



WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:

March 13, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number: 920B / 7R0122-7021

Customer:

TRMX

Document No.:

WI-ENG-PDE-644A

Purpose:

☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Revision No.:

0

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PARTS:		1. Connector 6098-3909 (W)				JIG:	1. Insertion jig								
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS					
1		P1		Connector setting to insertion jig 6098-3909 (W)				<div><div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>		<div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div><div>I-mark is not align</div><div>2 hole is open</div><div>NG</div></div></div><div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div></div>					
Revision History															
						Prepared by		Reviewed by		Approved by		Noted by			
03/13/23		0		Initial issue.				D. Castillo		J. Loterte		C. Villanueva		A. Arañes	
Eff. Date		Rev. No		Details of Change				Revised		Reviewed		Approved		Noted	

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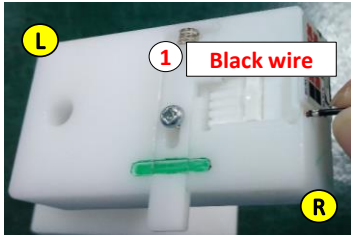

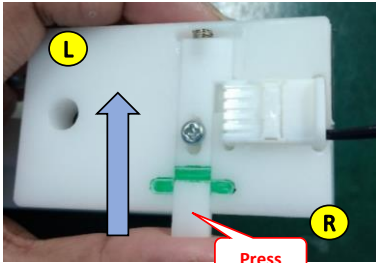
Page No.:

2 of 15**PARTS:**

1. AVSSf 0.3 wires B-B L=572±3mm

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Wire insertion to connector 6098-3909 (W)	<div>Wire facing</div> <div>1 Black wire</div> <div>2 Black wire</div> <div>Press</div> <div>1. Get 1st black wire then insert to terminal slot ① using right hand. Note: Insertion of wires must be from up to down direction.</div> <div>2. Get 2nd Black wire then insert to terminal slot ② 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>	n/a	<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>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>

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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div><div><div>Insertion jig</div><div>Side wire guide</div><div>Visual reference</div><div>Lower wire guide</div><div>Push button</div><div>Hole</div></div><div><div>I-mark</div><div>Insertion jig Orientation</div></div><div><div>Connector lock</div><div>Connector Orientation</div></div><div><div>1. Push the lower wire guide using right hand, the slot for Yellow wire will be opened.</div><div>2. Press the lock of insertion jig using left thumb.</div><div>3. Insert the connector 6098-3909 (W) with inserted B-B wire into jig using right hand and release the lock.</div></div></div>		n/a	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Follow the connector orientation2. Cannot insert the inverted connector. <ol style="list-style-type: none">1. Use provided jig per model2. No wrong usage of parts3. No wrong orientation of connector4. No damaged connector

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

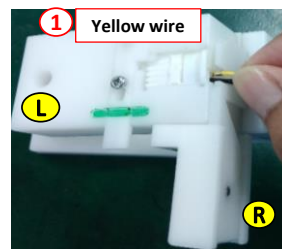
QUALITY POINTERS

4

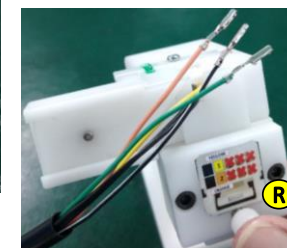
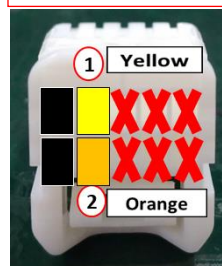
P1

Wire insertion to Connector
6098-3909 (W)

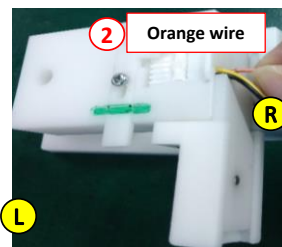
VISUAL REFERENCE



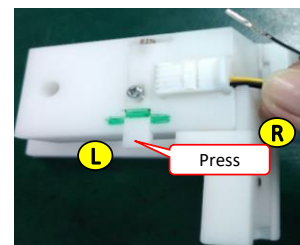
1. Get the **Yellow wire** using right hand then insert to terminal **slot 1** using right hand.



