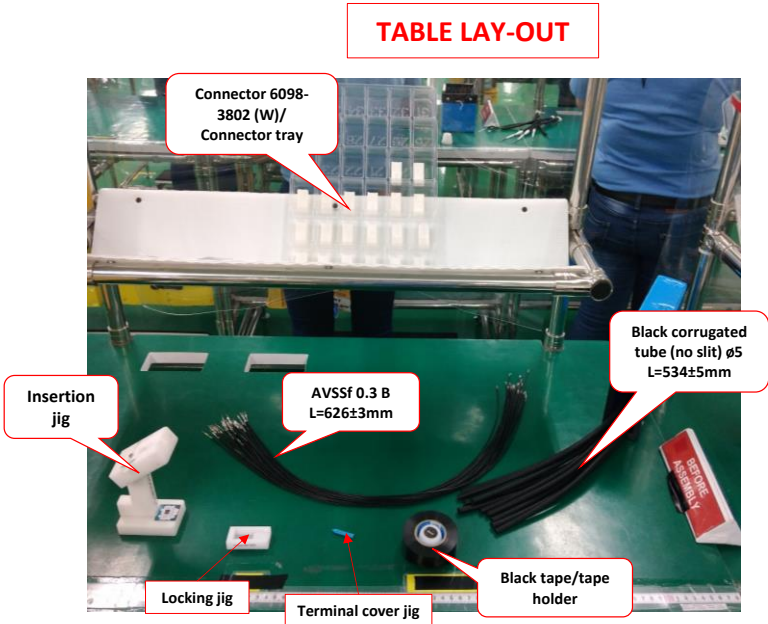
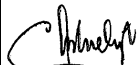



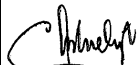



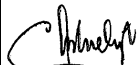



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	Model Code/Part Number: 879W / 7N0091-7020		Customer: TRJ		Document No.: WI-ENG-PDE-517A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 3		Page No.: 1 of 7	

PARTS: 1. Connector 6098-3802 (W); AVSSf 0.3 B L=626±3mm; Black corrugated tube (no slit) ø5 L=534±5mm; Black tape		JIG: 1. Insertion jig 2. Locking jig 3. Terminal cover jig																																													
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1	P1 Table Lay-out	<div style="text-align: center;"> <p>TABLE LAY-OUT</p>  </div>	<div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>																																												
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TAPING ASSEMBLY PROCESS

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n/a

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879W

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7N0091-7020

Customer:

TRJ

Document No.:

WI-ENG-PDE-517A

Purpose:

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☐ PRE-LAUNCH

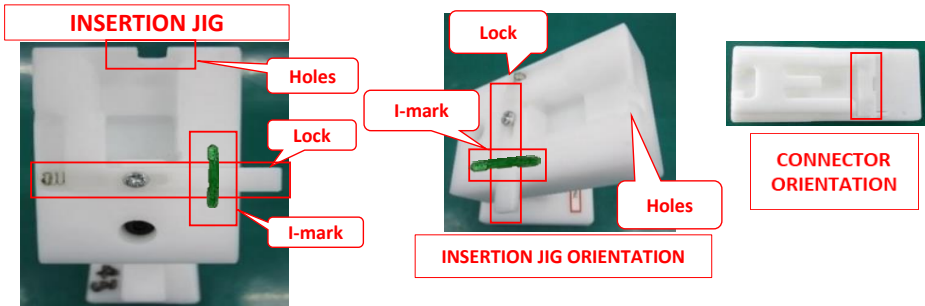
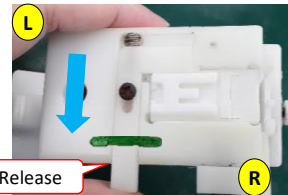
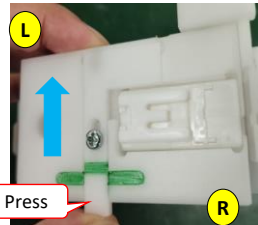
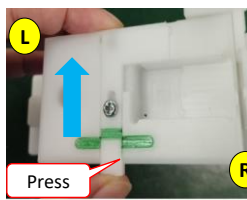

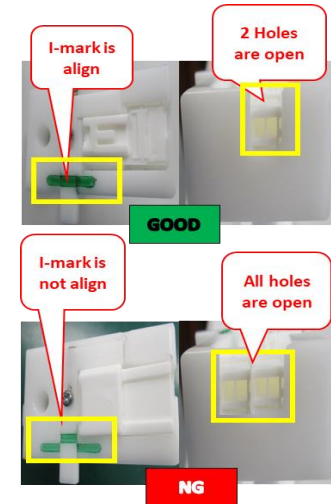
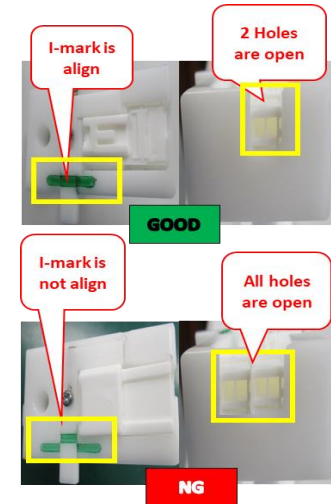
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PARTS:		1. Connector 6098-3802 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Connector setting to insertion jig 6098-3802 (W)	<div><div><div></div><div></div><div><div>1. Press the Lock of insertion jig using left hand.</div><div>2. Get the connector 6098-3802 (W) using right hand and insert to insertion jig. Release the lock after insertion. <i>Note: Follow the connector orientation.</i></div><div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div></div><div>n/a</div><td><div><div>Connector Orientation Illustration</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></td></div>	<div><div>Connector Orientation Illustration</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>	

