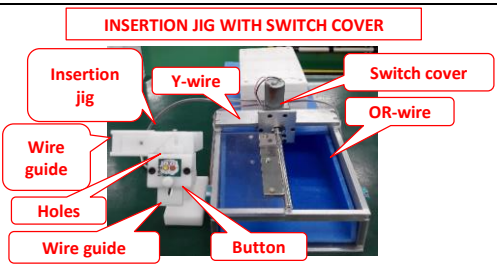
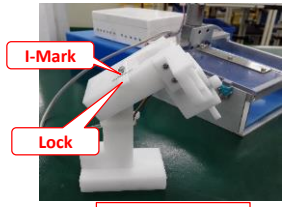
NBC	WORK INSTRUCTION		Effectivity Date:	August 2, 2021
	Process Name/Title:	TAPING ASSEMBLY PROCESS	Validity Date:	n/a
	Product Name/Code: 100B / 7M0592-7020B	Customer: TRJ	Document No.:	WI-ENG-PDE-311A
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	2 — Page No.: 1 of 10

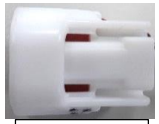
PARTS:	1. Connector 6189-0451 (W)	JIG:	1. Insertion jig with switch cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 △2 Connector setting to insertion jig △2 6189-0451 (W)			

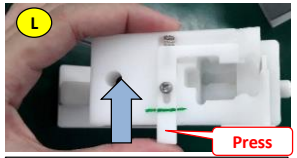




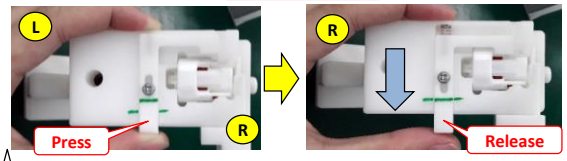
INSERTION JIG ORIENTATION



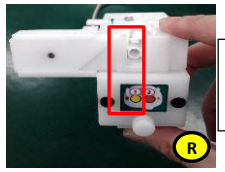
CONNECTOR ORIENTATION



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



△2 2. Insert the connector **6189-0451 (W)** into jig using right hand then release the lock using left thumb.
Note: Follow the connector orientation.



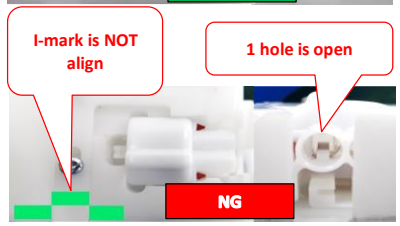
3. Push the guide using right thumb. The slot for **Yellow wire** will be opened.

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	2	Transfer process owner from Production (WI-PRO-ASY-116A) to Engineering (WI-ENG-PDE-311A). 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
07/18/19	1	Include insertion jig	J. Silang	W. Carbillon	O. Merin	
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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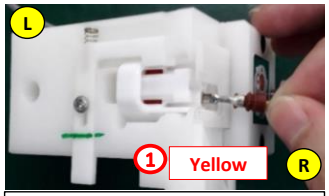
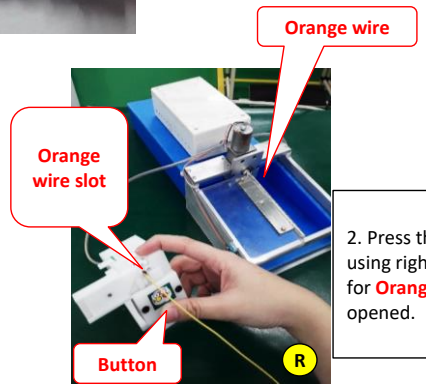
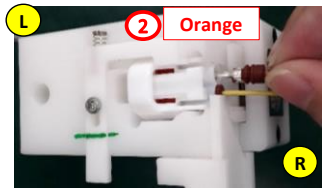
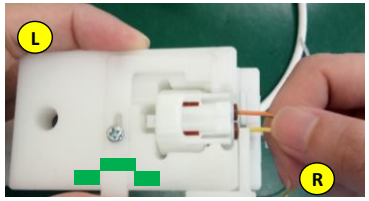
PARTS:	1. AVSSf 0.3 Y/OR wire L=245±2mm	**JIG**	1. Insertion jig with switch cover

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	2 Wire insertion to connector 2 6189-0451 (W)	  1. Hold the insertion jig using left hand, get **Yellow wire** and insert to connector slot **1** using right hand.  2. Press the button using right thumb, slot for **Orange wire** will be opened.  3. Hold the insertion jig using left hand, get **Orange wire** and insert to connector slot **2** 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	2 ***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 2 ***Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.***

