



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 13, 2022

Validity Date:

n/a

Model Code/Product Number: 749W / 7H0335W7020D

Customer:

NBS

Document No.:

WI-ENG-PDE-488A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

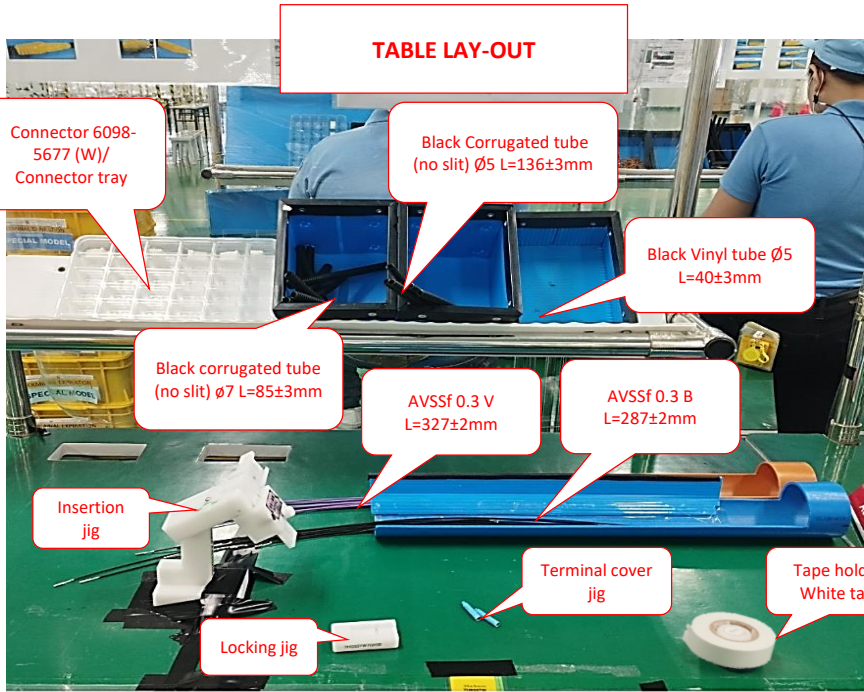
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PARTS:

1. All parts: Connector 6098-5677 (W); AVSSf 0.3 B L=287±2mm; V L=327±2mm; Black corrugated tube (no slit) Ø7 L=85±3mm; Black Corrugated tube (no slit) Ø5 L=136±3mm; Black Vinyl tube Ø5 L=40±3mm; White tape

JIG

1. Insertion jig
2. Locking jig
3. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out		<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <ol style="list-style-type: none">1. No missing parts/tools.2. No excess parts/tools.

Revision History

Eff.Date	Rev.No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
05/13/22	1	Change from Pre-Launch to Masspro. Additional table Lay-out.	K. Doria	J. Loterte	C. Villanueva	A.Arañes
04/25/22	0	Initial Issue.	K. Doria	J. Loterte	C. Villanueva	A.Arañes

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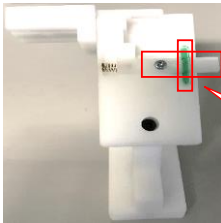
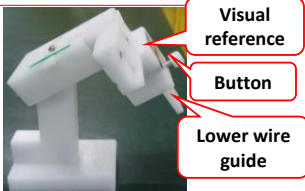


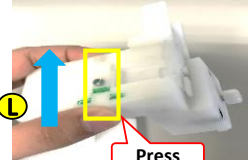
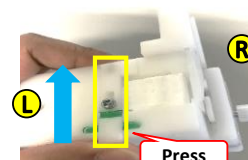
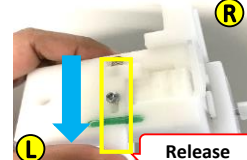
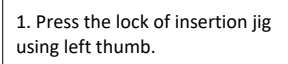
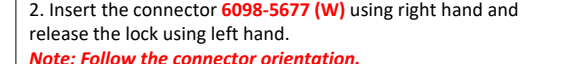
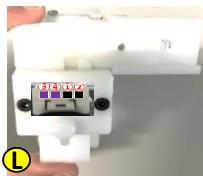
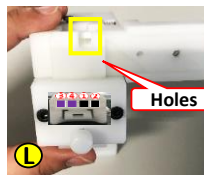
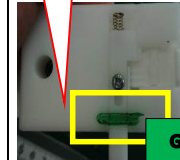
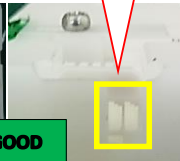
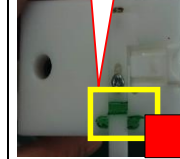

