



# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 26, 2021

Process Name/Title:

Product Name/Code: 096D / 7L0118-7020

Customer:

TRQSS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-241A

Revision No.:

1

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**PARTS:**

- Connector 6098-2220 (W)
- AVSSf 0.3 Y/OR wires L=713±2mm

JIG:

1. Insertion jig with switch cover

NO.

PROCESS NAME

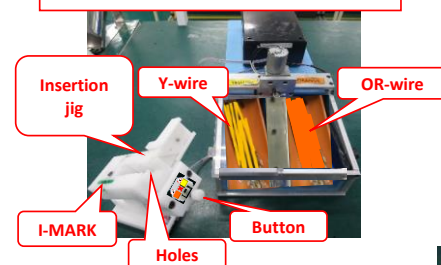
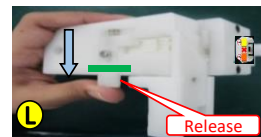
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

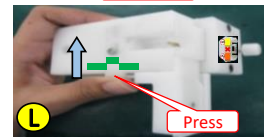
P1

Connector setting to  
insertion jig  
6098-2220 (W)**INSERTION JIG WITH SWITCH COVER****CONNECTOR ORIENTATION**

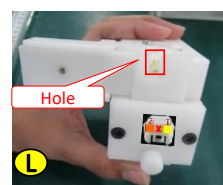
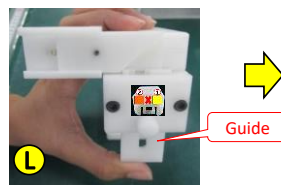
2. Insert the connector **6098-2220 (W)** into jig using right hand and release the lock.

**Note: Follow the connector orientation.**

1



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



3. Push the guide using left hand. The slot for **Y wire** will be opened.

**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.

**Connector Orientation Illustration**

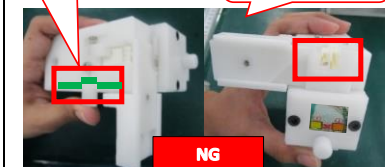
I-mark was align

1 hole is open



I-mark was not align

All holes were open



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	Prepared by	Reviewed by	Approved by	Noted by
05/26/21	1	Change type of purpose from Pre-launch to masspro. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
02/25/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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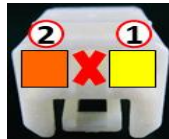
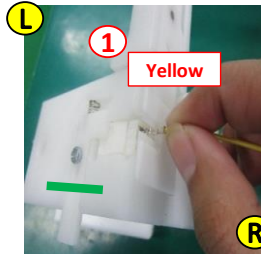
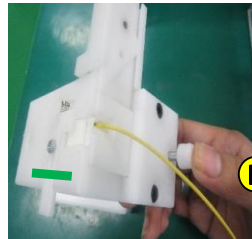
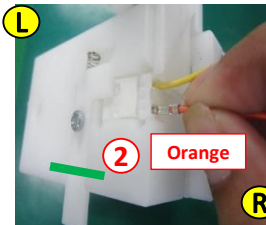
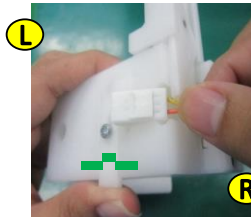
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		n/a			JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to connector 6098-2220 (W)	<div><div><p>WIRE FACING</p></div><div><p>VISUAL REFERENCE</p></div><div><div><p>1. Get the <b>Y wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div><div><p>2. After insertion of <b>Y wire</b>, press the button using right thumb. The slot for <b>OR wire</b> will be opened.</p></div><div><div><p>3. Get the <b>OR wire</b> then insert to terminal slot <b>2</b> 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></div></div></div>		n/a	<div>1. No loose insertion</div> <div>2. No wrong insertion</div> <div>3. One by one insertion</div> <div>4. No deformed terminal</div> <div>5. No wrong wire facing</div> <div>Note: Make sure wires are properly inserted.</div> <div>Conduct <b>Pull-Push-Pull-Push</b> after insertion.</div> <div>Do not exert extra force.</div>

