

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

Effectivity Date:

May 16, 2022Model Code/Part Number: **749W / 7H0336W7020D** Customer: **NBS**

Validity Date:

n/aPurpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Document No.:

WI-ENG-PDE-525A

Revision No.:

1

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1 of 6**PARTS:**

1. All parts; (Connector 6098-5677 (W); AVSSf 0.3 B wires L=398±2mm; Black Corrugated tube Ø5 L=305±3mm (No Slit); Black Vinyl tube Ø5 L=30±3mm; Black tape)

JIG:

1. Insertion jig
2. Locking jig
3. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out	<p>TABLE LAY-OUT</p> <p>Connector 6098-5677 (W)/ Connector tray</p> <p>Black Vinyl tube Ø5 L=30±3mm</p> <p>AVSSf 0.3 B wires L=398±2mm</p> <p>Black Corrugated tube Ø5 L=305±3mm (No Slit)</p> <p>Insertion jig</p> <p>Locking jig</p> <p>Terminal cover jig</p> <p>Tape holder/ Black tape</p>	<p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping</p> <ol style="list-style-type: none">1. Maintain and always practice 5's.2. Personal things on the workplace is prohibited. Keep it in your locker. <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</p> <ol style="list-style-type: none">1. No missing parts/tools.2. No excess parts/tools.

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
05/16/22	1	Change from Pre-Launch to Masspro. Additional Table Lay-out.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes		M. Ariola	J. Loterte	C. Villanueva	A. Arañes
05/11/22	0	Initial issue	M. Ariola	J. Loterte	C. Villanueva	A. Arañes		M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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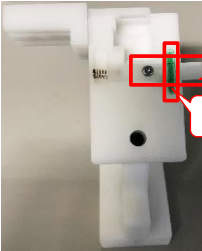
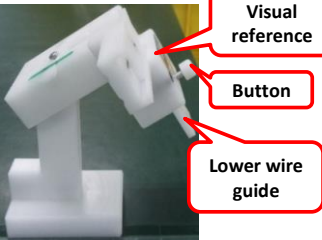
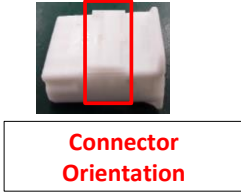
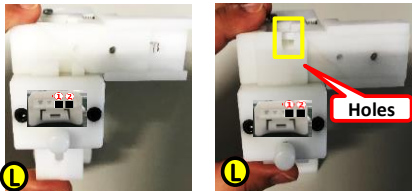
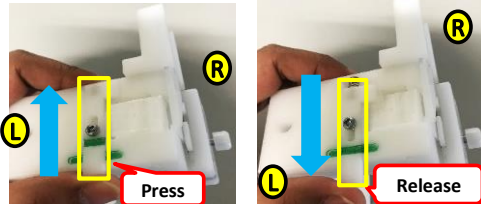
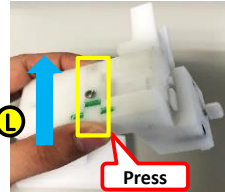


☒ MASSPRO

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PARTS:		1. Connector 6098-5677 (W)			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P1	<div><div><p>Insertion Jig</p></div><div><p>Insertion Jig Orientation</p></div><div><p>Connector Orientation</p></div></div> <div></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6098-5677 (W) using right hand and release the lock using left hand. <i>Note: Follow the connector orientation.</i></p><p>3. Check the holes/terminal slot for B-B wires.</p></div>			n/a	<div><p>Connector Orientation</p></div> <div><p>1. Use provided jig per model</p><p>2. No wrong usage of parts</p><p>3. No wrong orientation of connector</p><p>4. No damaged connector</p></div>

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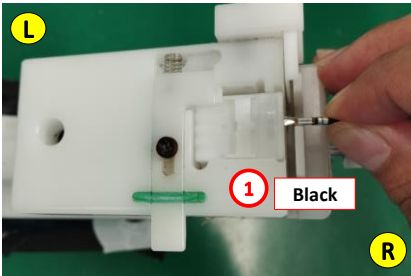
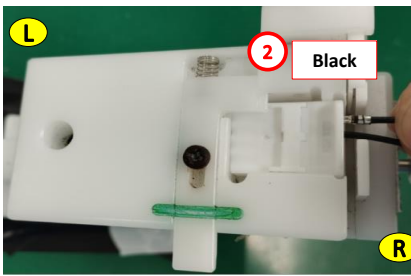
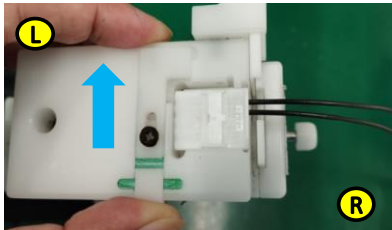
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. AVSSf 0.3 B wires L=398±2mm [2pcs.]			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	P1	<div>Wire insertion to Connector 6098-5677 (W)</div> <div><div>WIRE FACING</div></div> <div></div> <div></div> <div></div> <div>1. Get the 1st Black wire then insert to terminal slot 1 using right hand. <i>Note: Insertion of B-B wires must be from left to right.</i></div> <div>2. Get the 2nd Black wire then insert to terminal slot 2 using right hand.</div> <div>3. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div>			n/a	<div><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></div> <div><i>Note: Please hold the wire near terminal during insertion.</i></div> <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>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div><i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></div>