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Connector 6098-5677 (W)			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P1	<div><div><div>Insertion Jig</div></div><div><div>Insertion Jig Orientation</div></div><div><div>Double lock</div></div><div><div>CONNECTOR ORIENTATION</div></div></div> <div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div><div></div></div> <div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-5677 (W) using right hand and release the lock using left hand. Note: Follow the connector orientation.</div><div>3. Check the holes/terminal slot for B-B wires.</div></div>			n/a	<div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div></div><div><div>2 Holes are widely open</div></div></div> <div><div>I-mark is not align</div></div> <div><div>2 holes are partially open.</div></div>

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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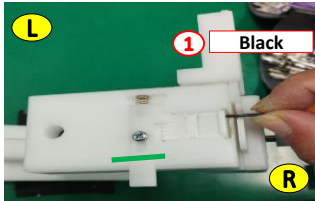
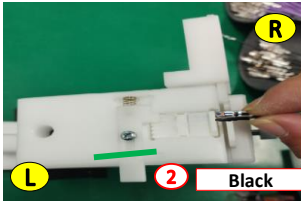
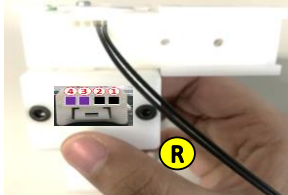


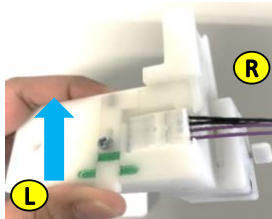
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PARTS:		1. AVSSf 0.3 B-B L=287±2mm; V-V L=327±2mm			JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	Wire insertion to Connector 6098-5677 (W)	<div><div><p>1. Get the 1st Black wire then insert to terminal slot 1 using right hand. <i>Note: Insertion of B-B wires must be from left to right.</i></p></div><div><p>2. Get the 2nd Black wire then insert to terminal slot 2 using right hand.</p></div><div><p>3. Press the button using right thumb. The slot for V-V wires will be opened.</p></div><div><p>4. Get the 1st Violet wire then insert to terminal slot 3 using right hand.</p></div><div><p>5. Get the 2nd Violet wire then insert to terminal slot 4 using right hand.</p></div><div><p>6. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div></div> <div>n/a</div> <td><p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p><p><i>Note: Please hold the wire near terminal during insertion.</i></p><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p><p>Make sure wires are properly inserted Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p><p><i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p></td>		<p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p> <p><i>Note: Please hold the wire near terminal during insertion.</i></p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Make sure wires are properly inserted Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p><i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p>	

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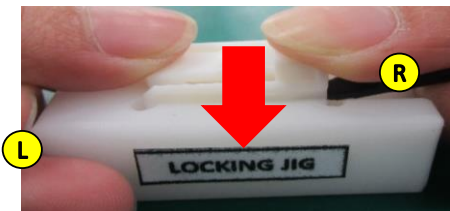
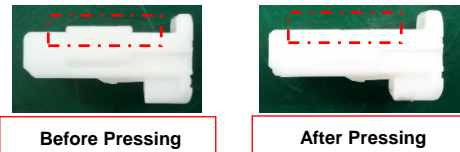
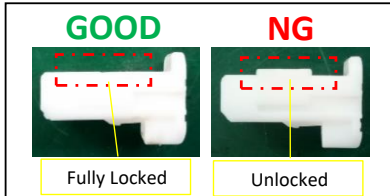





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PARTS:		1. Assy parts 2. Black corrugated tube (no slit) $\phi 7$ L=85 \pm 3mm			JIG	1. Locking jig 2. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
4	Connector lock	 <p>1. Put the connector into locking jig both hands then press 2x to lock using both hands. Touch the connector lock to confirm if properly locked. <i>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</i></p>  			<p>LOCKING JIG</p> 	<p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p> <p>1. Use the provided locking jig per model 2. No unlock/half-lock connector</p>	
5	P1 Wire insertion to Black corrugated tube $\phi 7$ L=85 \pm 3mm (no slit)	 <p>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B-B and V-V wires using left hand.</p>  <p>2. Get the corrugated tube (no slit) $\phi 7$ L=85\pm3mm using right hand then insert B-B and V-V wires using left hand.</p>  <p>3. After insertion, remove the terminal cover jig of all wires using right hand.</p>			<p>TERMINAL COVER JIG</p> 	<p>1. No wrong usage of parts 2. No deformed terminal tip</p>	