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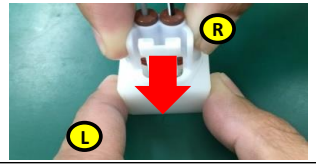
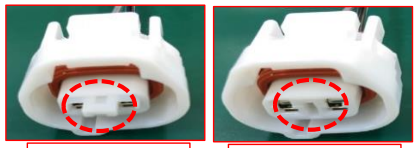
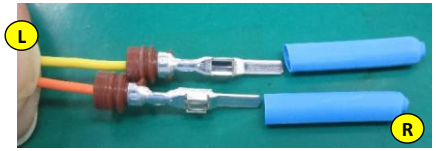
	WORK INSTRUCTION			Effectivity Date:	August 2, 2021	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Product Name/Code:	100B / 7M0592-7020B	Customer: TRJ	Document No.:	WI-ENG-PDE-311A	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	2	Page No.: 3 of 10

PARTS:	2	1. Assy parts 2. Black corrugated tube (no slit) Ø7 L=32±3mm 3. Black corrugated tube (no slit) Ø7 L=125±3mm	JIG	1. Locking jig 2. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	2 Connector lock	 1. Put the connector into locking jig using right hand then press **2x.** Touch the connector lock if properly locked.  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
4	P1	2 Wire insertion to Black corrugated tube (no slit) Ø7 L=32±3mm Ø7 L=125±3mm	 1. Get the cover jig then insert to **Y-OR wires** using right hand. 2. Get the corrugated tube (no slit) **Ø7 L=32±3mm** using right hand then insert the **Y-OR wires** using left hand. 2. Get the corrugated tube (no slit) **Ø7 L=125±3mm** using right hand then insert the **Y-OR wires** using left hand.  3. After insertion, remove the cover jig using right hand.	TERMINAL COVER JIG 	1. No wrong usage of parts 2. No damaged rubber seal

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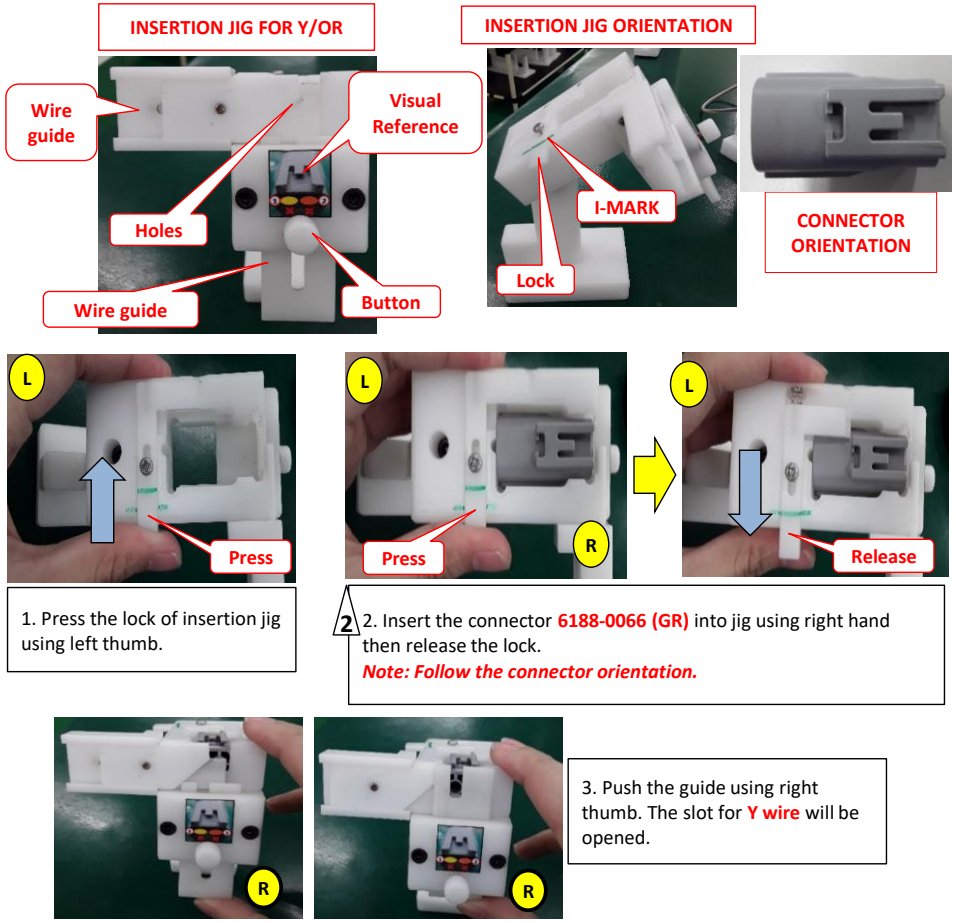
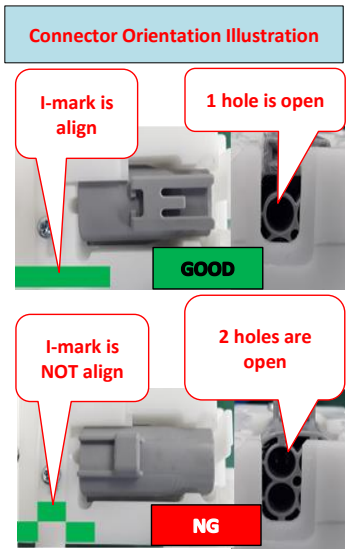
	WORK INSTRUCTION			Effectivity Date:	August 2, 2021	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Product Name/Code: 100B / 7M0592-7020B	Customer: TRJ		Document No.:	WI-ENG-PDE-311A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 4 of 10

