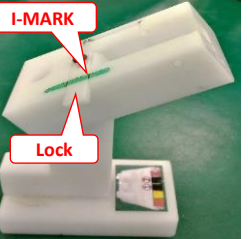

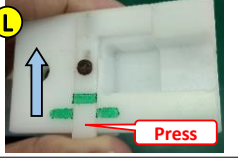
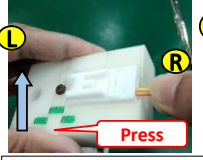

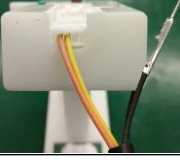
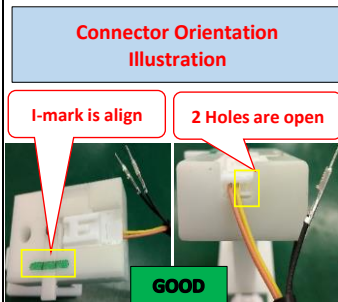
PARTS:		1. Assy parts 2. Green tape 3. Black corrugated tube (no slit) $\Phi 5$ L=237 \pm 3mm		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Taping 1 Black corrugated tube to wire near terminal	 <p>1. Measure from end of sunprene tube up to terminal pointed tip 55\pm3mm using both hands.</p>  <p>2. Get the Green tape using right hand then start taping process using both hands. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>3. After taping, check the measurement, wire alignment and taping condition.</p>			<p>NOTE: USE GREEN TAPE ONLY.</p> <p><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p> <p>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</p> <p>Wire alignment tolerance</p>  <p>0 - 1 mm</p>
10	Wire insertion to Black corrugated tube (no slit) $\Phi 5$ L=237 \pm 3mm	 <p>1. Get the vinyl tube $\Phi 5$ L=237\pm3mm using right hand and insert B/B wires using left hand.</p>		n/a	<p>1. No wrong use of parts 2. No deformed terminal</p>


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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.: 8 of 9

PARTS:	1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	Wire insertion to assy parts	<div>   </div> <div> <p>1. Hold the corrugated tube (no slit) Φ5 L=172±3mm using left hand then insert the assy parts using right hand.</p> <p>2. Hold the vinyl tube Φ5 L=181±3mm using left hand then insert the assy parts using right hand.</p> </div>		n/a	1. No wrong use of parts 2. No deformed terminal 3. No wrong insertion
12	P1 Connector setting to insertion jig 6098-3802 (W) (Assy parts)	<div>    </div> <div>     </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 for B/B wires, it must be opened.</p> </div>		n/a	<div>  </div> <p>GOOD</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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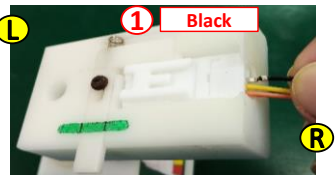
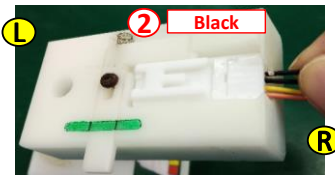
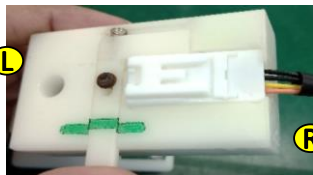
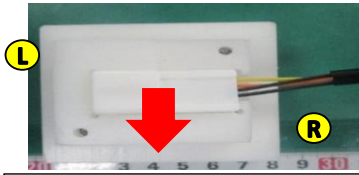

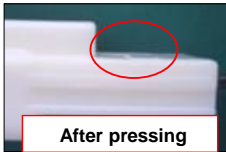


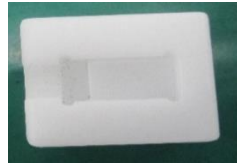
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PARTS:		1. Assy parts		JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	Wire insertion to connector 6098-3802 (W) (Assy parts)	<div><p>Wire facing</p></div> <div><p>1. Get the assy part and hold the B wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Hold the B 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>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed 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>
14	Connector lock	<div><p>1. Put the connector into locking jig using right hand then press 2x to lock. Touch the connector lock to confirm if properly locked. Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</p></div> <div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><p>GOOD Full Lock</p></div> <div><p>NG Half Lock</p></div>		<div>LOCKING JIG</div> 	<div>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</div> <div>1. Use the provided locking jig per model 2. No unlock/half-lock connector</div>

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