

	WORK INSTRUCTION						Effectivity Date:		June 1, 2023	
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:				Product Name/Code: 500B / 7L0086-7024		Customer: TRQSS		Document No.: WI-ENG-PDE-029B	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.: 6 Page No.: 1 of 7	

PARTS:	1. Connector 6098-3811 (B) 2. Twisted tube ø5 L=115±3mm 3. Assy parts 4. Black tape 5. White tape	JIG:	1. Insertion jig 2. Locking jig
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NO.	PROCESS NAME	6 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Table Lay-out	<div style="border: 1px solid black; padding: 5px; margin-bottom: 10px;"> Table Lay-out </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	<div style="border: 1px solid black; padding: 5px; margin-bottom: 10px;"> Document reference/s: 1. Please refer to WI-PRO-CNC-017 for wire and strip length tolerance. </div> <div> 1. No missing parts/tools 2. No excess parts/tools </div>

Revision History							Prepared by:	Checked by:	Approved by:	Noted by:
06/01/23	6	Inclusion of table lay-out and quality check points; improve important reminders/note/s and document references; Improve work procedure / illustration on process connector lock.	J. Loterte	C. Villanueva	A.Arañes	n/a				n/a
04/17/21	5	Remove validity date. Add quality pointers to Taping process. Change winds to windings. Add guidelines to connector lock process.	D.Castillo	C. Villanueva	A. Shimamura	A.Arañes				
10/12/20	4	Remove cycle time and change method from 2x pulling to PULL-PUSH-PULL-PUSH method.	D.Castillo	R. Peñaloza	A.Shimamura	A.Arañes				
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	November 26, 2019		

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **500B / 7L0086-7024**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Customer:

TRQSS

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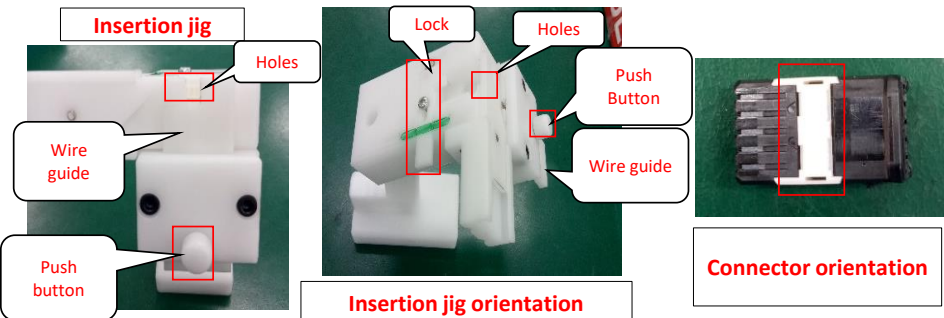
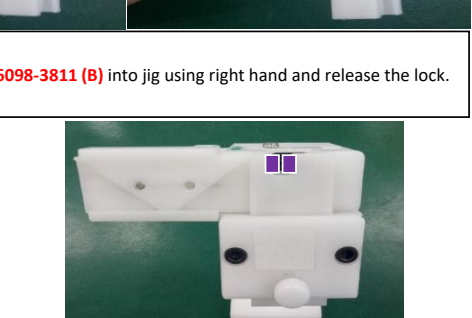
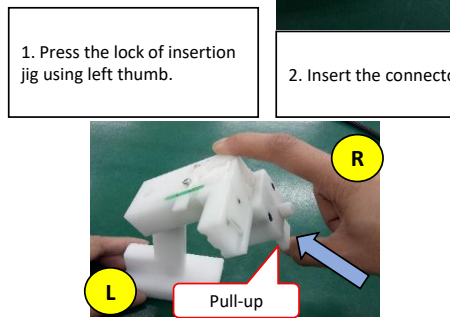
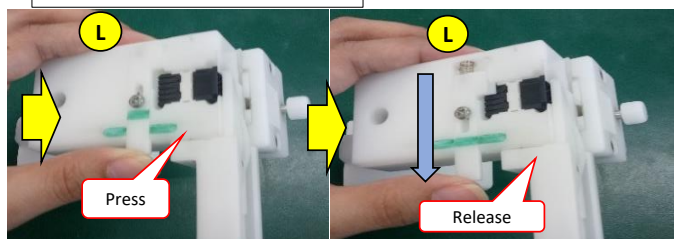
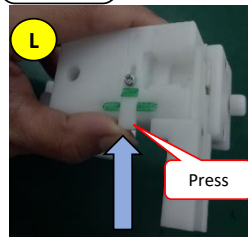
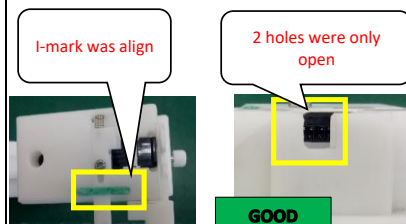
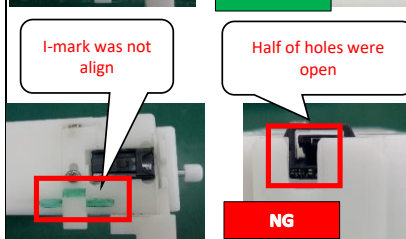
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PARTS:

