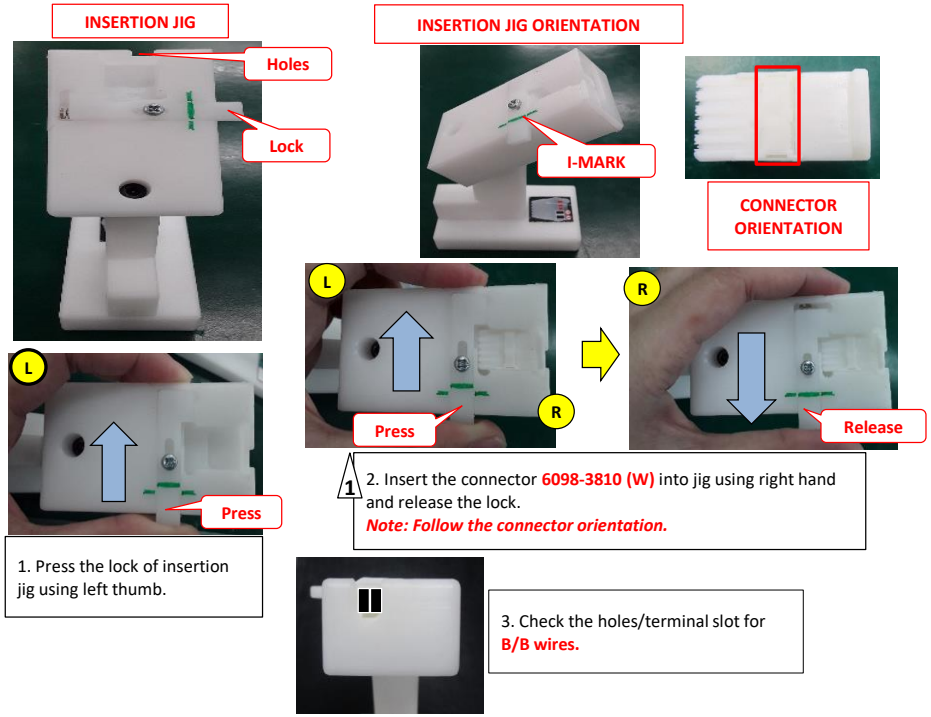
NBC	WORK INSTRUCTION		Effectivity Date:	August 2, 2021	
	Process Name/Title:	TAPING ASSEMBLY PROCESS	Validity Date:	n/a	
	Product Name/Code: 100B / 7M0592-7020B	Customer: TRJ	Document No.:	WI-ENG-PDE-311B	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.: 1 of 6

PARTS:	1. Connector 6098-3810 (W)	JIG:	1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 △1 Connector setting to insertion jig △1 6098-3810 (W)			



1. Press the lock of insertion jig using left thumb.

△1 2. Insert the connector **6098-3810 (W)** into jig using right hand and release the lock.
Note: Follow the connector orientation.

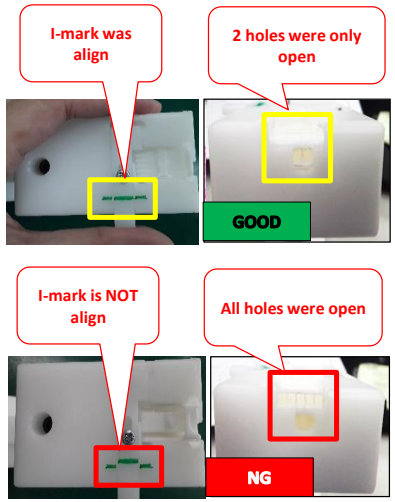
3. Check the holes/terminal slot for **B/B wires.**

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 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



1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted
08/02/21	1	Transfer process owner from Production (WI-PRO-ASY-116B) to Engineering (WI-ENG-PDE-311B). Change connector color in accordance with color standardization for plastic parts (Refer to GL-COM-003). Apply some improvements and update picture/illustration in all process.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
04/10/18	n/a	Previously established as Engineering instruction (EI-ENG-PDE-027). Initial issue	S. Manalo	R. Alcantara	A. Arañes	n/a

