

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

Effectivity Date:

January 31, 2023Model Code/Part Number: **373D / 7N0174-7020**Customer: **TRJ**

Validity Date:

n/aPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-605A

Revision No.:

1

Page No.:

1 of 8**PARTS:**

1. Assy parts: Connector 6098-5673 (GR); AVSSf 0.3 wires B L=203±3mm; Gray tape

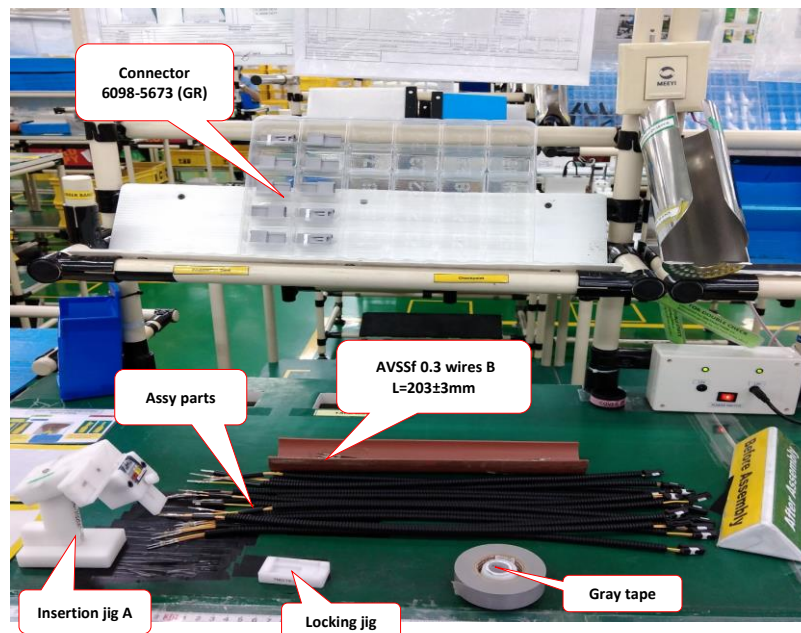
JIG:

1. Insertion jig
2. Locking jig**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P1

Table Lay-out

Table Lay-out**Safety Instruction**

Be sure to wear required 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.

Document references:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

1. No missing parts/tools
2. No excess parts/tools

Revision History

								Prepared by	Reviewed by	Approved by	Noted by
01/31/23	1	Change document purpose from prelaunch to masspro. Provide jigs: Insertion jig and locking jig. Inclusion of table layout and quality checkpoints. Improve work procedure and illustration, additional quality pointers. Change of spot taping measurement from 100±3mm to 120±3mm due to align on existing models.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
12/09/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	December 09, 2022			

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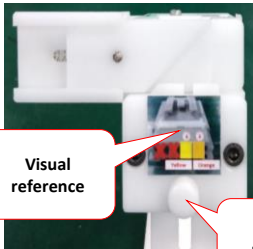


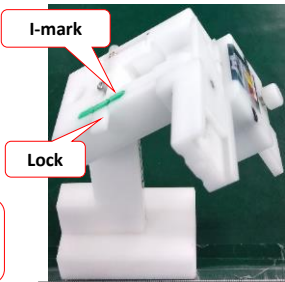

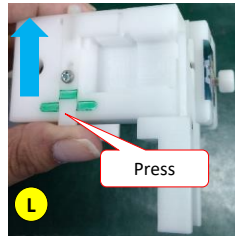
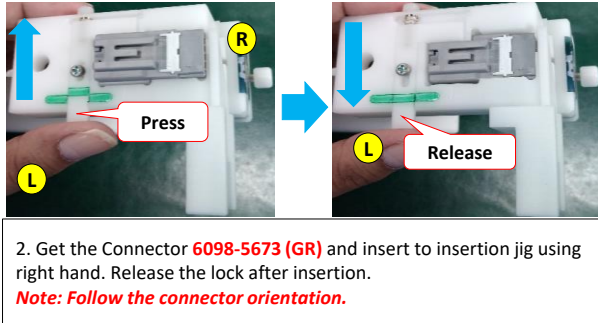
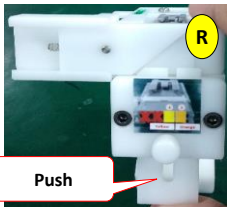
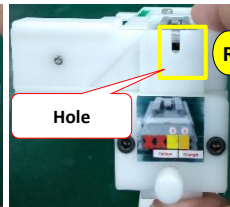
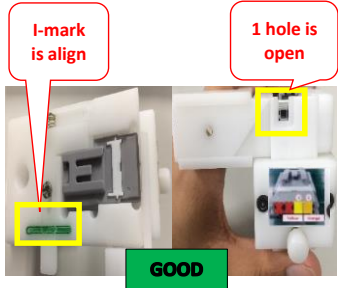