PARTS:	1. Connector 6188-0066 (GR)	JIG	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	2 Connector setting to insertion jig 6188-0066 (GR) 2	 1. Press the lock of insertion jig using left thumb. 2 2. Insert the connector **6188-0066 (GR)** into jig using right hand then release the lock. ***Note: Follow the connector orientation.*** 3. Push the guide using right thumb. The slot for **Y wire** will be opened.	n/a	 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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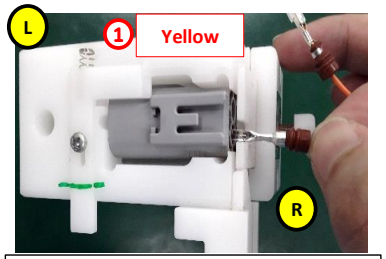
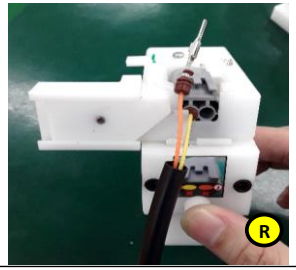
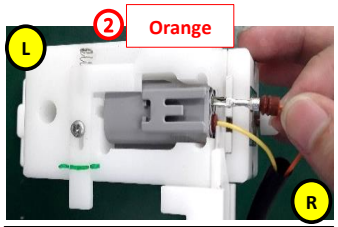
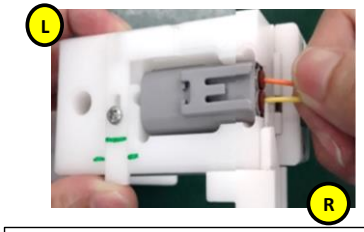
	WORK INSTRUCTION			Effectivity Date:	August 2, 2021	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Product Name/Code:	100B / 7M0592-7020B	Customer: TRJ	Document No.:	WI-ENG-PDE-311A	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	2	Page No.: 5 of 10

PARTS:	1. Assy parts	JIG	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1	2 Wire insertion to connector 6188-0066 (GR) 2	WIRE FACING  1. Hold the insertion jig using left hand. Get the assy parts, insert the **Yellow wire** to connector slot **1** using right hand.  2. Press the button using right thumb, slot for **Orange wire** will be opened.  3. Get **Orange wire** then insert to connector slot **2** 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	2 ***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 2 ***Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.***