Prepared by	Reviewed by	Approved by	Noted by
M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
Est. Date:	April 10, 2018		

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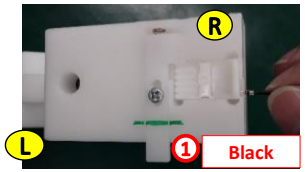
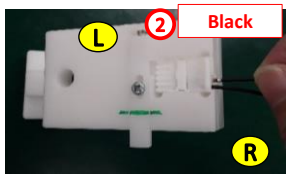
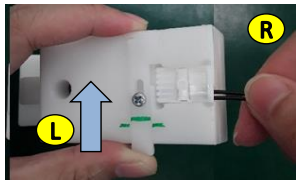
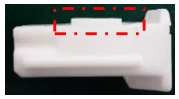
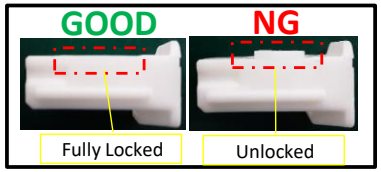
	Product Name/Code: 100B / 7M0592-7020B	Customer: TRJ		Document No.:	WI-ENG-PDE-311B	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 2 of 6

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	QUALITY POINTERS
2	P2	1 Wire insertion to connector 6098-3810 (W) 1	 WIRE FACING   1. Get the **1st Black wire** then insert to connector slot **1** using right hand. ***Note: insertion process must be from left to right.*** 2. Get the **2nd Black wire** then insert to connector slot **2** using right hand.  3. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.	n/a	***Note:** Please hold the wire near terminal during insertion.* 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing 1 ***Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.***
3		1 Connector lock	 Put the connector into locking jig using both thumb then press to lock **2x**. Check the connector lock if properly locked. ***Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.***  Before Pressing After Pressing 	LOCKING JIG 	***NOTE:*** ***MANUAL LOCKING MAY CAUSE DAMAGED LOCK.*** 1. Use the provided locking jig per model 2. No unlock/half-lock connector

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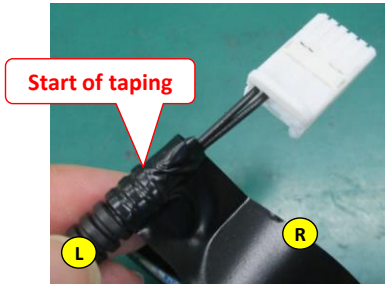
	Product Name/Code:	100B / 7M0592-7020B	Customer: TRJ	Document No.:	WI-ENG-PDE-311B	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.: 3 of 6

PARTS:	1. Assy parts 2. Black corrugated tube (no slit) ϕ5 L=85±3mm 3. Black tape	JIG	1. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	1 Wire insertion to Black corrugated tube (no slit) ϕ5 L=85±3mm	 1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the **B/B wires** using left hand. 2. Get the corrugated tube **(no slit) ϕ5 L=85±mm** using right hand then insert the **B/B wires** using left hand. 3. After insertion, remove the terminal cover jig using right hand.	TERMINAL COVER JIG 	1. No wrong usage of parts 2. No deformed terminal
5		1 Taping 1 Black corrugated tube to wire near connector	 1. Hold the corrugated tube using left hand then start taping using right hand.	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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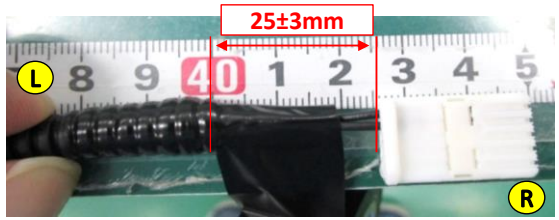
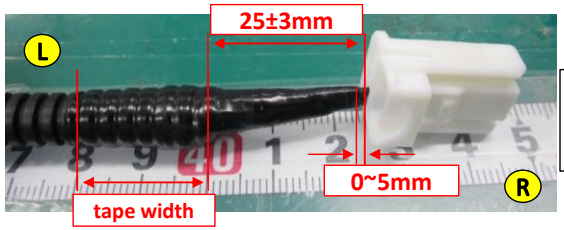
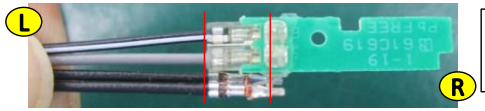
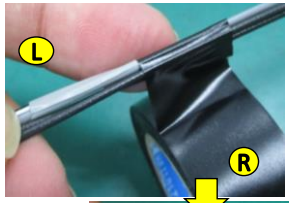
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.: 4 of 6

