







Revision History							Prepared by	Reviewed by	Approved by	Noted by
05/21/21	3	Revise due to standardize the color of connector in accordance with color standardization of plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts). Removal of GOOD and NG illustration of cover jig. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
10/20/20	2	Transfer process owner from Production (WI-PRO-ASY-120A) to Engineering (WI-ENG-PDE-180A). Change connector locking process from locking jig to sequential manual locking.	M. Catapang	R. Peñañoza	A. Shimamura	A. Arañes				
05/02/18	0	Previously established as Engineering instruction (EI-ENG-PDE-034). Initial issue.	D. Castillo	R. Alcantara	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change		Revised	Checked	Approved	Noted	Est. Date:	May 02, 2018	

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 21, 2021

Process Name/Title:

Product Name/Code: 100B / 7M0595-7020B

Customer: TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-180A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

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PARTS:

n/a

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

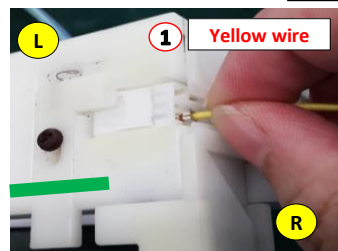
TOOLS/PPE

QUALITY POINTERS

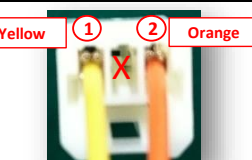
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P1

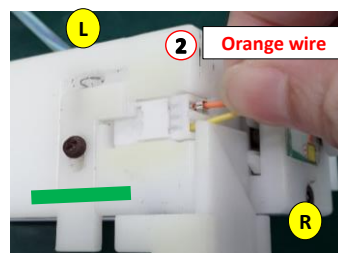
Wire insertion to
connector
6098-2220 (W)



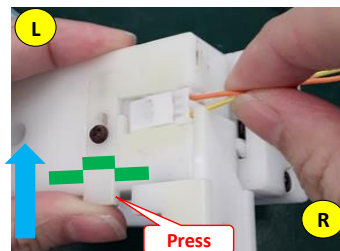
1. Hold the insertion jig using left hand.
Get the **Y wire** and insert to connector
using right hand.



2. Press the button using right thumb the
slot for **OR wire** will be opened.



3. Get the **OR wire** and insert to
connector using right hand.



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

n/a

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

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

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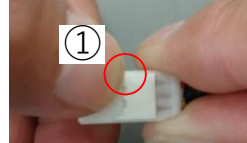
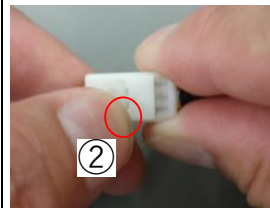
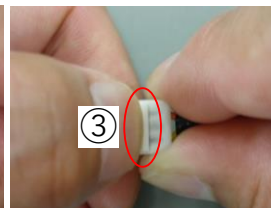
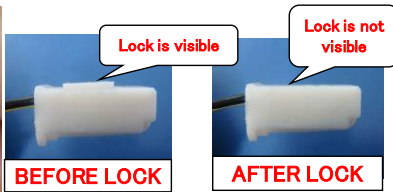
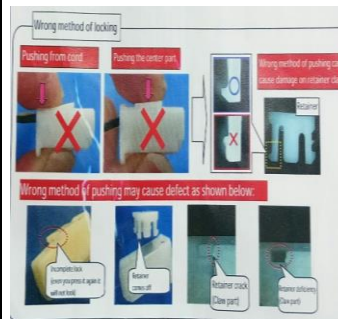

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PARTS:		1. Black corrugated tube (no slit) $\Phi 5$ L=249±3mm		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	<div>3</div> <div>P1</div> <div>Connector lock</div>	<div><div><div>Sequence of Pressing the Double Lock: ① - ② - ③ Method: Press one by one using one thumb</div><div></div></div><div><div><p>1. Hold the 6098-2220 connector using right hand</p></div><div><div><p>2. Press location 1 of the connector lock using your left thumb</p></div><div><div><p>3. Press location 2 of the connector lock using your left thumb</p></div><div><div><p>4. Press location 3 of connector near terminal insertion side with your left thumb</p></div><div><div><p>5. Check the locking condition</p></div></div></div></div></div></div></div>		n/a	<div><div>Wrong Locking Method</div><div></div><div>1. No unlocked/half-locked connector 2. No one time pressing of double lock 3. Make sure not to hit the portion ③ (bottom side) when pressing ① & ②</div></div>
4	Wire insertion to Black corrugated tube (no slit) $\Phi 5$ L=249±3mm	<div><div><div>L</div><div>R</div></div><div>1. Get the corrugated tube $\phi 5$ L= 249±3mm using right hand then insert the Y-OR wire by using left hand.</div></div>		n/a	1. No wrong use of parts