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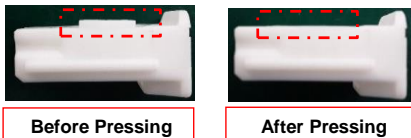
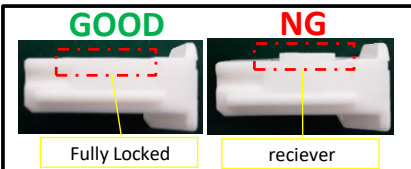





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4 of 6**PARTS:**

1. Assy parts
2. Black Corrugated tube Ø5 L=305±3mm (No Slit)

JIG

1. Locking jig
2. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Connector lock	   <p>1. Put the connector into locking jig using right hand then press to lock 2x using both hands. Touch the connector if it is properly locked. <i>Refer to GL-PRO-ASY-017 for verification of connector lock.</i></p>	LOCKING JIG 	NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK. 1. Use the provided locking jig per model 2. No unlock/half-lock connector
5	P1 Wire Insertion to Black Corrugated tube Ø5 L=305±3mm (No Slit)	   <p>1. Get the terminal cover jig using right hand then insert the B-B wires using left hand.</p> <p>2. Get the Black COT Ø5 L=305±3mm (No Slit) using right hand and insert B-B wires using left hand.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>	Terminal cover jig 	1. No wrong use of parts 2. No deformed terminal

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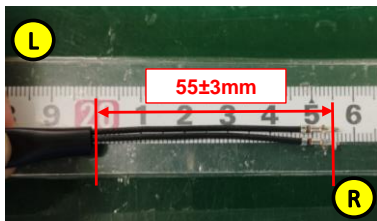

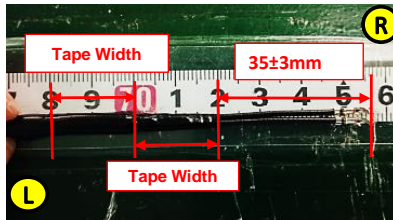

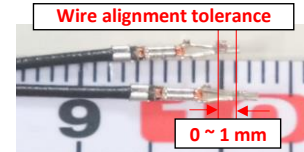
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PARTS:

1. Black Vinyl tube Ø5 L=30±3mm
- 2 .Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Wire insertion to Black Vinyl tube Ø5 L=30±3mm	 <p>1. Get the Black Vinyl tube Ø5 L=30±3mm using right hand and insert B-B wires using left hand.</p>	n/a	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal
7	Taping 1 Black Vinyl Tube to Wire near terminal	 <p>1.Measure the end of the Viny tube up to the end of the terminal pointed tip 55mm using both hands.</p>  <p>2. Get Black tape, hold the vinyl tube (Ø5 L=30±3mm) using left hand then fold the vinyl tube and start taping using right hand. <i>Refer to WI-PRO-ASY-001 for taping procedure</i></p>  <p>3.After taping,check the measurement, alignment and tape condition.</p>	<p>MEASURING TAPE</p> 	<p><i>Note:</i> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape  <p>Wire alignment tolerance 0 ~ 1 mm</p>

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

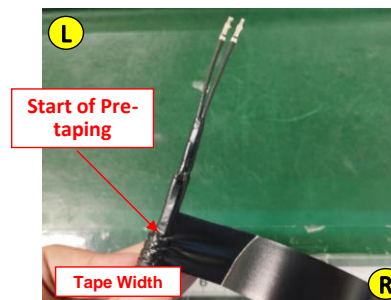
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P1

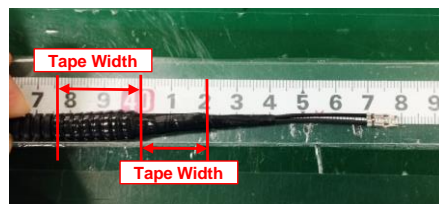
Taping 2
Black Corrugated tube
to Black Vinyl tube



1. Measure the end of the COT up to the end of the terminal pointed tip **85mm** using both hands.



2. Fix the Corrugated tube and Vinyl tube using left hand, get the **Black tape** and start taping process using both hands.
Note: Please refer to WI-PRO-ASY-001 for taping procedure.



3. After taping, check the measurement 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 dimension
6. No wrong use of tape

Wire alignment tolerance



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