1. Connector 6098-3811 (B)

JIG:

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Connector setting to Insertion jig 6098-3811 (B)	<div><p>Insertion jig orientation</p><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6098-3811 (B) into jig using right hand and release the lock.</p><p>3. Pull-up the wire guide using right thumb to show the holes/terminal slot.</p><p>4. Check the holes/terminal slot for V-V wires.</p></div>	n/a	<div><p>Connector Orientation Illustration</p><p>GOOD</p><p>NG</p><p>1. Use the provided jig per model 2. No wrong orientation of connector</p></div>

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Product Name/Code: 500B / 7L0086-7024

Customer: TRQSS

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

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PARTS:

1. Assy part

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

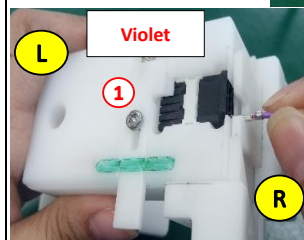
QUALITY POINTERS

3

P2

Wire Insertion to
connector
6098-3811 (B)

Wire facing



Violet

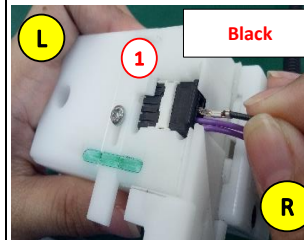
1. Get the assy part and hold first **Violet wire** and insert to connector using right hand then insert second **Violet wire**.
Note : Insertion should be left to right.

2

Violet

2. Push the button to show next slot for B/B wire.

Push button



Black

3. Hold first **Black wire** and insert to connector using right hand then insert second **Black wire**.
Note : Insertion should be left to right.

4

Black

4. After insertion, push the lock button using left thumb and then hold the wires and gently pull out the connector from jig using right hand.

Press

N/A

6

Important reminders and Note/s:

1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.
Do not exert extra force.

Document reference/s:

1. Refer to GL-PRO ASY-028 for Pull-Push procedure.
2. Refer to WI-PRO-CNC-017 for wire and strip length tolerance.

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

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PARTS:

1. Assy part

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

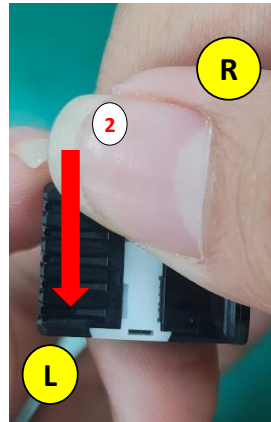
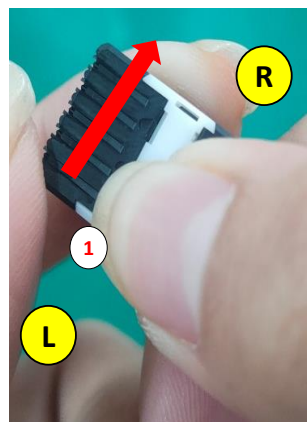
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P2

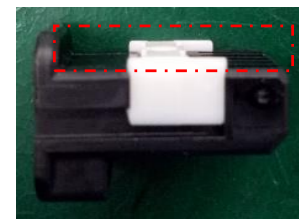
Connector lock



1. Put the connector into locking jig using right hand then press to lock **2x**. Check the connector lock to confirm if properly pressed.