PARTS:	1. Assy parts 2. Black tape	JIG	n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2 1 Taping 1 Black corrugated tube to wire near connector (Continuation)	 2. Measure from end of the corrugated tube up to connector **25±3mm** then continue the taping process using both hands. ***Note: Refer to WI-PRO-ASY-001 for taping procedure***  3. After taping, check the measurement and taping condition.	MEASURING TAPE 	1 *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
6	1 Taping 2 Spot taping	 1. Fix the hotmelted wire and terminal pointed tip using both hands.  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 Green tape.*** 	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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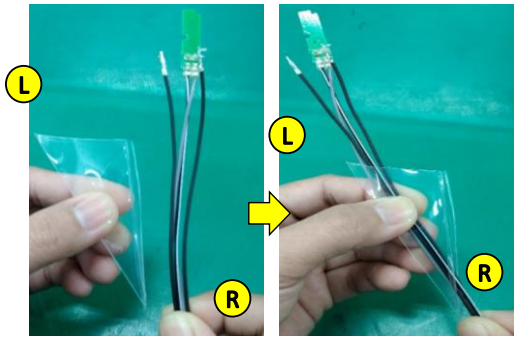
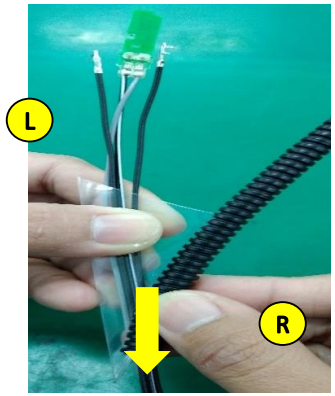
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 5 of 6

PARTS:	1. Assy parts 2. Black Corrugated tube (w/slit) ø5 L=411±3mm	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	1 P2	Wire insertion to Black Corrugated tube (w/slit) ø5 L=411±3mm	 1. Hold the COT adaptor using left hand then insert the wires using right hand.  2. Hold the COT adaptor with wires using left hand, get the **Black corrugated tube (w/slit) ø5 L=411±4mm** using right hand then insert to COT adaptor. Push the COT adaptor and pull down the COT ***(same timing)*** using both hands. Make sure all wires are inserted.	COT Adaptor 	1. No wrong use of parts 2. No wires left inside COT with slit

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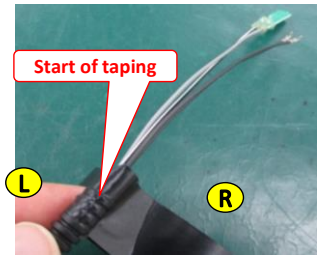
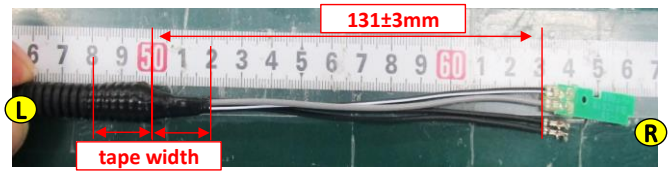
PARTS:	1. Assy parts 2. Black tape	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P2	1 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. ***Note: Refer to WI-PRO-ASY-001 for taping procedure***  3. After taping, check the measurement and taping condition.	MEASURING TAPE 	1 *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

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