

	WORK INSTRUCTION				Effectivity Date:		December 13, 2022	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model Code/Part Number: 100B / 7M0592-7021		Customer: TRJ		Document No.: WI-ENG-PDE-423B	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		2	Page No.: 1 of 8

PARTS:	1. Assy parts: Connector 6098-3810 (W); AVSSf 0.3 B-B wires L=668±3mm; Black COT (no slit) ø5 L=85±3mm; Black COT (with slit) ø5 L=411±3mm; Black tape [2pcs.]			JIG:	1. Insertion jig 2. Terminal cover jig 3. COT Adaptor
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	P2 Table Lay-out	<div style="border: 1px solid black; padding: 5px; margin-bottom: 10px; text-align: center;">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 workplace 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>	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by	Reviewed by	Approved by	Noted by
12/13/22	2	Improve quality pointers: Reminders/notes and references. Inclusion of Quality checkpoints	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
03/02/22	1	Correction of tape color from Green tape to Gray tape in Process 7, procedure 2.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
02/24/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: February 24, 2022	

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☐ PRE-LAUNCH




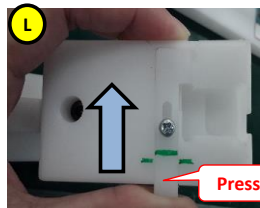
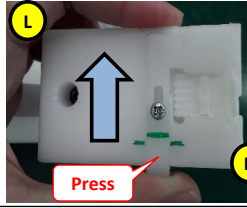
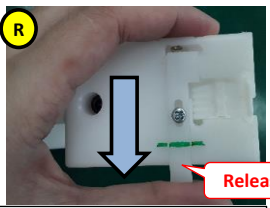

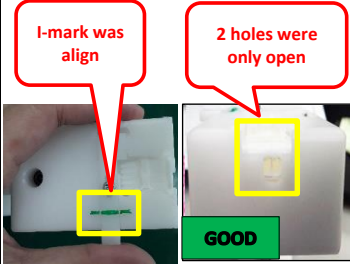

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PARTS:		1. Connector 6098-3810 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	<div><div>INSERTION JIG</div><div><div>INSERTION JIG ORIENTATION</div><div><div>CONNECTOR ORIENTATION</div><div></div></div><div><div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div><div>2. Insert the connector 6098-3810 (W) into jig using right hand and release the lock. Note: Follow the connector orientation.</div></div><div><div><div>3. Check the holes/terminal slot for B/B wires.</div></div></div></div><div></div></div></div></div>		n/a	<div><div>Connector Orientation Illustration</div><div><div><div>GOOD</div></div><div><div><div>NG</div></div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div></div></div>

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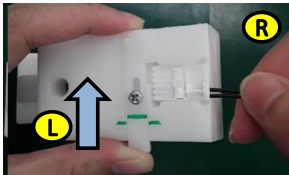






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PARTS:		1. AVSSf 0.3 wires B L=668±3mm [2pcs.]		JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	2 QUALITY POINTERS
3	P2	Wire insertion to connector 6098-3810 (W)	<div><p>WIRE FACING</p></div> <div><p>1. Get the 1st Black wire then insert to connector slot 1 using right hand. Note: insertion process must be from left to right.</p></div> <div><p>2. Get the 2nd Black wire then insert to connector 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	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted.</p> <p>Conduct Pull-Push-Pull-Push after insertion.</p> <p>Do not exert extra force.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>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. Note: WI-PRO-KIT-001 Proper locking and checking of connector lock</p></div> <div><p>Before Pressing</p></div> <div><p>After Pressing</p></div> <div><p>GOOD Fully Locked</p></div> <div><p>NG Unlocked</p></div>	LOCKING JIG 	<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damaged lock</p>

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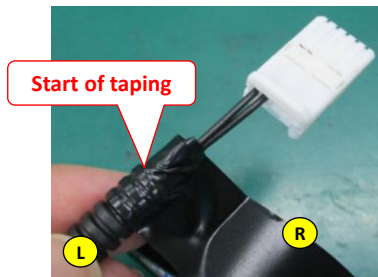
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PARTS:		1. Assy parts 2. Black corrugated tube (no slit) $\varnothing 5$ L=85 \pm 3mm 3. Black tape		JIG	1. Terminal cover jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Wire insertion to Black corrugated tube (no slit) $\varnothing 5$ L=85 \pm 3mm	<div><div><p>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B-B wires using left hand.</p></div><div><p>2. Get the corrugated tube (no slit) $\varnothing 5$ L=85\pmmm using right hand then insert the B-B wires using left hand.</p></div><div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div></div> <div>TERMINAL COVER JIG </div>		1. No wrong usage of parts 2. No deformed terminal	
6		Taping 1 Black corrugated tube to wire near connector	<div><p>1. Hold the corrugated tube using left hand then start taping using right hand.</p></div>	n/a	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	