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PARTS:		1. AVSSf 0.3 B-B L=626±3mm [2pcs.]		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	Wire insertion to connector 6098-3802 (W)		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 during insertion. 2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. 3. Insertion must be from left to right. Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</div>

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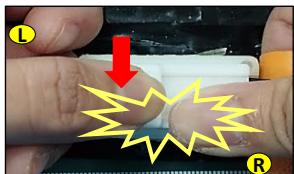



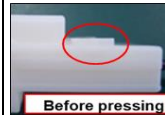


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PARTS:		1. Assy parts		JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	Connector lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div> <div><p>Right thumb-Lower Left thumb-middle</p><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-upper</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div>	<div>LOCKING JIG</div> 	<p>1. Use the provided locking jig per modle</p> <p>2. No unlocked/half-locked connector</p> <p>3. No damaged lock</p> <p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <div></div> <div><div>GOOD  Full Lock</div><div>NG  Half Lock</div></div>

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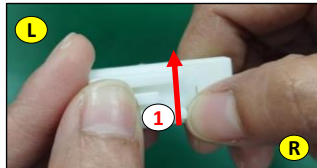





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PARTS:		1. Assy parts			JIG	1. Locking jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	Connector lock (Continuation)	<div><div><p>5. Lift then press the connector in the middle using left and right hand.</p></div><div><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div>		<div>LOCKING JIG</div> 	<div>1. Use the provided locking jig per modle 2. No unlocked/half-locked connector 3. No damaged lock</div> <div>Important reminders/Note/s:</div> <div>1. Manual locking may cause damaged connector lock.</div> <div><div><p>Before pressing</p></div><div><p>After pressing</p></div><div><div>GOOD <p>Full Lock</p></div><div>NG <p>Half Lock</p></div></div></div>

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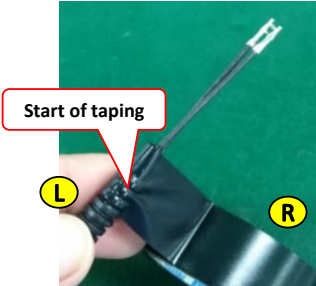
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PARTS:		1. Assy parts 2. Black corrugated tube (no slit) $\varnothing 5$ L=534 \pm 5mm		3. Black tape	JIG	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to corrugated tube (no slit) $\varnothing 5$ L=534 \pm 5mm	<div><div><p>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B-B wires using left hand.</p></div><div><p>2. Get the corrugated tube (no slit) $\varnothing 5$ L=534\pm5mm using right hand then insert the B-B wires using left hand.</p></div><div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No deformed terminal
6		Taping 1 Black corrugated tube to wire near terminal	<div><p>Start of taping</p></div> <div>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</div>	n/a	1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension	

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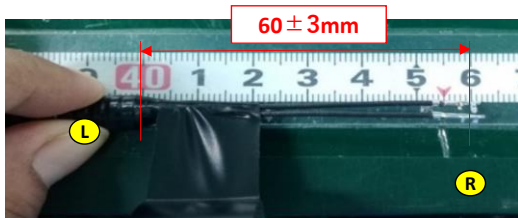

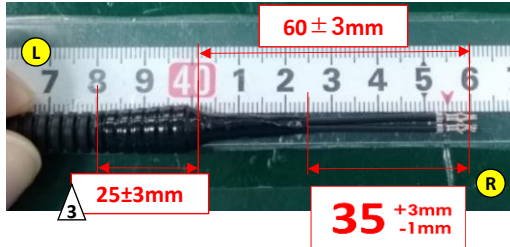

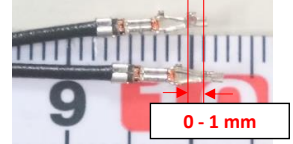
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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 Taping 1 Black corrugated tube to wire near terminal (Continuation)	 <p>2. Measure from end of COT up to terminal pointed tip $60 \pm 3\text{mm}$ then continue the taping process using both hands.</p>  <p>3. Confirm measurement of $35 \pm 3\text{mm}$ from end of tape up to terminal pointed tip then continue the taping process using both hands.</p>  <p>4. After taping, check the measurement, taping condition and terminal appearance.</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> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Wire alignment tolerance</p> 

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