



# WORK INSTRUCTION

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

Model Code/Part Number: **C11 / 7H0382W7020A** Customer: **NBS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

May 5, 2022

Validity Date:

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1

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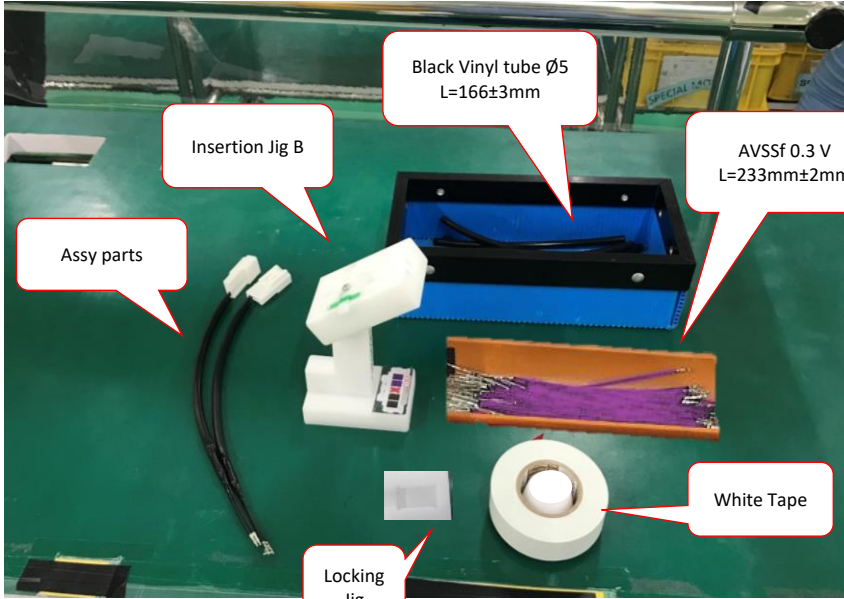
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## PARTS:





1. Assy parts; AVSSf 0.3 V L=233mm±2mm; Black Vinyl tube Ø5 L=166±3mm; White Tape

## JIG:

1. Insertion jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	Table Lay-out 	<b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)  <b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.  <b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	<b>Note: Refer to WI-PRO-CNC-017 for Wire and Strip length Tolerance.</b>  1. No missing parts/ tools. 2. No excess parts/tools.

## Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/5/22	1	Change Pre-launch to Masspro.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
04/19/22	0	Initial Issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	April 19, 2022		

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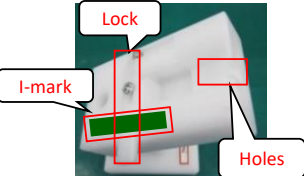
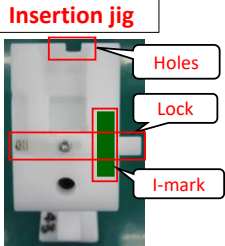
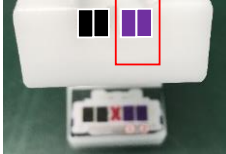
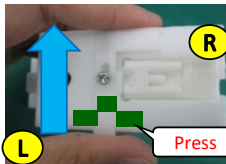
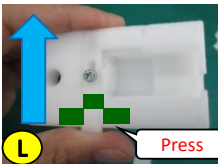
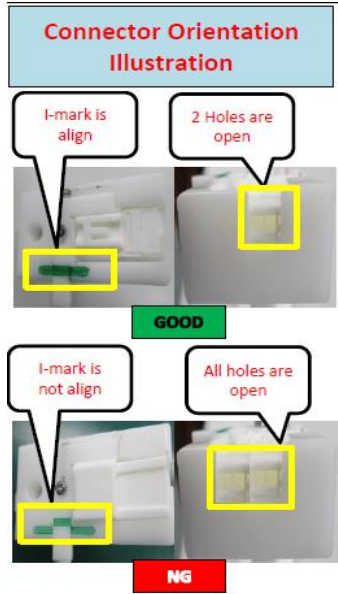
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a Connector Setting to Insertion jig 6098-3802 (W)	<div><p><b>CONNECTOR ORIENTATION</b></p><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the Connector <b>6098-3802 (W)</b> into jig using right hand and release the lock.</p><p>3. Check the holes/terminal slot for <b>2 Violet wires</b>.</p></div>		n/a	<div><p><b>Connector Orientation Illustration</b></p><p><b>GOOD</b></p><p>I-mark is align 2 Holes are open</p><p><b>NG</b></p><p>I-mark is not align All holes are open</p></div> <p>1. Use the provided jig per model 2. No wrong orientation of connector</p>

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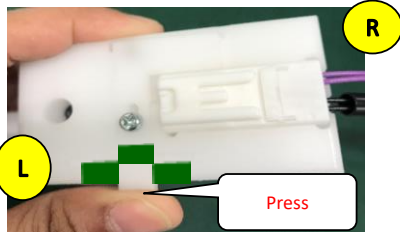
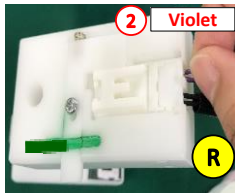

