



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 13, 2023

Model Code/Part Number:

300D / 7N0123-7020

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-602A

Revision No.:

1

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PARTS:

1. Connector 6098-3802 (W); AVSSf 0.3 B-V-G wires L=816±3mm; Black Corrugated tube ø5 L=653±6mm (no slit); Black tape

JIG:

1. Insertion jig with and w/o switch cover
2. Terminal cover jig
3. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

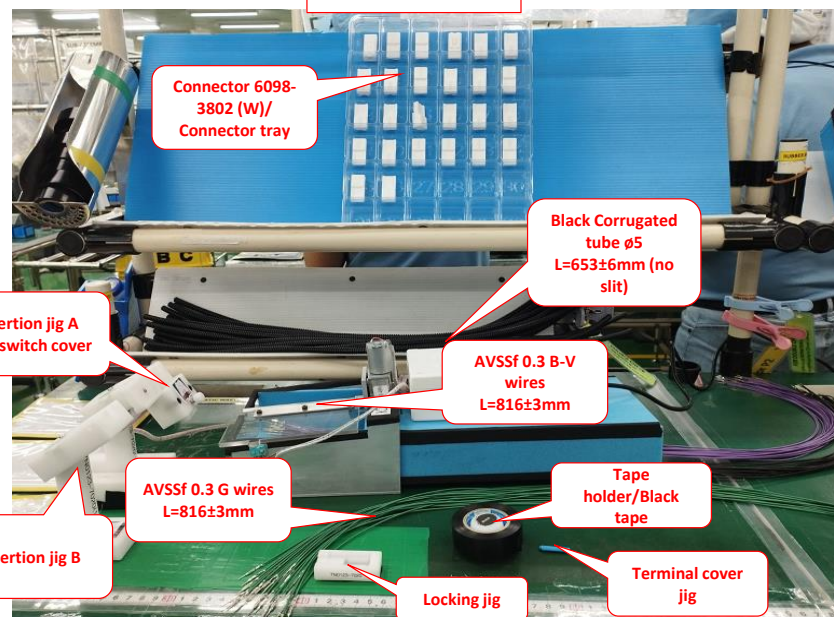
TOOLS/PPE

QUALITY POINTERS

1

P1

Table Lay-out

**Safety Instruction**

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

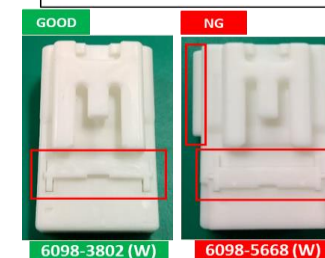
1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

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

CONNECTOR ILLUSTRATION



Revision History

Eff. Date	Rev. No	Details of Change	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	Prepared by	Reviewed by	Approved by	Noted by
1/13/23	1	Change document purpose from pre-launch to masspro. Additional table layout. Improve work procedure and illustration; quality pointers in all process. Inclusion of quality checkpoints.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
12/02/22	0	Initial issue.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	December 2, 2022		

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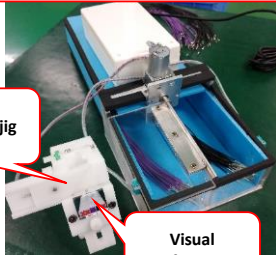
DCC Stamp



WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	January 13, 2023
Validity Date:	n/a
Document No.:	WI-ENG-PDE-602A
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Process Name/Title:
Model Code/Part Number: **300D / 7N0123-7020** Customer: **TRJ**
Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	1. Connector 6098-3802 (W)			JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	P1 Connector Setting to Insertion jig 6098-3802(W)	<p>INSERTION JIG WITH SWITCH COVER</p>  <p>Insertion jig</p> <p>Visual reference</p> <p>I-MARK</p> <p>Lock</p> <p>INSERTION JIG ORIENTATION</p> <p>CONNECTOR ORIENTATION</p> <p>L R Press</p> <p>1. Press the lock of insertion jig using left thumb.</p> <p>L R Press</p> <p>2. Insert the connector 6098-3802 (W) into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></p> <p>L R Release</p> <p>3. Push the guide using left hand. The slot for Violet wire will be opened.</p> <p>Guide</p> <p>Holes</p>	n/a	<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>Connector Orientation Illustration</p> <p>I-mark is align 1 Hole is open</p> <p>GOOD</p> <p>I-mark is not align 1 Hole is open</p> <p>NG</p> <p>CONNECTOR ILLUSTRATION</p> <p>GOOD NG</p> <p>6098-3802 (W) 6098-5668 (W)</p>	

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. AVSSf 0.3 B-V wires L=816±3mm

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

1 QUALITY POINTERS

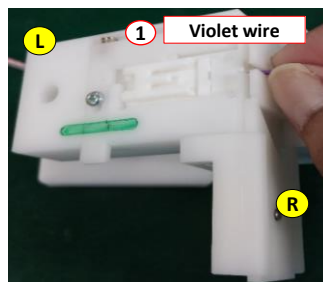
3

P1

Wire insertion to Connector 6098-3802 (W)