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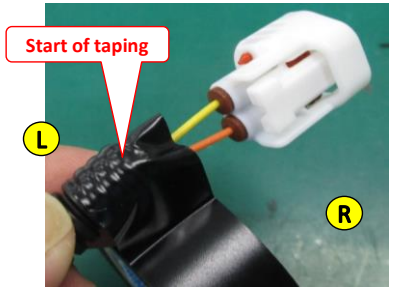
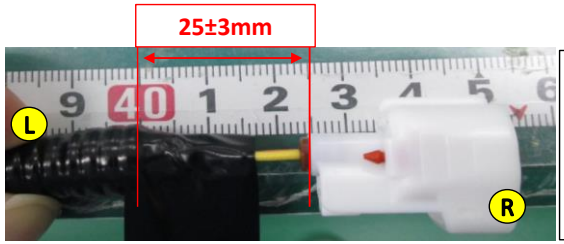
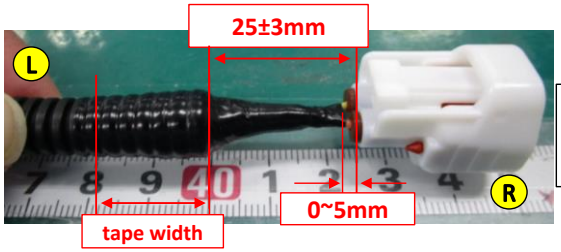
PARTS:	2 1. Assy parts 2. Black tape	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1	2 Taping 1 Black corrugated tube (no slit) to wire near connector	 1. Hold the corrugated tube using left hand then start taping using right hand.  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 	2 *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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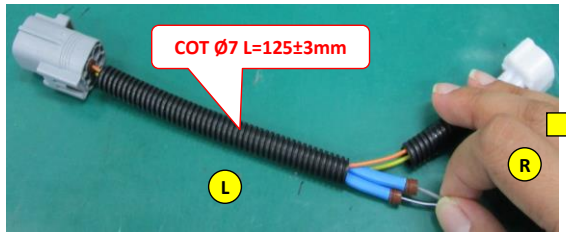
PARTS:	2 1. MRSW CP 7M0365-K050 GR-B/W wires L=830±3mm 2. Assy parts	JIG	1. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1	2 Wire insertion to Black corrugated tube (no slit) Ø7 L=111±3mm	1. Get the cover jig then insert to **GR-B/W wires** using right hand. 2. Get the corrugated tube (no slit) **Ø7 L=111±3mm** using right hand then insert the **GR-B/W wires** using left hand.		
9		2 Wire insertion to assy parts	 1. Hold the corrugated tube (no slit) **Ø7 L=125±3mm** using left hand then insert **GR-B/W wires** using right hand. 2. After insertion, remove the cover jig using right hand.	TERMINAL COVER JIG	1. No wrong usage of parts 2. No damaged rubber seal

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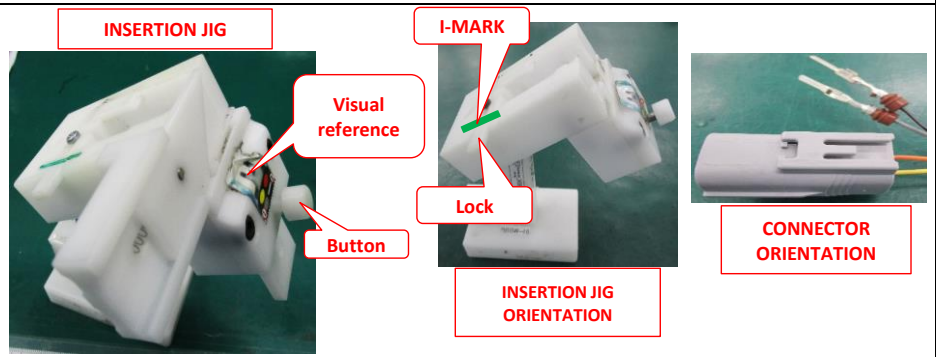
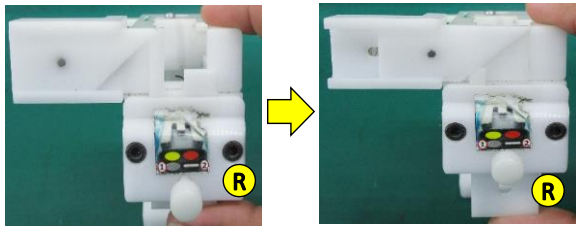
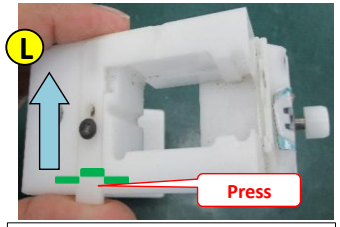
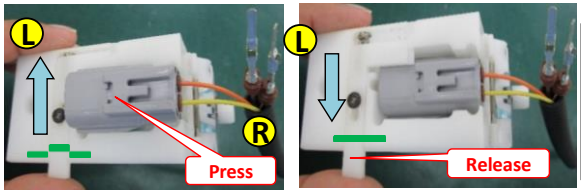
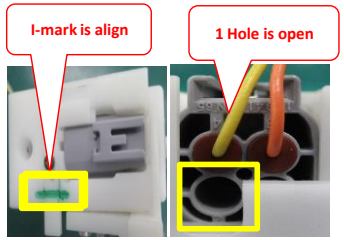
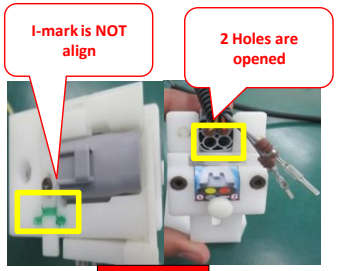
	Product Name/Code:	100B / 7M0592-7020B	Customer: TRJ	Document No.:	WI-ENG-PDE-311A	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	2	Page No.: 8 of 10