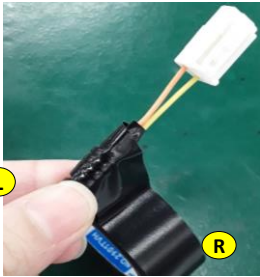
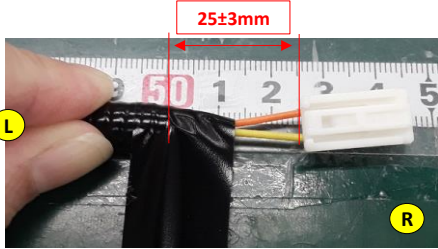
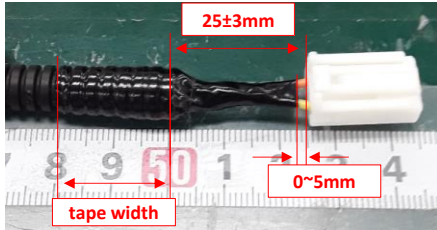



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	Product Name/Code: 100B / 7M0595-7020B	Customer: TRJ	Document No.:	WI-ENG-PDE-180A	
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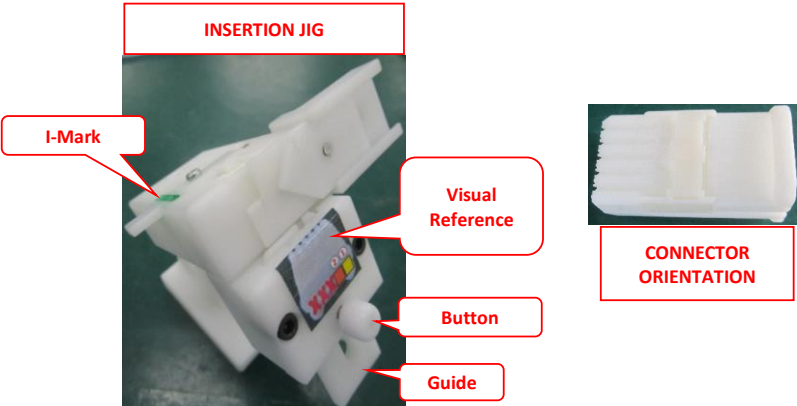
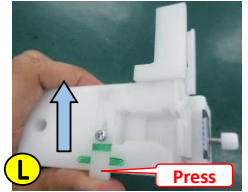
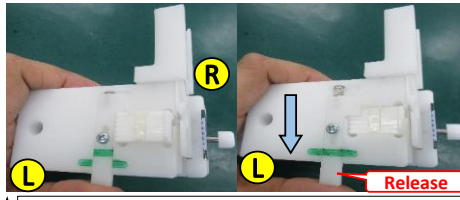
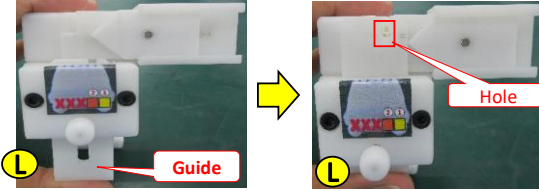
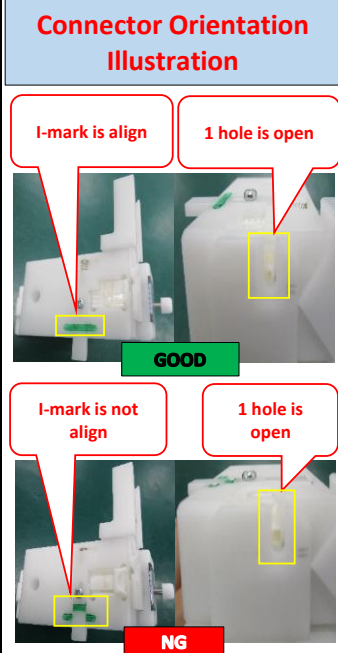
PARTS:	1. Black tape 2. Black Corrugated tube (no slit) $\phi 7$ L=177 \pm 3mm 2. Black Corrugated tube (no slit) $\phi 7$ L=94 \pm 3mm	JIG	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 Taping 1 Black corrugated tube to wire near Connector	 <p>1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping.</p>  <p>2. Measure from COT to Connector 25\pm3mm using both hands and continue the taping process. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>3. After taping, check the measurement and taping condition.</p>		<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <ul style="list-style-type: none"> 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
6	Wire insertion to Black corrugated tube (no slit) $\phi 7$ L=177 \pm 3mm $\phi 7$ L=94 \pm 3mm	 <p>1. Get the corrugated tube $\phi 7$ L=177\pm3mm using right hand then insert the Y-OR wire using left hand.</p>  <p>2. Get the corrugated tube $\phi 7$ L=94\pm3mm using right hand then insert the Y-OR wire using left hand.</p>	n/a	<ul style="list-style-type: none"> 1. No wrong use of parts 2. No deformed terminal