2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.



BEFORE PRESSING



AFTER PRESSING

LOCKING JIG



6

Important reminders and Note/s:

1. Manual locking may cause damaged lock.

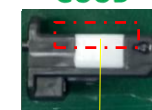
Document reference/s:

1. Refer to GL-PRO-ASY-017 for verification of connector lock.

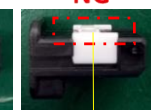
CONNECTOR LOCK CONDITION

GOOD

NG



Fully Locked



Unlocked

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☐ PROTOTYPE

☐ PRE-LAUNCH

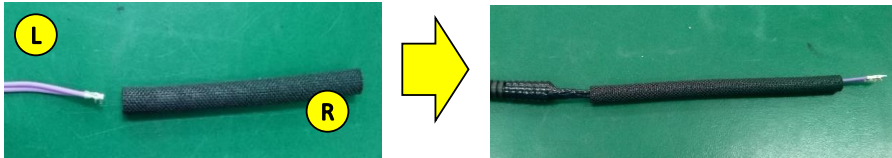
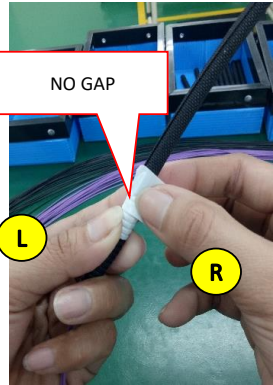
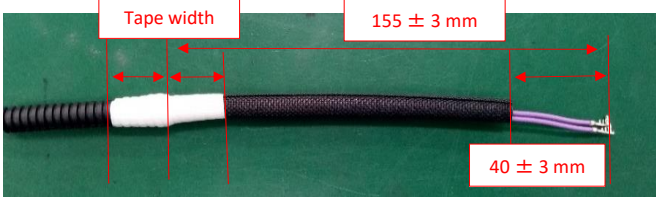

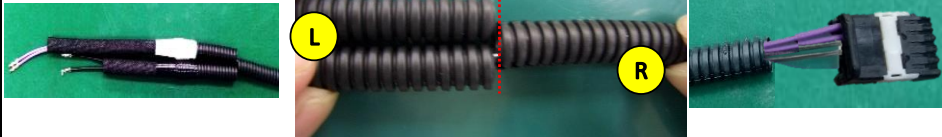
☒ MASSPRO

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PARTS:		1. Twisted tube 2420F ø5 L=115±3mm 2. White tape			3. Assy parts	JIG	N/A
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
6	P2	Twisted tube insertion ø5 L=115±3mm	<div></div> <div>1. Get the twisted tube ø5 L=115±3mm using right hand and insert to violet wires using left hand.</div>		N/A	1. No wrong usage of parts	
7		Taping 4 Corrugated tube to twisted tube	<div></div> <div><div>1. Hold the twisted tube using left hand and get White tape using right hand and begin taping.</div><div>2. After taping, check the measurement and taping condition.</div></div> <div></div>		<div>MEASURING TAPE</div> 	<div><div>6</div><div>Important reminders and Note/s: 1. Manual locking may cause damaged lock. 2. USE <u>WHITE</u> TAPE ONLY</div></div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</div> <div>1. No flip out tape 2. No peel-off tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</div>	
8		Y-Taping	<div></div> <div>1. Fix the corrugated tube .</div>		N/A	<div>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No gap between corrugated tubes 6. No exposed wire</div>	

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Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:

1. Assy parts
2. Black tape

JIG

N/A

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

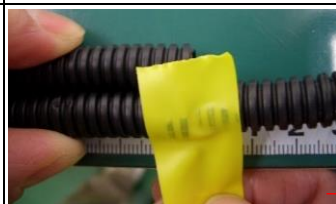
TOOLS/PPE

QUALITY POINTERS

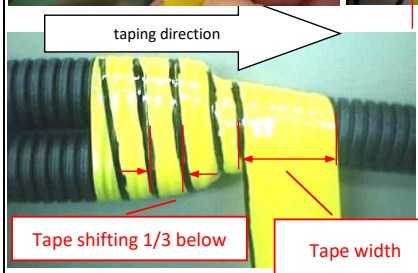
9

P2

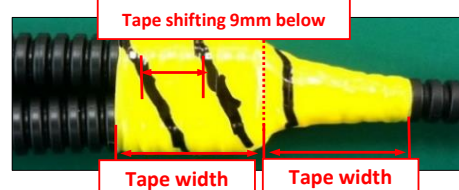
Y-Taping
(Continuation)