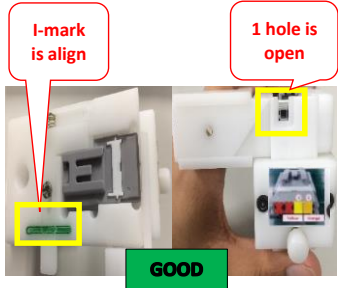

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	January 31, 2023		
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Process Name/Title:
Model Code/Part Number: **373D / 7N0174-7020** Customer: **TRJ**
Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Connector 6098-5673 (GR)		JIG	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 <div>1</div> Connector setting to insertion jig 6098-5673 (GR)	<div><div><p>Visual reference</p></div><div><p>Lower wire guide</p></div><div><p>Push button</p></div><div><p>I-mark</p><p>Lock</p><p>Insertion jig orientation</p></div><div><p>Connector Orientation</p></div><div><div><p>Press</p><p>1. Press the insertion jig lock using left hand.</p></div><div><p>Press</p><p>Release</p><p>2. Get the Connector 6098-5673 (GR) and insert to insertion jig using right hand. Release the lock after insertion. Note: Follow the connector orientation.</p></div><div><div><p>Push</p></div><div><p>Hole</p></div><div><p>3. Press the lower wire guide using right hand. Slot for Yellow wire will be opened.</p></div></div></div><div>n/a</div><td><div>Connector Orientation Illustration</div><div><div><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p></div><div><p>I-mark is not</p><p>2 holes are open</p><p>NG</p></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></td></div>		<div>Connector Orientation Illustration</div> <div><div><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p></div><div><p>I-mark is not</p><p>2 holes are open</p><p>NG</p></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>	

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Customer: TRJ

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH


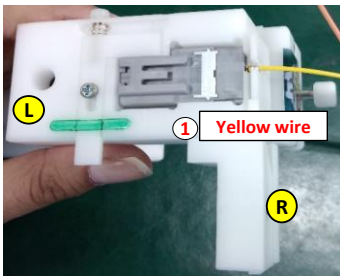

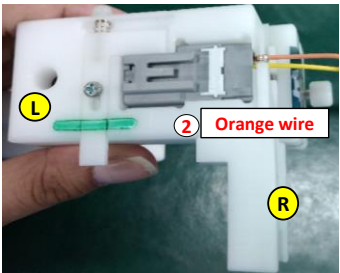
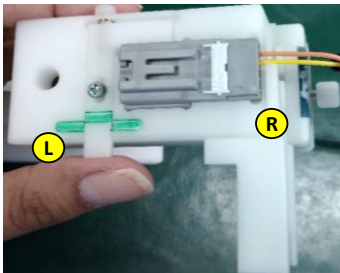

☒ MASSPRO

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 6098-5673 (GR)	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for Orange wire will be opened.</p></div> <div><p>3. Get the Orange wire then insert to terminal slot 2 using right hand.</p></div> <div><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>	n/a	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please hold the wire near terminal.2. Make sure wires are properly inserted. <p>Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references:</p> <ol style="list-style-type: none">1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. <ol style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deform terminal5. No wrong wire facing. <p>1</p> <p>Make sure to check the presence of SV tube (Vinyl) before insertion</p> 

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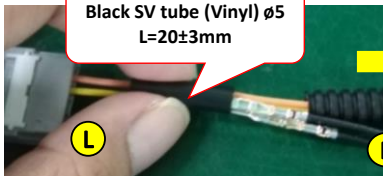


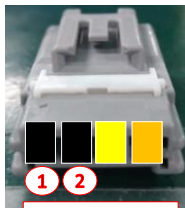

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PARTS:

1. Assy parts
2. AVSSf 0.3 wires B-B L=203±3mm

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black SV tube (Vinyl) ø5 L=20±3mm (Assy parts)	  <p>1. Get the B-B L=203±3mm and insert to Black SV tube (Vinyl) ø5 L=20±3mm (Assy parts) using right hand.</p>	n/a	1. No wrong use of parts
5	Wire insertion to connector 6098-5673 (GR) (Assy parts)	   <p>1. Hold the connector 6098-5673 (GR) then get the Black wire and insert to terminal slot 1 using right hand. Conduct 2x push-pull after wire insertion.</p> <p>2. Get the 2nd Black wire and insert to terminal slot 2 using right hand. Conduct 2x push-pull after wire insertion.</p>	n/a	<ol style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deformed terminal5. No wrong wire facing <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please hold the wire near terminal.2. Make sure wires are properly inserted. <p>Conduct Pull-Push-Pull-Push after insertion.</p> <p>Do not exert extra force.</p> <p>Document references:</p> <ol style="list-style-type: none">1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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PARTS:

1. Assy parts

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

6

P1

Connector lock



1. Load the connector into the jig holding both side of the connector, tip first.



2. Press the lower part of connector to fully insert into the locking jig.



Right thumb-Lower
Left thumb-middle

3. Press the lower parts of connector using right hand while left hand holding the middle.



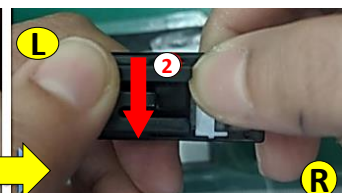
Right thumb-upper
Left thumb-middle

4. Press the upper part of connector using right hand while left hand holding the middle.



Right thumb-middle

5. Lift then press the connector in the middle using left and right hand.



6. Ensure that connector is in locked condition by touching the connector lock based on the sequence

LOCKING JIG



1. No Unlock and half-locked
2. Use provided jig tools per model to avoid damaged lock.

Important reminders/Note/s:

1. Manual locking may cause damaged connector
2. Refer WI-PRO-KIT-001 Proper locking and checking of connector lock

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PARTS:

1. Assy parts
2. Gray tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

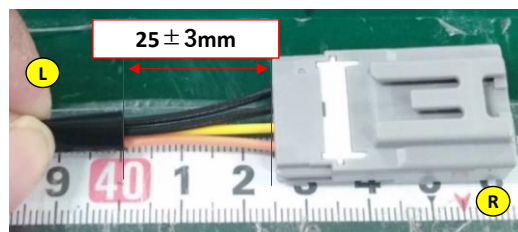
TOOLS/PPE

QUALITY POINTERS

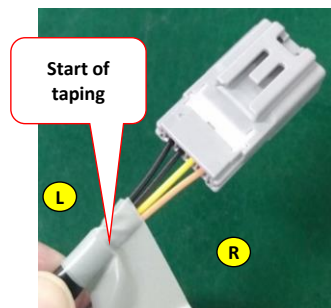
7

P1

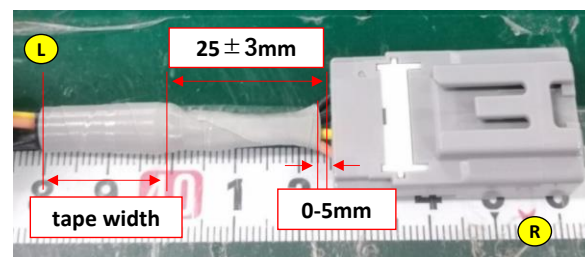
Taping 1
Black Vinyl tube to wire near
connector



1. Hold the Black vinyl tube using left hand and measure from end of vinyl tube up to connector **25±3mm**.
Note: Without folding in Vinyl tube



1. Hold the tube using left hand, get the **Gray tape** using right hand then start pre-taping using both hands.



4. After taping, check the measurement and taping condition.

MEASURING TAPE



Important reminders/Note/s:
1. Use GRAY TAPE only
2. 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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☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts
2. Gray tape

JIG

n/a

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

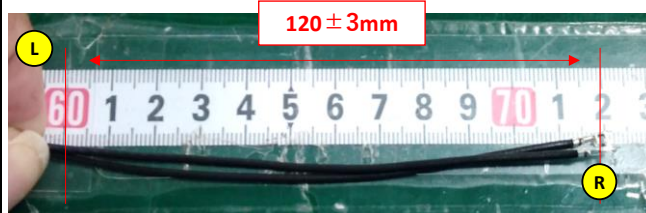
QUALITY POINTERS

8

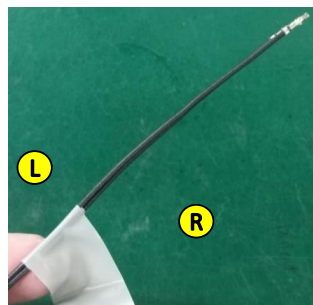
P1

Spot taping 1

1



1. Hold the wires using left hand and measure from wire up to terminal pointed tip **120±3mm**.

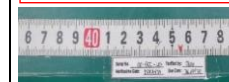


2. Get the **Gray tape** and start taping on the Black wires. Conduct **2 windings** of tape before cutting using both hands.

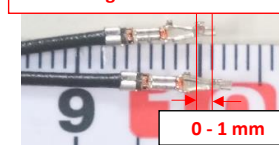


3. After taping, check the measurement and taping condition.

MEASURING TAPE



Wire alignment tolerance



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

Important reminders/Note/s:

1. Use **GRAY TAPE** only
2. Please use calibrated/verified measuring tape when getting the measurement.

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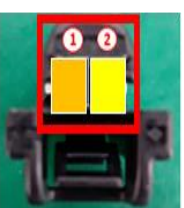
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PARTS:

1. Assy parts

JIG

n/a

**QUALITY CHECKPOINTS****P1****7N0174-7020****GOOD****GOOD****NO GOOD****NO GOOD****GOOD****NO GOOD**

① No **Unlock/Halflock Connector**
(2 connector)

② No **Wrong Insert**

③ No **Terminal Backing Out**

④ No **Wrong Used of Tape** (Gray tape)

⑤ No **Deformed Terminal**

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