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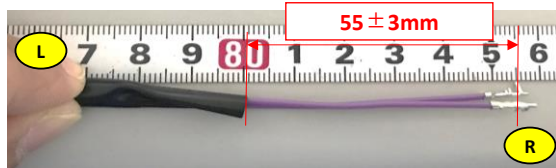
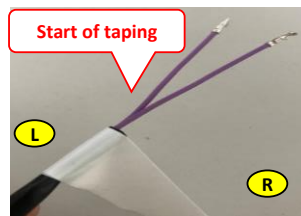
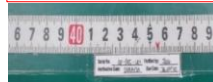
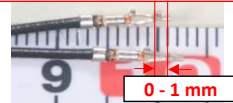
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PARTS:		1. Assy parts 2. Black Corrugated tube (no slit) Ø5 L=136±3mm			3. White tape 4. Black Vinyl tube Ø5 L=40±3mm		JIG	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS
6	P1	Wire insertion to Black Corrugated tube (no slit) Ø5 L=136±3mm	<div><div><p>1. Get the assy part and combine the V-V wires L=327mm using both hands and get the terminal cover jig using right hand</p></div><div><p>2. Get the corrugated tube (no slit) Ø5 L=136±3mm using right hand and insert the wires using left hand.</p></div><div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div></div>			<div><div>TERMINAL COVER JIG</div></div>	1. No wrong usage of parts 2. No deformed terminal tip	
7		Wire insertion to Black Vinyl tube Ø5 L=40±3mm	<div><p>1. Get the Black Vinyl tube Ø5 L=40±3mm using right hand then insert the V-V wires using left hand.</p></div>	n/a	1. No wrong usage of parts 2. No deformed terminal tip			
8		Taping 1 Black Vinyl tube to wire near terminal	<div><div><p>2. Measure from end of Vinyl up to terminal pointed tip 55±3mm then continue the taping process using both hands.</p></div><div><p>1. Hold the Vinyl using left hand, get the White tape using right hand then start the taping process using both hands. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p></div></div> <div>NOTE: USE <u>WHITE TAPE</u> ONLY.</div>			<div><div>MEASURING TAPE</div></div> <div>Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div><div>Wire alignment tolerance</div><p>0 - 1 mm</p></div>	2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension	

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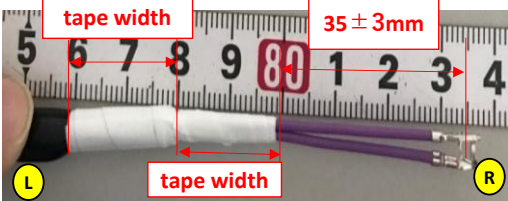

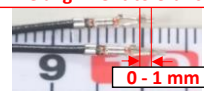
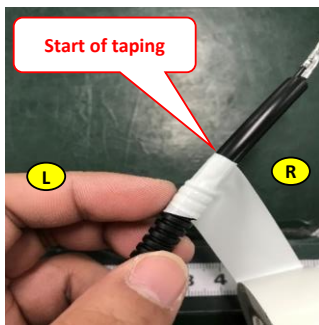
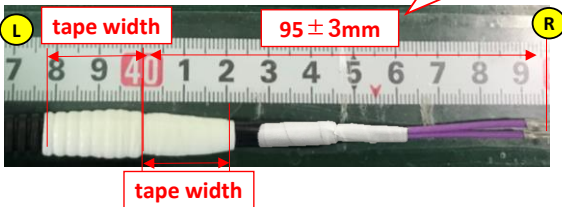

PARTS:

1. Assy parts
2. Black Corrugated tube (no slit) Ø5 L=136±3mm

3. White tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	Taping 1 Black Vinyl tube to wire near terminal (Continuation)	 <p>4. After taping, check the measurement, terminal appearance and taping condition.</p> <p>NOTE: USE <u>WHITE</u> TAPE ONLY.</p>	 <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>	<ol style="list-style-type: none">2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <p>Wire alignment tolerance</p> 
10	Taping 2 Black Corrugated tube to Vinyl tube	 <p>1. Hold the COT using left hand, get the White tape using right hand then start using both hands. Note: Please refer to WI-PRO-ASY-001 for taping procedure.</p>  <p>4. After taping, check the measurement, terminal appearance and taping condition.</p>		<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <p>NOTE: USE <u>WHITE</u> TAPE ONLY.</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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PARTS:

1. Assy parts
2. Black Corrugated tube (no slit) $\varnothing 5$ L=136 \pm 3mm

JIG

1. Terminal cover jig

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

11

P1

Wire insertion to
Black Corrugated tube
(no slit)
 $\varnothing 5$ L=136 \pm 3mm



1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the **B-B wires** using left hand.



2. Get the corrugated tube (**no slit**) $\varnothing 5$ L=136 \pm 3mm using right hand then insert the **B-B wires** using left hand.



3. After insertion, remove the terminal cover jig using right hand.

TERMINAL COVER JIG

1. No wrong usage of parts
2. No deformed terminal tip

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