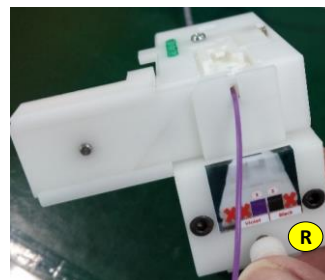


Wire facing

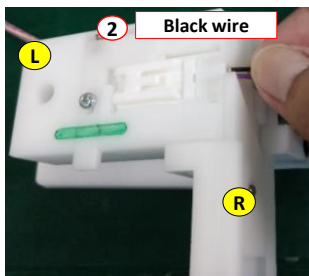


1 Violet wire

1. Hold the insertion jig using left hand. Get the Violet wire then insert to terminal slot 1 using right hand.

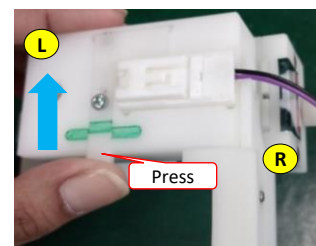


2. Press the button using right thumb. The slot for Black wire will be open.



2 Black wire

3. Get the Orange wire then insert to terminal slot 2 using right hand.



Press

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.

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

Important reminders/Note/s:

1. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted.
Conduct Pull-Push-Pull-Push after insertion.
Do not exert extra force.

Document reference/s:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
2. Please refer to WI-PRO-CNC-017 for Wire and Strip Length tolerance.

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PARTS:

1. Assy parts
2. AVSSf 0.3 G wire L=816±3mm

JIG

1. Insertion jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

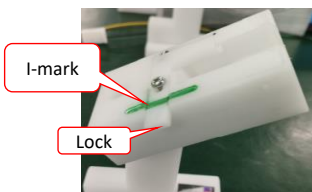


QUALITY POINTERS

4

P1

Wire Insertion to
Connector 6098-3802(W)
(Assy parts)



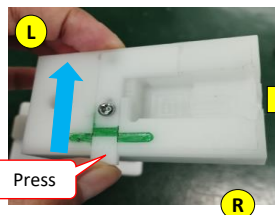
Insertion Jig Orientation



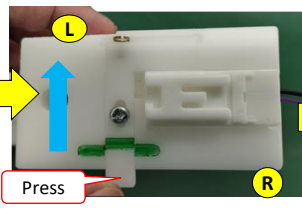
Connector
Orientation



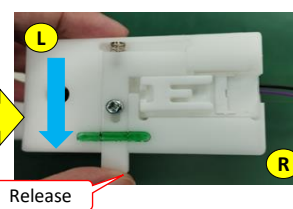
Wire facing



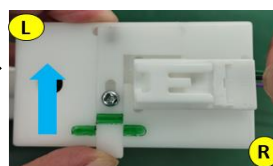
1. Press the Lock of insertion jig using left hand.



2. Get the assy parts using right hand and insert to insertion jig. Release the lock after insertion.



3. Get the **Green wire** then insert to connector using right hands.



4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.

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

Important reminders/Note/s:

1. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted.
Conduct Pull-Push-Pull-Push after insertion.
Do not exert extra force.

Document reference/s:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
2. Please refer to WI-PRO-CNC-017 for Wire and Strip Length tolerance.

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☐ PRE-LAUNCH






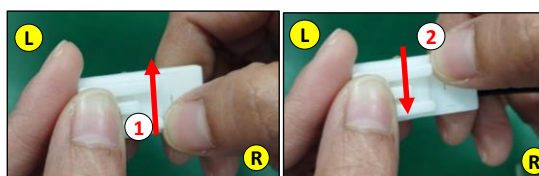





☒ MASSPRO

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PARTS:		1. Assy parts		JIG	1. Locking jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
5	P1	Connector lock			
		<div><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 Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div><div><p>Right thumb-middle Left thumb-middle</p><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><div><p>LOCKING JIG</p></div></div> <div><div><p>Before pressing</p></div><div><p>After pressing</p></div><div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div><p>Important reminders/Note/s: 1. Manual locking may cause damaged connector lock.</p></div>			

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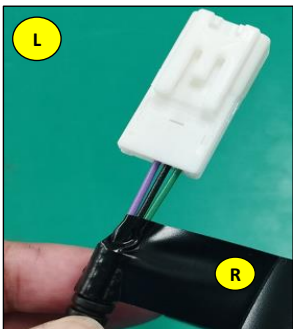

PARTS:

1. Assy parts
2. Black Corrugated tube $\varnothing 5$ L=653 \pm 6mm (no slit)

3. Black tape

JIG

1. Terminal cover jig

NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	1 QUALITY POINTERS
6	Wire Insertion to Black Corrugated tube $\varnothing 5$ L=653 \pm 6mm (no slit)	<div><p>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B-G-V wires using left hand.</p></div> <div><p>2. Get the corrugated tube (no slit) $\varnothing 5$ L=653\pm6mm (no slit) using right hand then insert the B-G-V wires using left hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>	<div>TERMINAL COVER JIG</div> 	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal
7	Taping 1 Black COT to wire near connector	<div><p>1. Hold the corrugated using left hand, get the Black tape and start pre-taping using both hands.</p></div>	<div>MEASURING TAPE</div> 	<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>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