2. Press the button using left hand, the slot for **Orange wire** will be opened.



3. Get the **Orange wire** using right hand then insert to terminal **slot 2** using right hand.



4. After insertion, press the lock guide 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

Important reminders/Note/s:

1. Please hold the wire near terminal.
 2. Make sure wires are properly inserted.
- Conduct Pull-Push-Pull-Push after insertion.
Do not exert extra force.

Document references:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

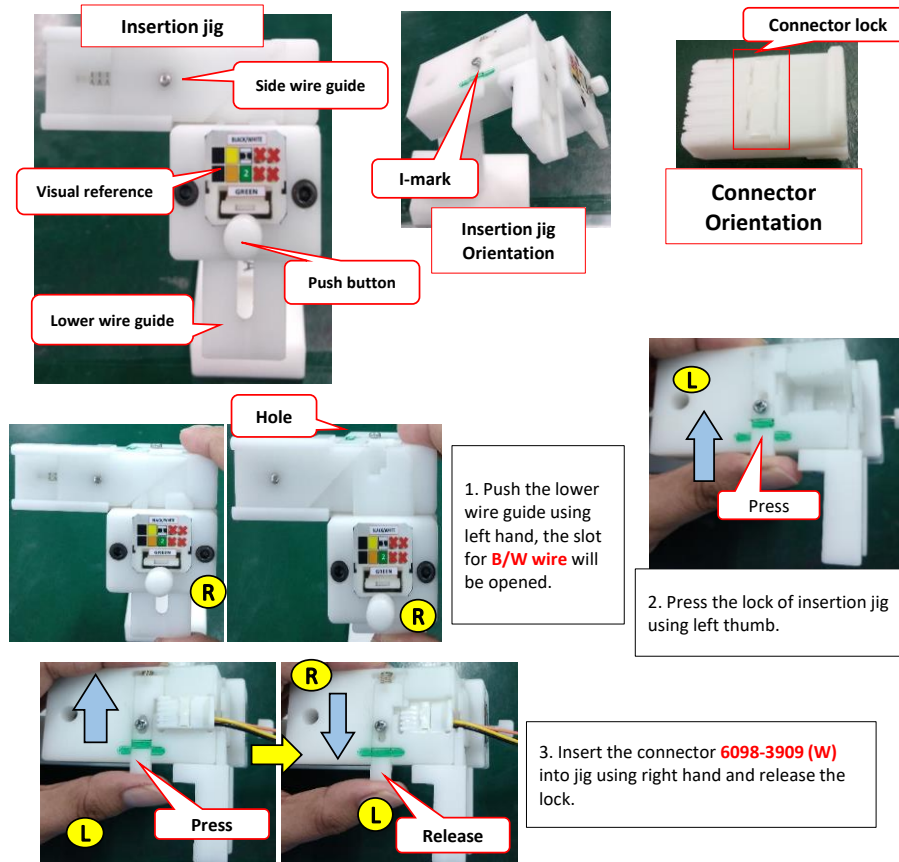
TOOLS/PPE

QUALITY POINTERS

5

P1

Connector setting to
insertion jig
6098-3909 (W)



n/a

Important reminders/Note/s:
1. Follow the connector orientation
2. Cannot insert the inverted connector.