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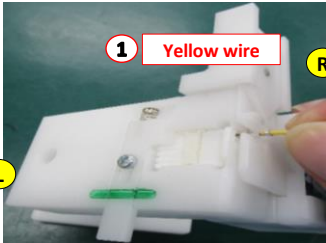
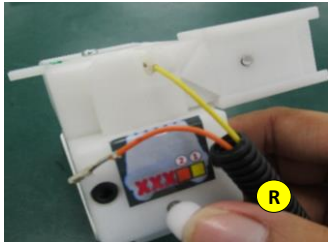
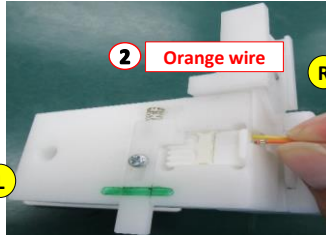
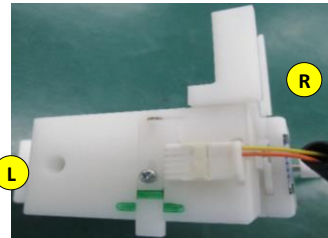
PARTS: 1 Connector 6098-3810 (W)		JIG 1. Insertion jig	
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 Connector setting to insertion jig 6098-3810 (W)	<div style="text-align: center;">  </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>1. Press the lock of insertion jig using left thumb.</p> </div> <div style="text-align: center;">  <p>2. Insert the connector 6098-3810 (W) into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></p> </div> </div> <div style="text-align: center;">  <p>3. Push the guide using left hand. The slot for Y wire will be opened.</p> </div>	n/a	<div style="text-align: center;">  </div> <p>Connector Orientation Illustration</p> <p>GOOD</p> <ul style="list-style-type: none"> I-mark is align 1 hole is open <p>NG</p> <ul style="list-style-type: none"> I-mark is not align 1 hole is open


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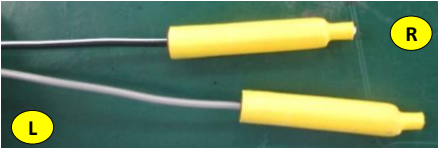

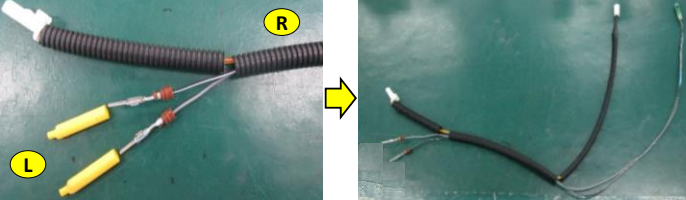

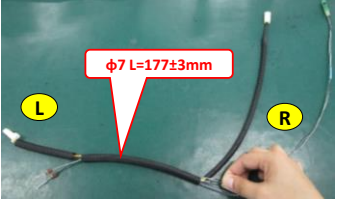
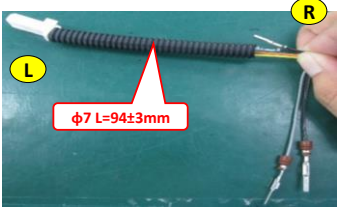
PARTS:	1. Assy parts		JIG	1. Insertion jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1 Wire insertion to connector 6098-3810 (W)	<div style="text-align: center;">  <p>WIRE FACING</p> </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>1 Yellow wire</p> <p>1. Hold the insertion jig using left hand. Get the Y wire and insert to open slot of connector using right hand.</p> </div> <div style="text-align: center;">  <p>2</p> <p>2. Press the button using right thumb the slot for OR wire will be opened.</p> </div> </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>2 Orange wire</p> <p>3. Get the OR wire and insert to open slot of connector using right hand.</p> </div> <div style="text-align: center;">  <p>4</p> <p>4. 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> </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> <div style="border: 1px solid red; padding: 5px; margin-top: 10px;"> <p>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> </div>