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P1

Connector lock

1

## Sequence of Pressing the Double Lock:

① - ② - ③

**Method:** Press one by one using one thumb



1. Hold the 6098-2220 connector using right hand

①

2. Press location 1 of the connector lock using your left thumb

②

3. Press location 2 of the connector lock using your left thumb

③

4. Press location 3 of connector near terminal insertion side with your left thumb

Lock is visible

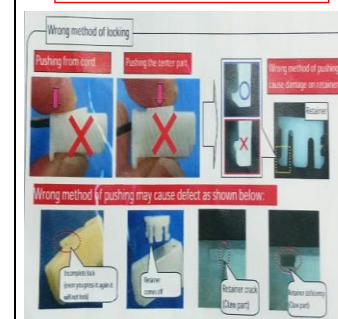
**BEFORE LOCK**

Lock is not visible

**AFTER LOCK**

5. Check the locking condition

## Wrong Locking Method



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

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PARTS:	1. Assy parts			JIG	n/a
	2. Black corrugated tube (no slit) $\Phi 5$ L=316±3mm 3. Black corrugated tube (no slit) $\Phi 5$ L=172±3mm				
4. Black vinyl tube $\Phi 5$ L=181±3mm					
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Wire insertion to Black corrugated tube (no slit) $\Phi 5$ L=316±3mm $\Phi 5$ L=172±3mm	<div><p>1. Get the corrugated tube <math>\Phi 5</math> L=316±3mm using right hand then insert the Y-OR wire using left hand.</p></div>	n/a	1. No wrong use of parts 2. No deformed terminal
			<div><p>1. Get the corrugated tube <math>\Phi 5</math> L=172±3mm using right hand then insert the Y-OR wire using left hand.</p></div>		
5		Wire insertion to Black vinyl tube $\Phi 5$ L=181±3mm	<div><p>1. Get the vinyl tube <math>\Phi 5</math> L=181±3mm using right hand then insert the Y-OR wire using left hand.</p></div>	n/a	1. No wrong use of parts 2. No deformed terminal

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### PARTS:

1. Connector 6098-3802 (W)

### JIG

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

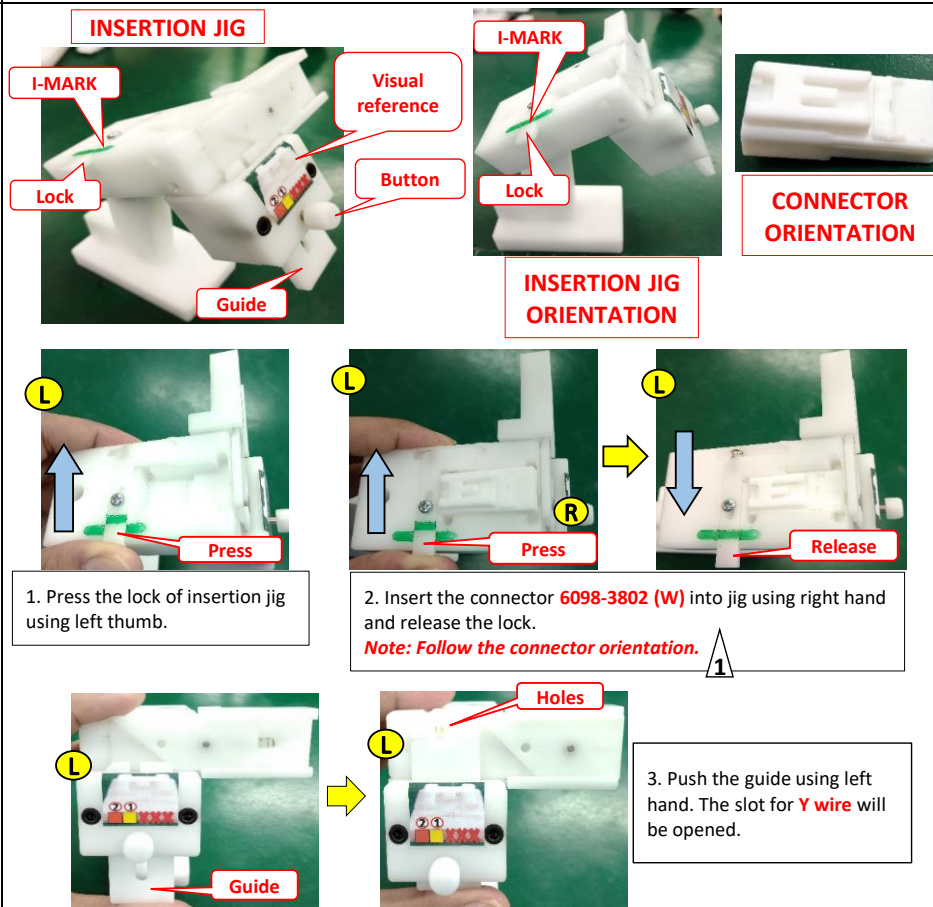
### TOOLS/PPE

### QUALITY POINTERS

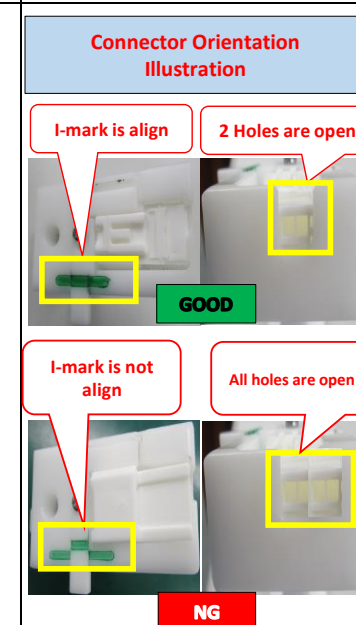
6

P1

Connector setting to  
insertion jig  
6098-3802 (W)