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

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

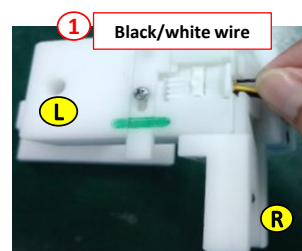
QUALITY POINTERS

6

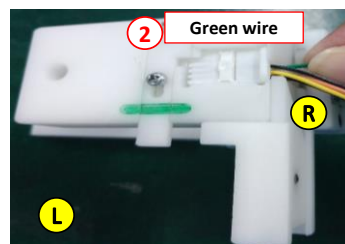
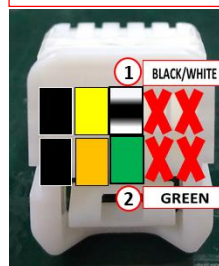
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Wire insertion to Connector
6098-3909 (W)

VISUAL REFERENCE



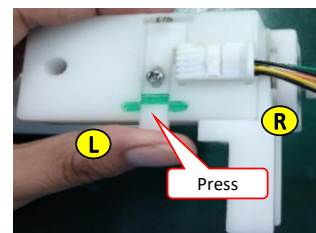
1. Get the **Black/white wire** using right hand then insert to terminal **slot 1** using right hand.



3. Get the **Green wire** using right hand then insert to terminal **slot 2** using right hand.



2. Press the button using left hand, the slot for **Green wire** will be opened.



4. After insertion, press the lock guide 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

Important reminders/Note/s:

1. Please hold the wire near terminal.
 2. Make sure wires are properly inserted.
- Conduct Pull-Push-Pull-Push after insertion.
Do not exert extra force.

Document references:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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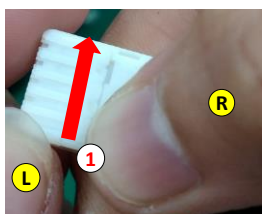



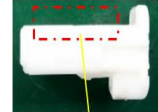
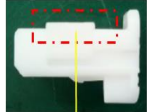


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PARTS:

1. Assy parts
2. Black SV tube (Vinyl) Ø7 L=314±3mm

JIG

1. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	Connector Lock	<div></div> <div><p>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</p><p><i>Note: WI-PRO-KIT-001 Proper locking and checking of connector lock</i></p></div>	<div></div> <div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div> <div></div> <div></div>	<div><p>LOCKING JIG</p></div> <div></div>	<p><i>Important reminders/Note/s:</i></p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided locking jig per model</p> <p>2. No unlock/half-locked connector</p> <div><p>CONNECTOR LOCK CONDITION</p><div><div><p>Fully Locked</p></div><div><p>UnLocked</p></div></div></div>
8		Wire insertion to Black SV tube (Vinyl) Ø7 L=314±3mm	<div></div> <div></div> <div><p>1. Get the Black SV tube (Viny) Ø7 L=314±3mm using right hand then insert the all wires using left hand.</p></div>	n/a	<p>1. No wrong use of parts</p> <p>2. No deformed terminal</p>	

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PARTS:

1. Connector 7188-0996 (W)

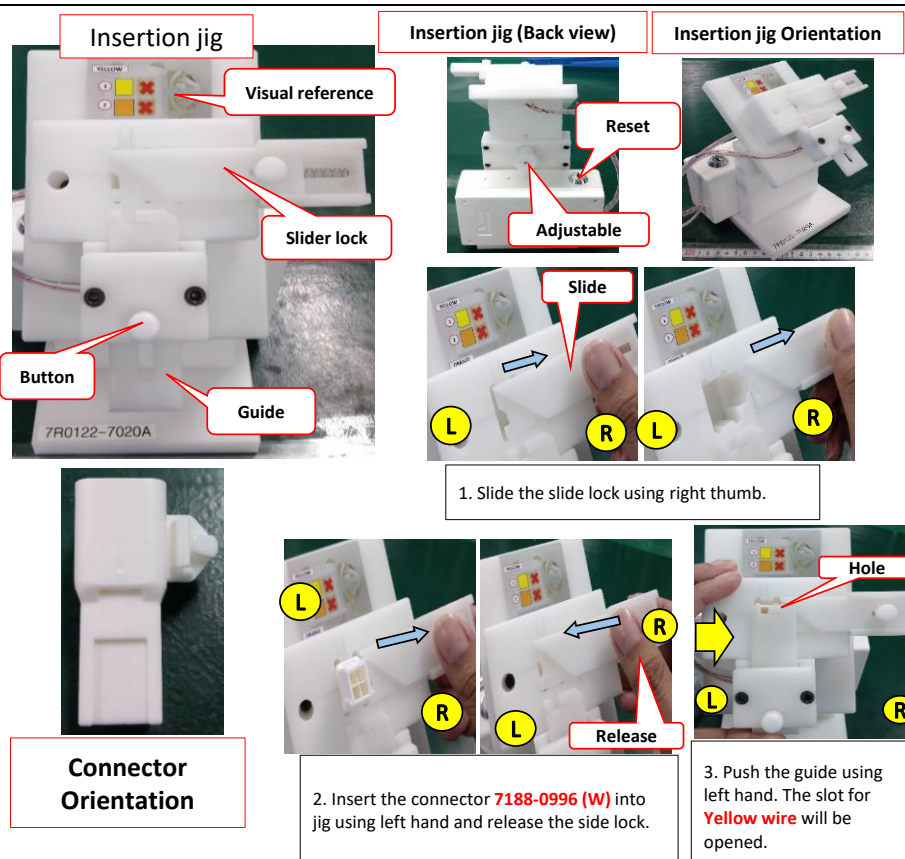
JIG

1. Insertion jig

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

9

P1

Connector setting to
insertion jig
7188-0996 (W)

n/a

Important reminders/Note/s:**1. Cannot insert the inverted connector.**

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

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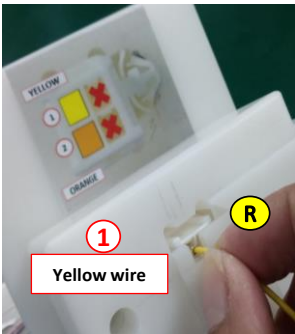
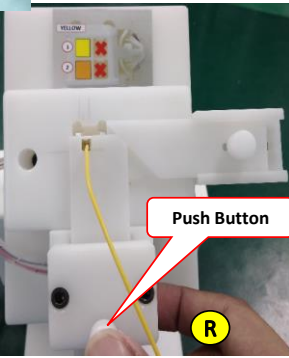
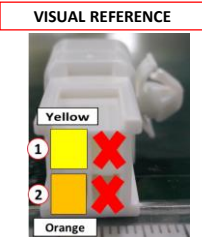
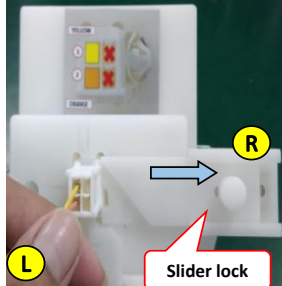
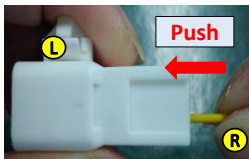
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PARTS:

1. AVSSf 0.3 wires Y-OR L=384±2mm

JIG

1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1	Wire insertion to connector 7188-0996 (W)	<div><p>Wire facing</p></div> <div><p>1 Yellow wire</p></div> <div><p>Push Button</p></div> <div><p>2 Orange wire</p></div> <div><p>Slider lock</p></div> <div><p>Push</p></div> <div><p>1. Get the Yellow wire then insert to terminal slot 1 using right hand. Conduct Pull-Push-Pull-Push after insertion.</p><p>2. Press the button using left hand. The slot for Orange wire will be opened.</p><p>3. Get the Orange wire then insert to terminal slot 2 using right hand. Conduct Pull-Push-Pull-Push. After insertion, press the button using left hand. GO sound will be heard.</p><p>4. Slide the lock using right thumb and then hold the wires and gently pull out the connector from jig using left hand.</p><p>5. After removing the connector from jig, conduct Pushing (1x) of Y wire using right hand to confirm that wire is fully inserted. Repeat the process for OR wire.</p></div> <div>n/a</div> <td><div><p>1. No loose insertion</p><p>2. No wrong insertion</p><p>3. One by one insertion</p><p>4. No deformed terminal</p><p>5. No wrong wire facing</p></div><div><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>3. Insertion jig will alarm if will not conduct Pull-Push-Pull-Push method.</p><p>4. Insertion jig will alarm if Yellow wire will not insert before 5 seconds.</p><p>5. Conduct Pushing of wires after removing the connector from jig.</p><p>6. Pushing of wires will be done one by one of every inserted wires</p></div><div><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></div></td>	<div><p>1. No loose insertion</p><p>2. No wrong insertion</p><p>3. One by one insertion</p><p>4. No deformed terminal</p><p>5. No wrong wire facing</p></div> <div><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>3. Insertion jig will alarm if will not conduct Pull-Push-Pull-Push method.</p><p>4. Insertion jig will alarm if Yellow wire will not insert before 5 seconds.</p><p>5. Conduct Pushing of wires after removing the connector from jig.</p><p>6. Pushing of wires will be done one by one of every inserted wires</p></div> <div><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></div>		

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PARTS:	1. Connector 7188-0996 (W)			JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1	Connector setting to insertion jig 7188-0996 (W)	<div><div><div>Insertion jig</div><div>Visual reference</div><div>Slider lock</div><div>Button</div><div>Guide</div></div><div><div>Insertion jig (Back view)</div><div>Reset</div><div>Adjustable</div></div><div><div>Insertion jig Orientation</div></div><div><div>Slide</div><div>L</div><div>R</div><div>L</div><div>R</div></div><div><div>1. Slide the slide lock using right thumb.</div></div><div><div>Connector Orientation</div></div><div><div>L</div><div>R</div><div>L</div><div>R</div><div>Release</div></div><div><div>Hole</div><div>L</div><div>R</div></div><div><div>2. Insert the connector 7188-0996 (W) into jig using left hand and release the side lock.</div></div><div><div>3. Push the guide using left hand. The slot for B/W wire will be opened.</div></div></div>	n/a	<p>Important reminders/Note/s:</p> <p>1. Cannot insert the inverted connector.</p> <p>1. Use provided jig per model</p> <p>2. No wrong usage of parts</p> <p>3. No wrong orientation of connector</p> <p>4. No damaged connector</p>

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PARTS:

1. AVSSf 0.3 wires B/W-G L=384±2mm

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

12

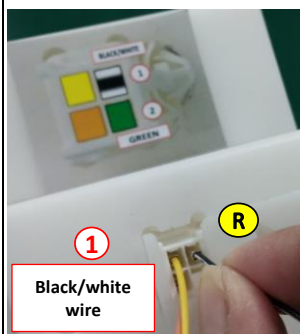
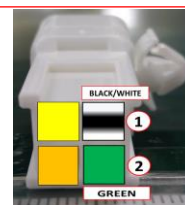
P1

Wire insertion to connector
7188-0996 (W)



Wire facing

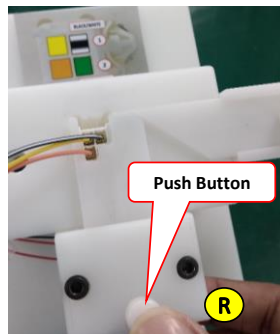
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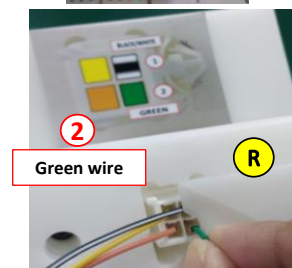
Black/white
wire

1. Get the **Black/white wire** then insert to terminal slot **1** using right hand. Conduct **Pull-Push-Pull-Push** after insertion.