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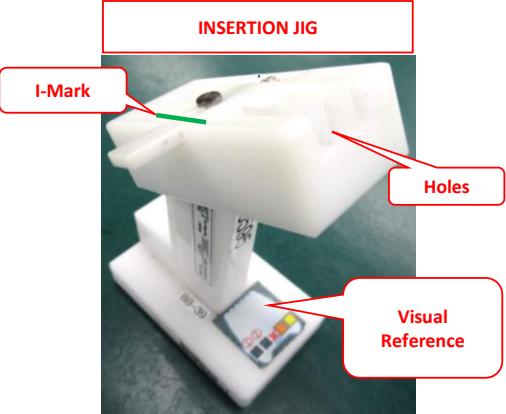

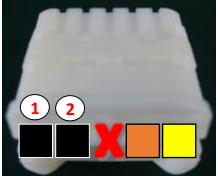
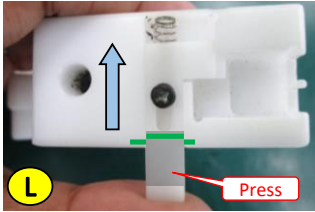
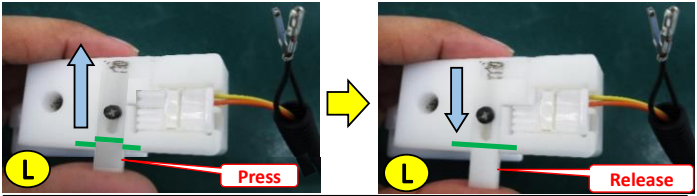
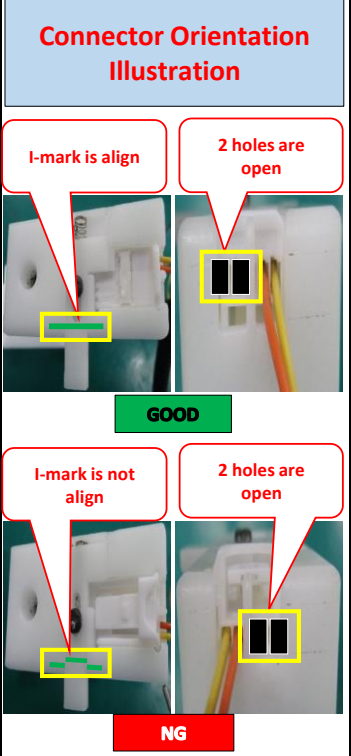
PARTS:	1. Assy parts 2. MRSW CP 7M0595-7040 GR-B/W wires L=813±3mm 3. AVSSf 0.3 B/B wires L=673±3mm [2pcs.]	JIG	1. Terminal cover jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1 Wire insertion to assy parts	 <p>1. Get the terminal cover jig using right hand then insert to both terminals (GR-B/W wires) using right hand.</p>  <p>2. Hold the COT φ7 L=177±3mm using left hand then insert the GR-B/W wires using right hand.</p>  <p>3. After insertion, remove the cover jig using left hand.</p>		1. No wrong usage of parts 2. No damaged rubber seal
10	Wire insertion to assy parts	 <p>1. Get the B wires L=673±3mm [2pcs.] using right hand and then insert to COT φ7 L=177±3mm.</p>  <p>2. Continue insertion of B/B wires to COT φ7 L=94±3mm using right hand.</p>	n/a	1. No wrong use of parts 2. No deformed terminal


