

	WORK INSTRUCTION						Effectivity Date:		May 20, 2022	
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:				Model Code/Part Number: 666W / 7H0309W7020D		Customer: NBS		Document No.: WI-ENG-PDE-524A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		1	Page No.:

PARTS:	1. All parts: Connector 6098-3802 (W); AVSSf 0.3 B L=631±3mm; Black corrugated tube (no slit) ø5 L=468±5mm; Black sunprene tube ø9 L=120±3mm; Black tape				JIG:	1. Insertion jig 2. Locking Jig 3. Terminal Cover Jig	
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px; color: red; font-weight: bold;">TABLE LAY-OUT</div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b style="color: red;">Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b style="color: red;">Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> <b style="color: red;">Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	<p style="color: red; font-weight: bold; text-align: center;">Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> 1. No missing parts/tools. 2. No excess parts/tools.

Revision History								Prepared by	Reviewed by	Reviewed by	Approved by
05/20/22	1	Change from Pre-Launch to Masspro. Additional table Lay-out.	K. Doria	J. Loterte	C. Villanueva	A. Arañes					
05/13/22	0	Initial issue	K. Doria	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Prepared	Checked	Approved	Noted	Est. Date:	May 13, 2022			

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PARTS:

1. Connector 6098-3802 (W)

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

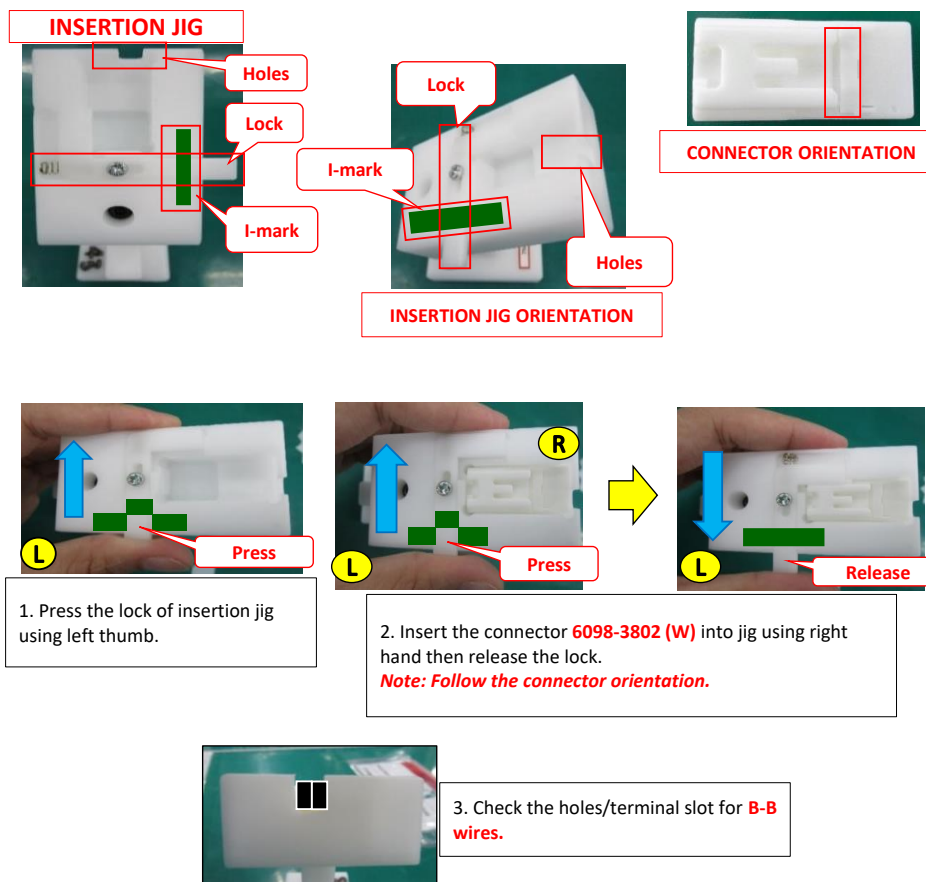
TOOLS/PPE

QUALITY POINTERS

2

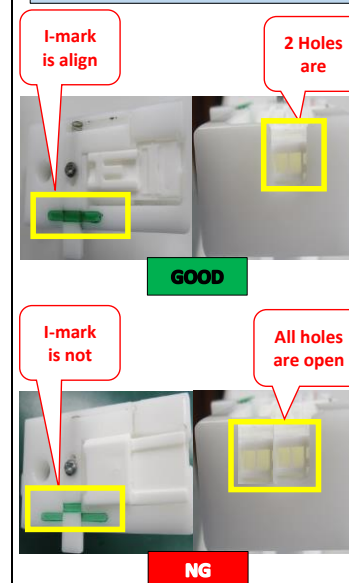
P1

Connector setting to
insertion jig
6098-3802 (W)



n/a

Connector Orientation Illustration



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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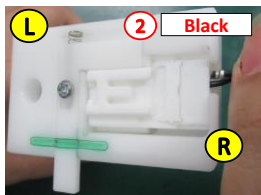