Push Button

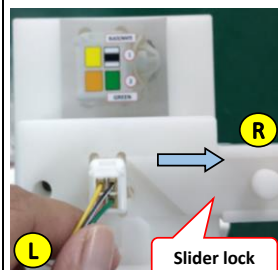
2. Press the button using left hand. The slot for **Green wire** will be opened.



2

Green wire

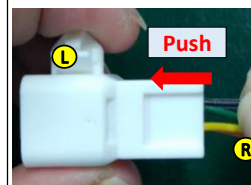
3. Get the **Green wire** then insert to terminal slot **2** using right hand. Conduct Pull-Push-Pull-Push. After insertion, press the button using left hand. **GO** sound will be heard.



R

Slider lock

4. Slide the lock using right thumb and then hold the wires and gently pull out the connector from jig using left hand.



Push

5. After removing the connector from jig, conduct **Pushing (1x)** of **B/W wire** using right hand to confirm that wire is fully inserted. Repeat the process for **G wire**.

n/a

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

Important reminders/Note/s:

1. Please hold the wire near terminal.
2. Make sure wires are properly inserted.
- Conduct **Pull-Push-Pull-Push** after insertion.
Do not exert extra force.
3. Insertion jig will alarm if will not conduct **Pull-Push-Pull-Push** method.
4. Insertion jig will alarm if Yellow wire will not insert before 5 seconds.
5. Conduct Pushing of wires after removing the connector from jig.
6. Pushing of wires will be done one by one of every inserted wires

Document references:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:

March 13, 2023

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: 920B / 7R0122-7021

Customer: TRMX

Document No.:

WI-ENG-PDE-644A

Purpose: ☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Revision No.:

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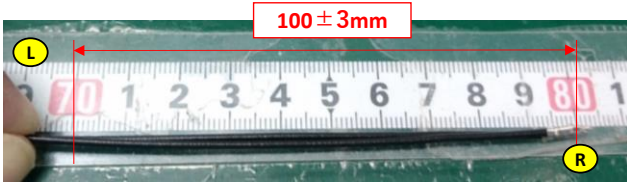
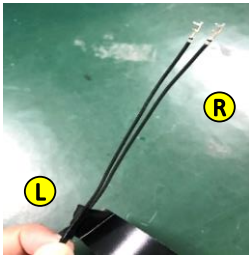
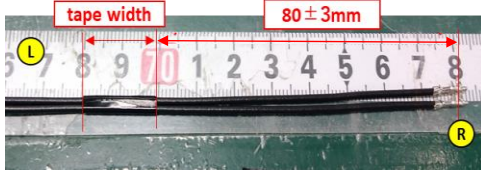


PARTS:

1. Assy parts
2. Black tape

3. Black twisted tube $\varnothing 5$ L=182 \pm 4mm

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
13	Spot taping 1	<div><p>1. Hold the wires using left hand and measure from wire up to terminal pointed tip 100\pm3mm.</p></div> <div><p>2. Get the Black tape and start taping on the Black wires. Conduct 2 windings of tape before cutting using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<div>MEASURING TAPE</div> 	<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p>
14	Wire insertion to Black twisted tube $\varnothing 5$ L=182 \pm 4mm	<div><p>1. Get the Black twisted tube $\varnothing 5$ L=182\pm4mm using right hand then insert the B-B wire using left hand.</p></div>	n/a	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal

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Purpose:

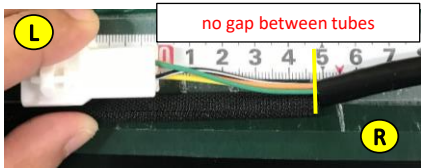
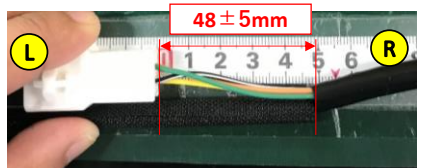
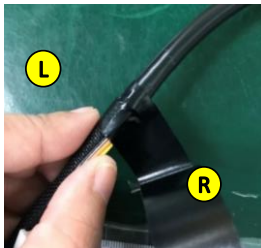