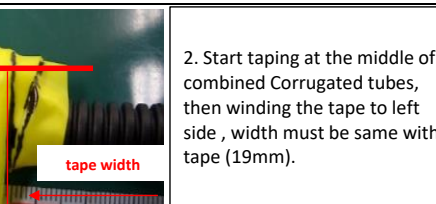
2. Start taping at the middle of combined Corrugated tubes, then winding the tape to left side, width must be same with tape (19mm).



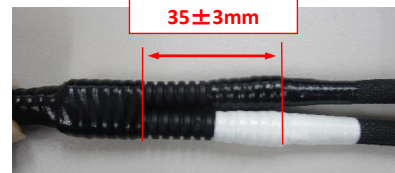
3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)



5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.



4. Winding the tape backward 1/2 shifting.



6. Check the measurement from end of y-taping to the middle of corrugated tube and twisted tube **35±3mm**.

MEASURING TAPE



Important reminders and Note/s:
1. Used Yellow tape for easy visualization of shifting lines, but actual should be BLACK.

2. Please use calibrated/verified measuring tape when getting the measurement.

3. Do not exert excessive force during pulling & winding of tape

- 1.No flip out tape
- 2.No tape peeling
3. No loose tape
4. No wrong use of tape
5. No wide interval between COT
6. No exposed wire

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PARTS:

1. Assy parts

JIG

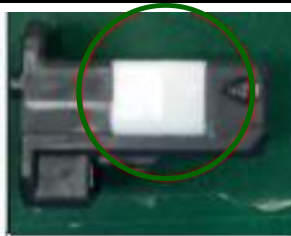
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QUALITY CHECKPOINTS

P2

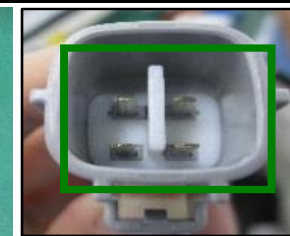
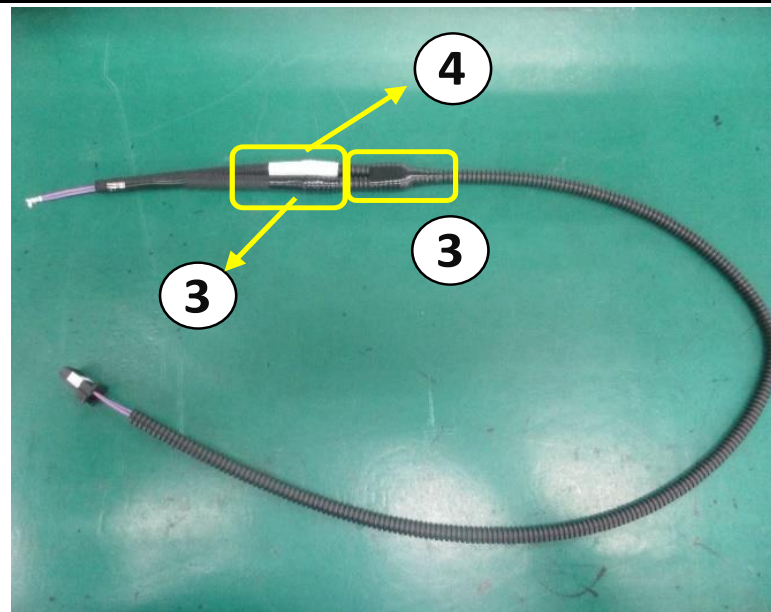
7L0086-7024



GOOD



GOOD



GOOD



GOOD



NO GOOD



NO GOOD



NO GOOD



NO GOOD

1 No Unlock/Halflock Connector

2 No Wrong Insert

3 No Missing Tape (y-taping and on twisted tube)

4 No Wrong Used of tape (white tape)

5 No Terminal Backing Out

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