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PARTS:		1. Assy parts 2. AVSSf 0.3 V L=233mm±2mm [2pcs.]		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a  Wire insertion to connector 6098-3802 (W)	<div><div>Wire facing</div></div> <div><div>1. Get the <b>first violet wire</b> and insert to <b>location 1</b> using right hand. <i>Note: Conduct one by one insertion from left to right.</i></div><div>2. Get the <b>2nd Violet wire</b> and insert to <b>location 2</b> using right hand.</div><div>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.</div></div> <div>n/a</div> <td><div>Note: Refer to WI-PRO-CNC-017 for Wire and Strip length Tolerance</div><div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</div><div>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</div><div>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div></td>		<div>Note: Refer to WI-PRO-CNC-017 for Wire and Strip length Tolerance</div> <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</div> <div>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</div> <div>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>	

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**PARTS:**

1. Assy parts
2. Black Vinyl tube Ø5 L=166±3mm

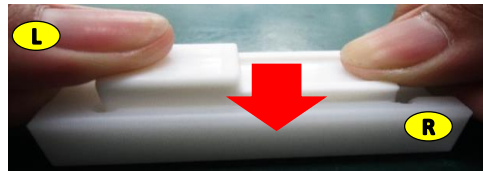
**JIG**

1. Locking Jig

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

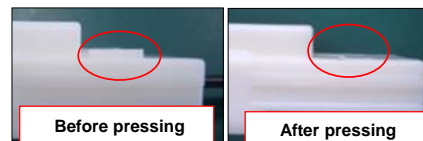
4

Connector lock



1. Put the connector into locking jig both hands then press **2x** to lock using both hands. Touch the connector lock to confirm if properly locked.

*Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.*

**GOOD****NG****LOCKING JIG**

**NOTE:**  
**MANUAL LOCKING MAY CAUSE DAMAGED LOCK.**

1. Use the provided locking jig per model
2. No unlock/half-lock connector

5

Wire insertion to  
Black Vinyl tube Ø5  
L=166±3mm

1. Get the Black Vinyl tube **Ø5 L=166±3mm** using right hand then insert the **V-V wires** using left hand.

n/a

1. No wrong usage of parts
2. No deformed terminal tip

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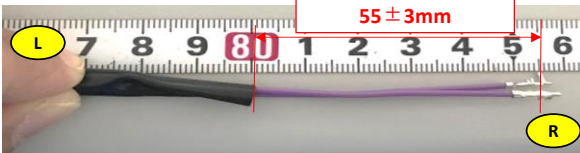
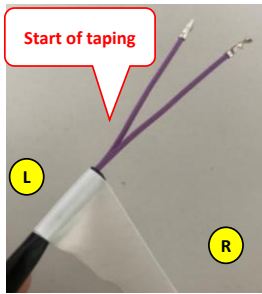
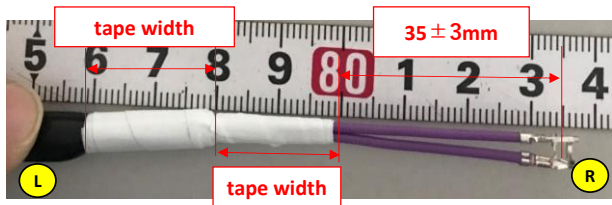

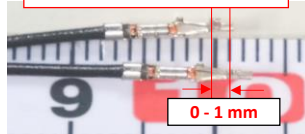
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PARTS:		1. Assy parts 2. White tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	n/a  Taping 2 Black Vinyl tube to wire near terminal	 <p>55 ± 3mm</p> <p>1. Measure from end of Vinyl tube up to terminal pointed tip <b>55±3mm</b> then continue the taping process using both hands.</p>  <p>Start of taping</p> <p>2. Get the <b>White Tape</b> 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>tape width</p> <p>35 ± 3mm</p> <p>tape width</p> <p>4. After taping, check the measurement, terminal appearance and taping condition.</p>	 <p>MEASURING TAPE</p>	<p>Note: <b>USE WHITE TAPE ONLY.</b></p> <p><b>Note:</b> 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>

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<b>PARTS:</b>	n/a			<b>JIG</b>	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	Visual/By Two's Inspection	<div>1. Check the connector lock</div> <div>2. Check the taping condition, clamp attachment and alignment.</div> <div>3. Check the terminal appearance, make sure no deformed terminal.</div> <div>4. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></div> 			<b>MASTER SAMPLE</b>
8	Measurement	<div><b>MEASURING TAPE</b></div> <div><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></div> 			<div><b>NOTE: FOR HATSUMONO AND OWARIMONO</b></div> 1. No wrong dimension

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