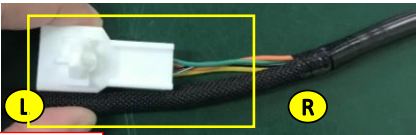
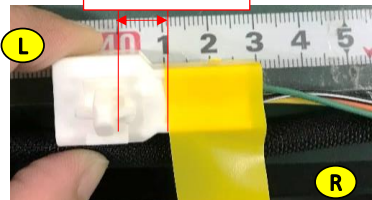

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
15	P1 Spot taping 2	<div><p>1. Fix the Connector and the twisted tube. Note: Alignment of twisted tube must be beside the Connector.</p></div> <div><p>2. Measure from end of connector up to end of twisted tube 48±5mm using both hands.</p></div> <div><p>3. Get the Black tape using right hand then conduct 2 windings of tape using both hands.</p></div>		<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p>
16	Y-taping	<div><p>1. Fix the Twisted tube to the side of the Connector.</p></div> <div><p>2. Measure from Connector to tape 11mm. Then, start taping the connector and twisted tube, make 2 winds before 1/3 shifting upward (must be tape width)</p></div>		<p>Important reminders/Note/s: 1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape

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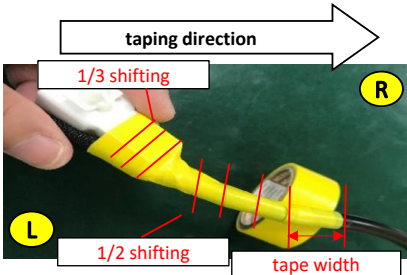
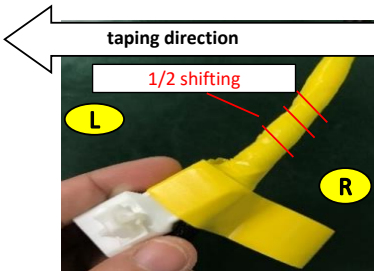
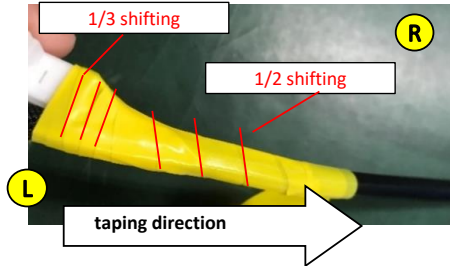
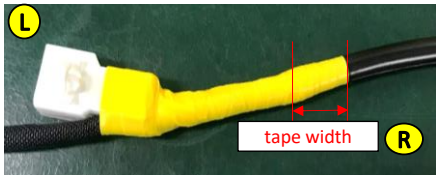

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	March 13, 2023
Validity Date:	n/a
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Process Name/Title:
Model Code/Part Number: **920B / 7R0122-7021** Customer: **TRMX**
Purpose: ☐ PROTOTYPE ☒ PRE-LAUNCH ☐ MASSPRO

PARTS:		1. Assy parts 2. Black tape		JIG	n/a	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
16	P1	Y-taping (Continuation)	<div><div><p>3. Wind the tape upward 1/3 shifting , then conduct 1/2 shifting upward until it reach the SV tube (Vinyl) (must be tape width)</p></div><div><p>4. Wind the tape backward 1/2 shifting.</p></div><div><p>5. Wind the tape 1/3 shifting then 1/2 shifting , same shifting to no. 3, then cut the tape after 2 winds on SV tube (Vinyl).</p></div><div><p>6. After taping, check the condition of tape, measurement and the connector facing.</p></div></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</p> <p>2. 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>