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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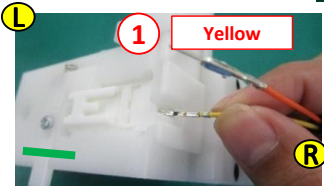
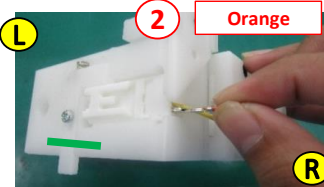
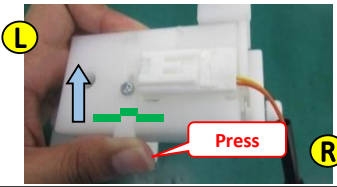

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### PARTS:

1. Assy parts
2. AVSSf 0.3 B/B wires L=798±3mm [2pcs.]
3. Black sunprene tube Φ5 L=121±3mm

### JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	Wire insertion to connector 6098-3802 (W)	 <p><b>Wire facing</b></p>  <p><b>1 Yellow</b></p> <p>1. Get the assy part and hold the <b>Y wire</b> then insert to terminal slot <b>1</b> using right hand.</p>  <p><b>2 Orange</b></p> <p>3. Get the <b>OR wire</b> then insert to terminal slot <b>2</b> using right hand.</p>  <p><b>Press</b></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>	n/a	<ol style="list-style-type: none"> <li>1. No loose insertion</li> <li>2. No wrong insertion</li> <li>3. One by one insertion</li> <li>4. No deformed terminal</li> <li>5. No wrong wire facing</li> </ol> <p><b>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</b></p>
8	Wire insertion to Black sunprene tube Φ5 L=121±3mm	 <p><b>1. Get the black sunprene tube Φ5 L=121±3mm using right hand then insert the B/B wires L= 798±3mm (n=2) using left hand.</b></p>	n/a	<ol style="list-style-type: none"> <li>1. No wrong use of parts</li> </ol>

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Purpose: ☐ PROTOTYPE

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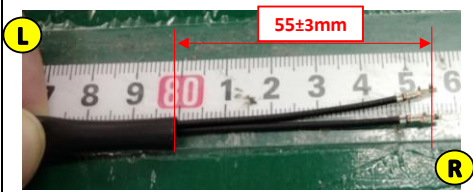
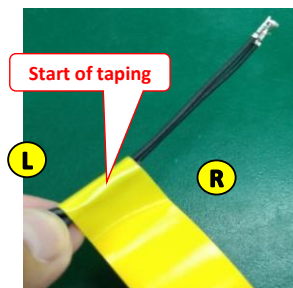
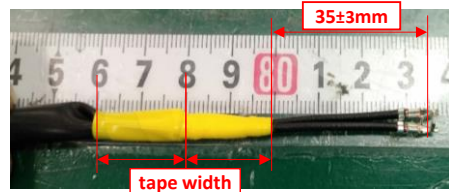

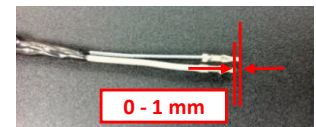

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PARTS:		JIG		n/a
		1. Assy parts 2. Yellow tape 3. Black corrugated tube (no slit) $\Phi 5$ L=237 $\pm$ 3mm		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1  Taping 1 Black corrugated tube to wire near terminal	<div><p>1. Measure from end of sunprene tube up to terminal pointed tip <b>55<math>\pm</math>3mm</b> using both hands.</p></div> <div><p>2. Get the <b>Yellow 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></div> <div><p>3. After taping, check the measurement, wire alignment and taping condition.</p></div>	<div><b>MEASURING TAPE</b></div> 	<div><b>NOTE:</b> <b>USE YELLOW TAPE ONLY.</b></div> <div><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</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> <div><b>Wire alignment tolerance</b></div> 
10	Wire insertion to Black corrugated tube (no slit) $\Phi 5$ L=237 $\pm$ 3mm	<div><p>1. Get the corrugated tube <b><math>\Phi 5</math> L=237<math>\pm</math>3mm (no slit)</b> using right hand and insert <b>B/B wires</b> using left hand.</p></div>	n/a	1. No wrong use of parts 2. No deformed terminal