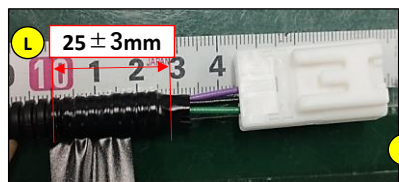
TOOLS/PPE

QUALITY POINTERS

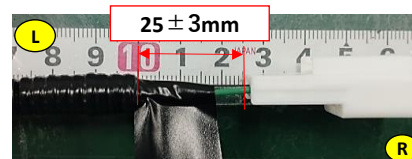
7

P1

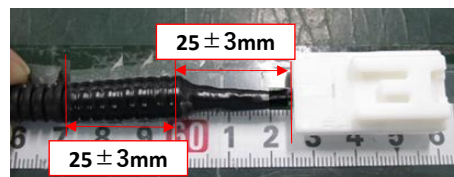
Taping 1
Black COT to wire near
connector (Continuation)



2. Confirm measurement of $25 \pm 3\text{mm}$ from end of tape up to COT then continue the taping process using both hands.

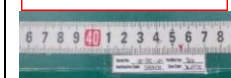


3. Measure from end of Corrugated tube up to end of connector $25 \pm 3\text{mm}$ using both hands.



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

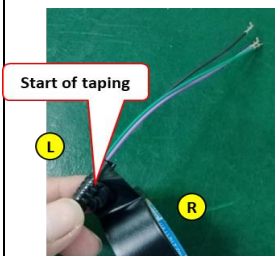
MEASURING TAPE



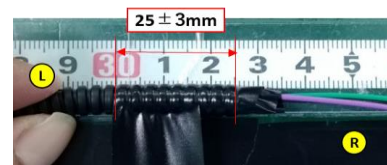
Important reminders/Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

8

Taping 2
Black COT to wire near
terminal



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



2. Confirm measurement of $25 \pm 3\text{mm}$ from end of tape up to COT then continue the taping process using both hands.

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

Important reminders/Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

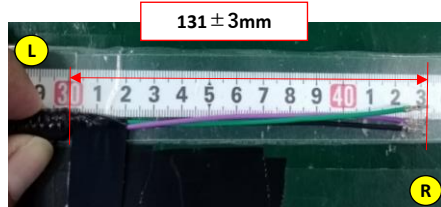
TOOLS/PPE

1 QUALITY POINTERS

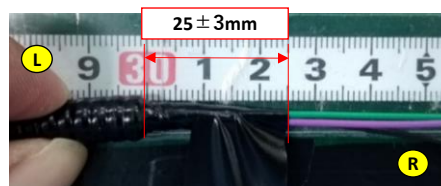
9

P1

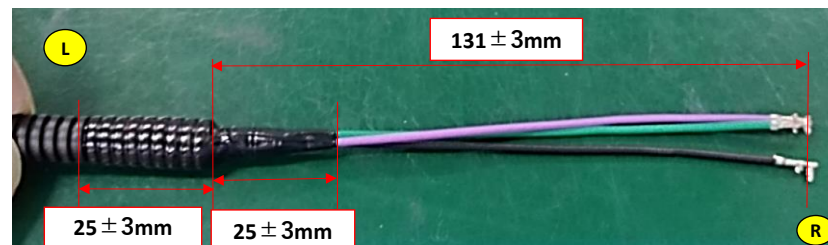
Taping 1
Black COT to wire near
terminal (Continuation)



3. Measure from end of COT up to terminal pointed tip $131 \pm 3\text{mm}$ then continue the taping process using both hands.



4. Confirm measurement of $25 \pm 3\text{mm}$ from COT up to end of tape then continue the taping process using both hands.



5. After taping, check the measurement, terminal appearance and taping condition.

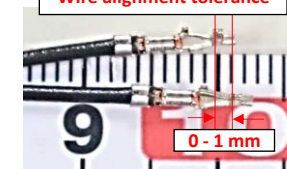
MEASURING TAPE



Important reminders/Note/s:
1. 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

Wire alignment tolerance



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PARTS:

1. Assy parts
2. Black tape

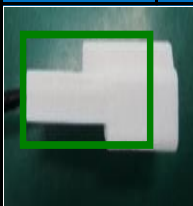
JIG

n/a

1 QUALITY CHECKPOINTS

P1

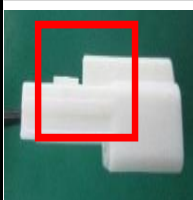
7N0123-7020



GOOD



GOOD



NO GOOD



NO GOOD

1 No Unlock/Halflock Connector



2 No Wrong Insert

4 No Missing Tape

3 No Terminal Backing Out

5 No Deformed

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