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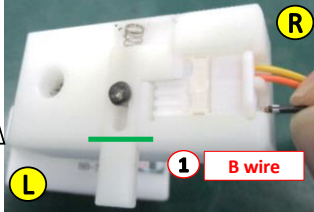
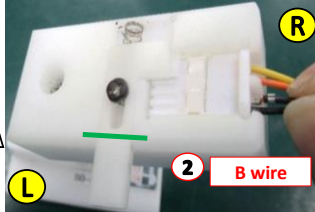
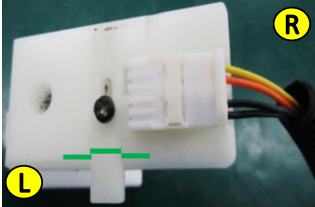
PARTS:	1. Assy parts			JIG	1. Insertion jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
11	P1 Connector setting to insertion jig (assy parts) 3 6098-3810 (W)	<div>    </div> <div>  <p>1. Press the lock of insertion jig using left thumb.</p> </div> <div>  <p>2. Insert the connector 6098-3810 (W) with inserted Y-OR wires into jig using right hand and release the lock. Holes/terminal slot for B/B wires are opened.</p> </div>	n/a	<div>  <p>GOOD</p> <p>NG</p> </div> <ol style="list-style-type: none"> 1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector 	


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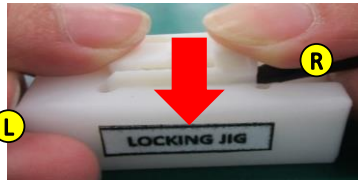
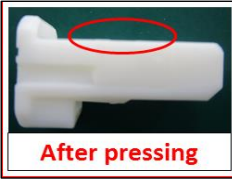
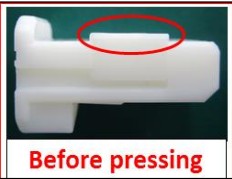

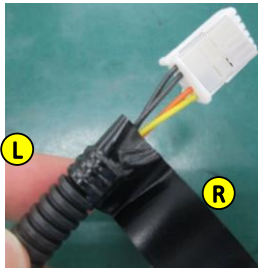
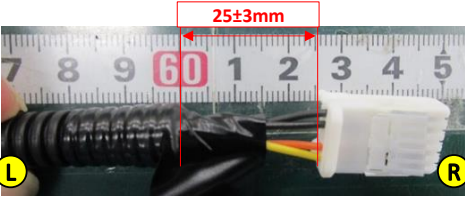
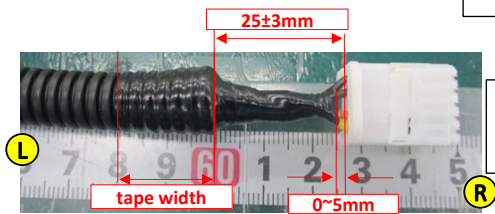

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PARTS:		1. Assy parts			JIG		1. Insertion jig	
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	P1 Wire insertion to connector (assy parts) 3 6098-3810 (W)	<div style="text-align: center;">  <p>WIRE FACING</p> </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>1. Hold the insertion jig using left hand. Get the 1st B wire and insert to connector using right hand. <i>Note: Insertion of wire must be from left to right.</i></p> </div> <div style="text-align: center;">  <p>2. Hold the 2nd B wire and insert to connector using right hand.</p> </div> </div> <div style="text-align: center; margin-top: 20px;">  <p>3. 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.</p> </div>	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing <div style="border: 1px solid red; padding: 5px; margin-top: 10px;"> Note: Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. </div>

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	WORK INSTRUCTION				Effectivity Date:		May 21, 2021	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Product Name/Code: 100B / 7M0595-7020B		Customer: TRJ		Document No.:		WI-ENG-PDE-180A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		3	Page No.:	10 of 10	

PARTS:	1. Assy parts 2. Black tape				JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
13	Connector lock	<div>  <p>1. Put the connector into locking jig using both hands then press 2x using both hands. Touch the connector lock to confirm if properly locked. <i>Refer to GL-PRO-ASY-017 for the verification of lock.</i></p> </div> <div>   </div>			<div> LOCKING JIG  </div>	<div> NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK. </div> <div> 1. Use the provided jog per model 2. No unlocked/half-locked connector </div>
14	P1 Taping 2 Black corrugated tube to wire near Connector	<div>  <p>1. Hold the assy parts using left hand. Get the Black tape using right hand and start pre-taping.</p> </div> <div>  <p>2. Measure from COT to Connector 25±3mm using both hands and continue the taping process. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p> </div> <div>  <p>3. After taping, check the measurement and taping condition.</p> </div>			<div> MEASURING TAPE  </div>	<div> Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i> </div> <div> 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 </div>

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