PARTS:	1. Assy parts	JIG	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1	2 Connector setting to insertion jig 2 6188-0066 (GR) (Assy parts)	  1. Press the guide using left thumb. The slot for **GR wire** will be opened.  2. Press the lock of insertion jig using left thumb.  3. Insert the connector **6188-0066 (GR)** with inserted **Y/OR wire** using right hand. ***Note: Follow the connector orientation.*** 2	n/a	**Connector Orientation Illustration**  GOOD  NG 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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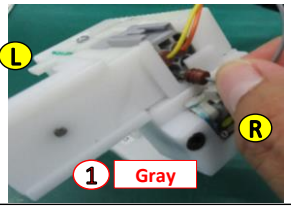
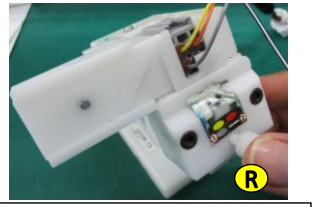
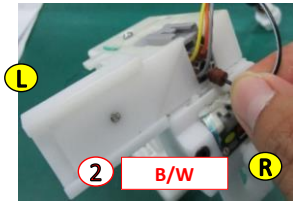
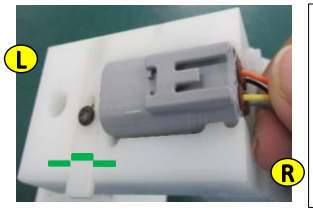
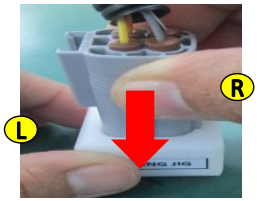
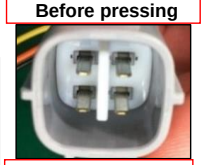
PARTS:	1. Assy parts	JIG	1. Insertion jig 2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1 2 Wire insertion to connector 2 6188-0066 (GR) (Assy parts)	 1 Hold the **GR wire** then insert to terminal slot **1** using right hand. WIRE FACING  2. Press the button using right thumb. The slot for **B/W wire** will be opened.  3. Hold the **B/W wire** then insert to terminal slot **2** using right hand.  4. 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	2 ***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 2 ***Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.***
12	2 Connector Lock	 1. Put the connector into locking jig using both hands and then press **2x.** Check the connector if properly locked. Before pressing  After pressing **Coupler Cross Sectional View** NG NG GOOD Unlock / Half Lock Condition / Full Lock Condition	LOCKING JIG 	***NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK*** 1. Use the provided locking jig per model 2. No unlock/half-locked connector

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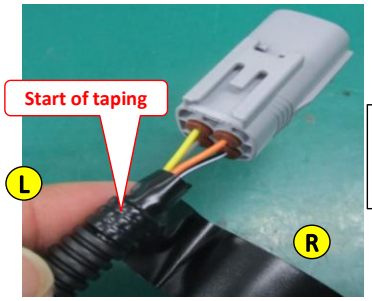
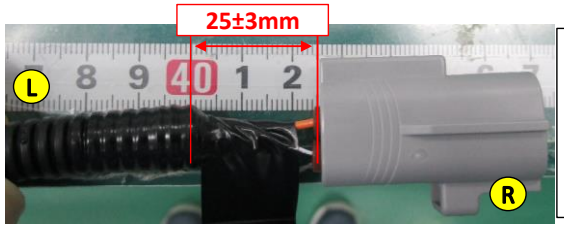
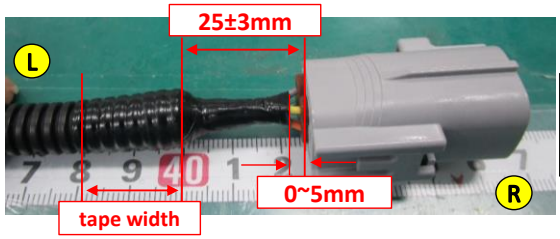
	WORK INSTRUCTION			Effectivity Date:	August 2, 2021	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Product Name/Code:	100B / 7M0592-7020B	Customer: TRJ	Document No.:	WI-ENG-PDE-311A	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	2	Page No.: 10 of 10

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
13	P1	2 Taping 2 Black corrugated tube (no slit) to wire near connector	 1. Hold the corrugated tube using left hand then start taping using right hand.  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** 	2 *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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