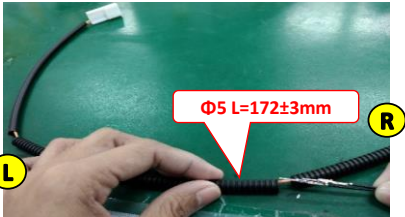
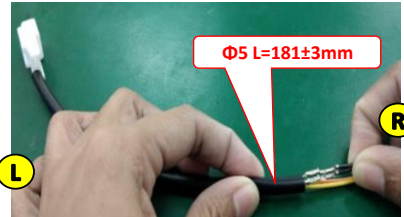
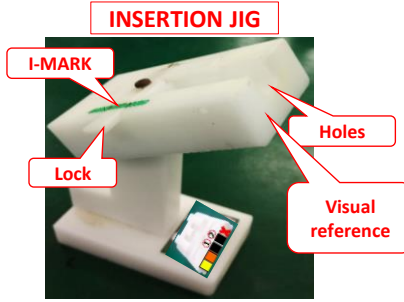
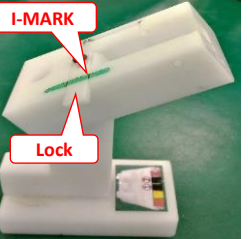

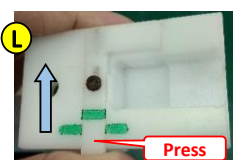
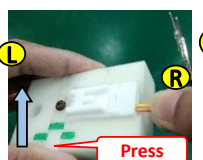


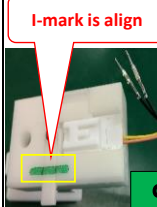
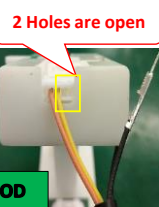
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:

<b>PARTS:</b>	1. Assy parts				<b>JIG</b>	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
11	Wire insertion to assy parts	<div>   </div> <div> <p>1. Hold the corrugated tube (no slit) <b>Φ5 L=172±3mm</b> using left hand then insert the assy parts using right hand.</p> <p>2. Hold the vinyl tube <b>Φ5 L=181±3mm</b> using left hand then insert the assy parts using right hand.</p> </div>		n/a	1. No wrong use of parts 2. No deformed terminal 3. No wrong insertion	
12	Connector setting to insertion jig 6098-3802 (W) (Assy parts)	<div>    </div> <div>     </div> <div> <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. <b>Note: Follow the connector orientation.</b></p> <p>3. Check the holes for <b>B/B wires</b>, it must be opened.</p> </div>		n/a	<div> <b>Connector Orientation Illustration</b> </div> <div>   </div> <div> <p>1. Use the provided jig per model</p> <p>2. No wrong orientation of connector</p> <p>3. No wrong use of connector</p> <p>4. No damaged connector</p> </div>	

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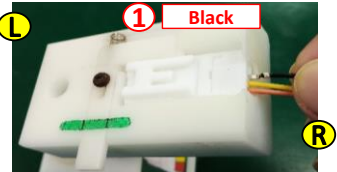
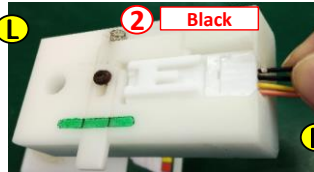
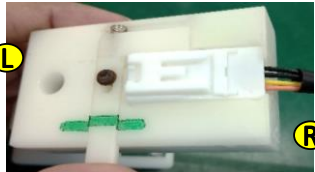
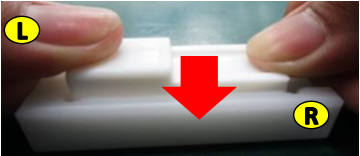


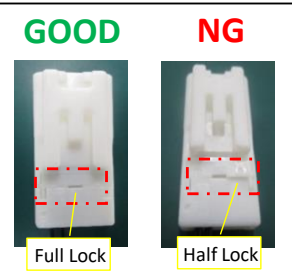
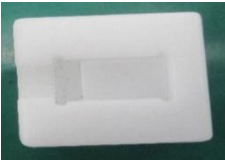
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PARTS:		1. Assy parts		JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1	<div><b>WIRE FACING</b></div> <div><b>1 Black</b> 1. Get the assy part and hold the <b>B wire</b> then insert to terminal slot <b>1</b> using right hand. <b>Note: Insertion of wire must be from left to right.</b></div> <div><b>2 Black</b> 2. Hold the <b>B wire</b> then insert to terminal slot <b>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>		n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing  <b>Note: Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</b>
14		<div><b>1</b> 1. Put the connector into locking jig both hands then press <b>2x</b> to lock using both hands. Touch the connector lock to confirm if properly locked. <b>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</b></div> <div><b>Before pressing</b></div> <div><b>After pressing</b></div> <div><b>GOOD NG</b> Full Lock Half Lock</div>		<b>LOCKING JIG</b> 	<b>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</b> 1. Use the provided locking jig per model 2. No unlock/half-lock connector

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