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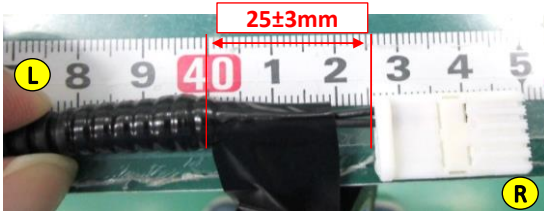
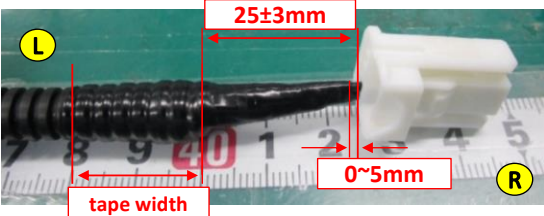

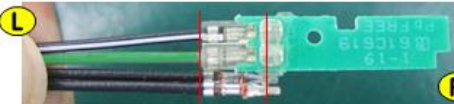


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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	2 QUALITY POINTERS
6	Taping 1 Black corrugated tube to wire near connector (Continuation) P2	 <p>2. Measure from end of the corrugated tube up to connector 25±3mm then continue the taping process using both hands.</p>  <p>3. After taping, check the measurement and taping condition.</p>	 <p>MEASURING TAPE</p>	<p>Important reminders/Note/s:</p> <p>1. 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 dimension 6. No wrong use of tape</p>
7	Taping 2 Spot taping	 <p>1. Fix the hotmelted wire and terminal pointed tip using both hands.</p>  <p>2. Hold the wires using left hand, get the Black tape using right hand then make 2 windings of tape using both hands. Note: Position of spot taping must be right beside Gray tape.</p> 	n/a	<p>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</p> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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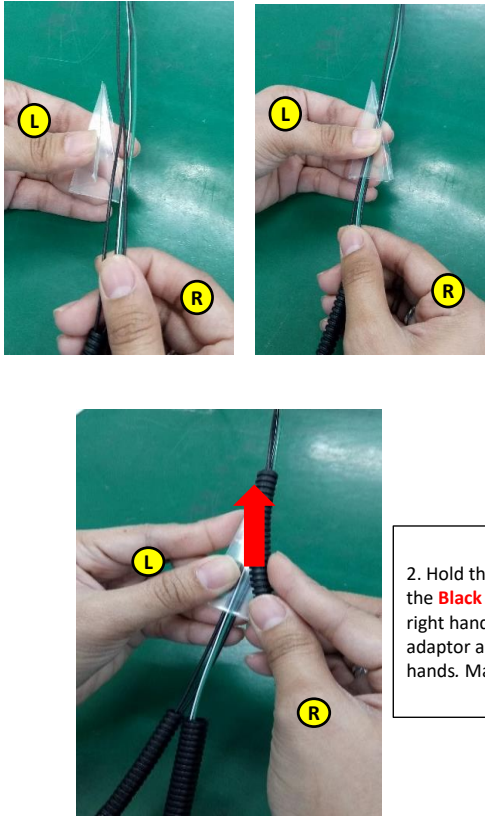

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1. Assy parts
2. Black Corrugated tube (w/slit) $\phi 5$ L=411 \pm 3mm

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P2 Wire insertion to Black Corrugated tube (w/slit) $\phi 5$ L=411 \pm 3mm	 <p>1. Hold the COT adaptor using left hand then insert the wires using right hand.</p> <p>2. Hold the COT adaptor with wires using left hand, get the Black corrugated tube (w/slit) $\phi 5$ L=411\pm4mm using right hand then insert to COT adaptor. Hold the COT adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted.</p>	<p>COT Adaptor</p> 	<ol style="list-style-type: none">1. No wrong use of parts2. No wires left inside COT with slit

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

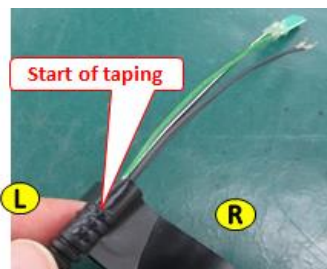
TOOLS/PPE

2 QUALITY POINTERS

9

P2

Taping 3
Black Corrugated tube
(w/slit) to wire near PCB
and terminal tip



1. Hold the corrugated tube using left hand then start taping using right hand.



2. Measure from end of the corrugated tube up to hotmelted wires **131±3mm** then continue the taping process using both hands.

MEASURING TAPE



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



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

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1. Assy parts

JIG

n/a

2 QUALITY CHECKPOINTS**P2****7M0592-7021****1**

No **WRONG INSERT**
No **UNLOCKED/HALFLOCKED**
NO **TBO**

2

No **MISSING TAPE**

**Proper
alignment of
B/B wires and
hotmelt**

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