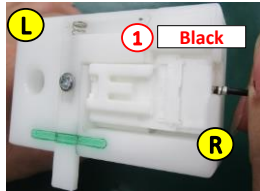
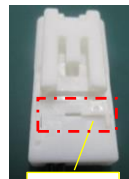



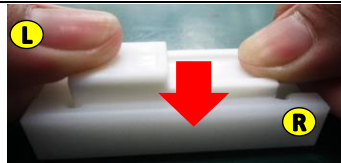
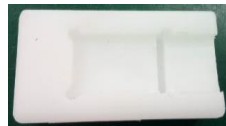
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PARTS:

1. AVSSf 0.3 B-B L=631±3mm [2pcs.]

JIG

1. Insertion jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to connector 6098-3802 (W)	<div></div> <div><p>1. Get the 1st Black wire then insert to terminal slot 1 of connector using right hand. Note: Insertion of wires must be from left to right</p><p>2. Get the 2nd Black wire then insert to terminal slot 2 of connector using right hand.</p><p>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.</p></div>	n/a	<p>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <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>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force."</p> <p>Note: Please hold the wire near terminal during insertion.</p>
4	Connector lock	<div></div> <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. Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</p>	LOCKING JIG 	<p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</p> <ol style="list-style-type: none">1. Use the provided locking jig per modle2. No unlocked/half-locked connector2. No damaged lock

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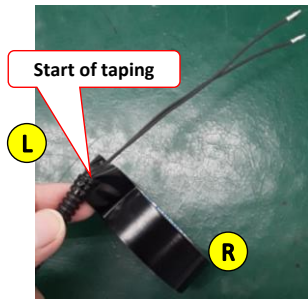
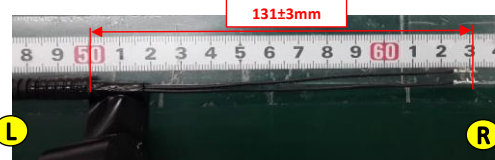
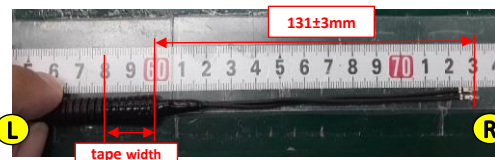

PARTS:

1. Assy parts
2. Black corrugated tube (no slit) $\phi 5$ L=468 \pm 5mm

3. Black tape

JIG

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to Black corrugated tube (no slit) $\phi 5$ L=468 \pm 5mm	   <p>1. Get the terminal cover jig using right hand then insert the B-B wires.</p> <p>2. Get the Black corrugated tube (no slit) $\phi 5$ L=468\pm5mm using right hand and insert the B-B wires.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>		<ol style="list-style-type: none">1. No wrong usage of parts2. No deformed terminal
6	Taping 1 Black corrugated tube to wire near terminal	   <p>1. Hold the COT using left hand, get the Black tape then start taping using right hand. Note: Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>2. Measure from end of COT up to the terminal tip 131\pm3mm then continue the taping process.</p> <p>3. After taping, check the taping condition, wire alignment and measurement.</p>		<p>Note: 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 <p>Wire alignment tolerance 0 ~ 1 mm</p>

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PARTS:

1. Assy parts
2. Black sunprene tube $\varnothing 9$ L=120 \pm 3mm

3. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

7

Wire insertion to
Black sunprene tube
 $\varnothing 9$ L=120 \pm 3mm



1. Get the sunprene tube $\varnothing 9$ L=120 \pm 3mm using right hand then insert the assy parts using left hand.
NOTE: COT must be inserted to sunprene tube (20 \pm 5mm).

n/a

1. No wrong use of parts
2. No deformed terminal

8

P1

Taping 2
Black Sunprene tube to
Black corrugated tube
(no slit)



1. Measure from end of sunprene tube up to the terminal pointed tip **31 \pm 3mm**.

2. Hold the Sunprene tube using left hand, get the **Black tape** then start taping using right hand.
Note: Refer to WI-PRO-ASY-001 for taping procedure.

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

MEASURING TAPE



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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