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TAPING ASSEMBLY PROCESS

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

Model Code/Part Number: **920B / 7R0122-7021** Customer: **TRMX**

Purpose: ☐ PROTOTYPE ☒ PRE-LAUNCH ☐ MASSPRO

PARTS:

1. Assy parts

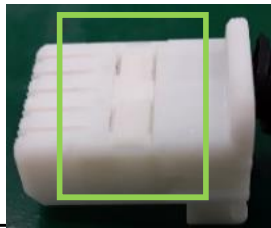
JIG

n/a

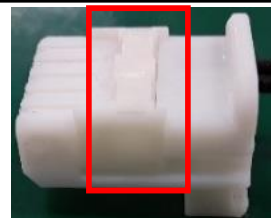
QUALITY CHECKPOINTS

P1

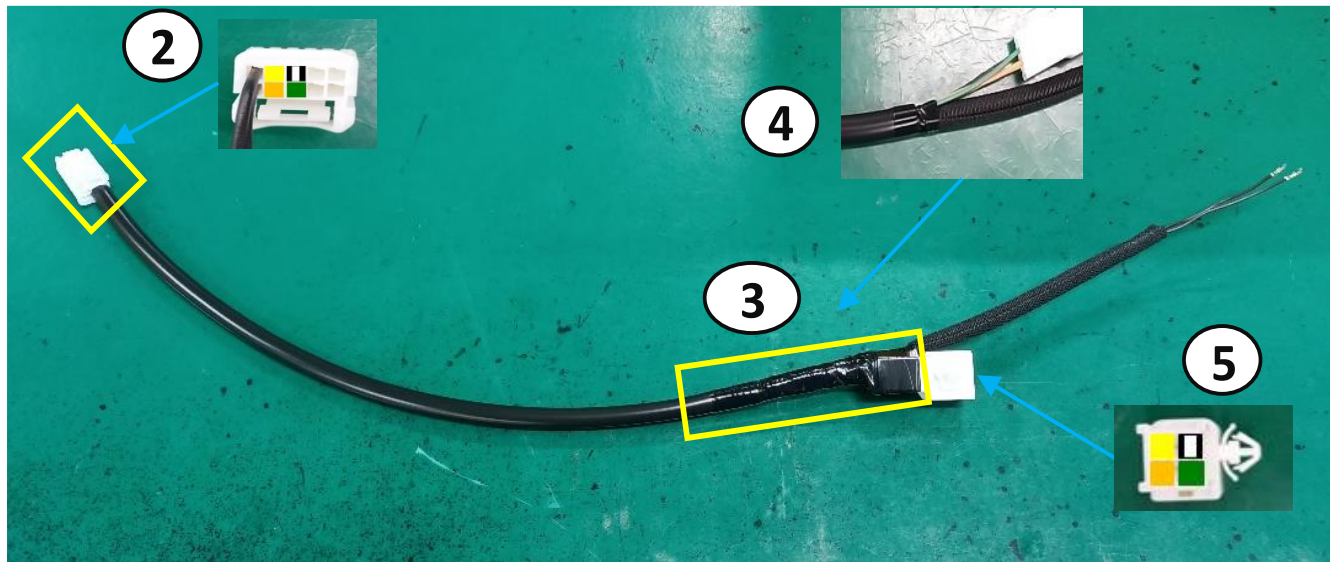
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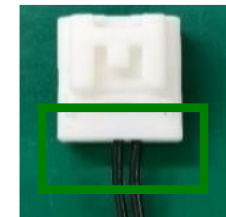
GOOD



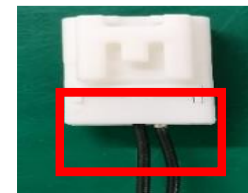
NO GOOD



6



GOOD



NO GOOD

① No Unlock/Halflocked Connector

②⑤ No Wrong Insert

③④ No Missing tape

⑥ No Terminal Backing Out

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