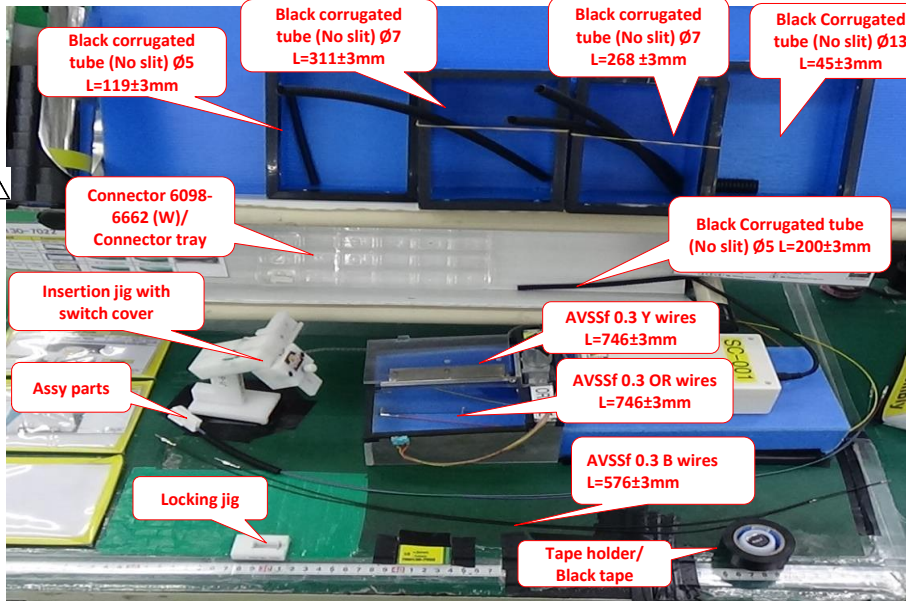




	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>						Effectivity Date: <b>June 14, 2023</b>	
	Process Name/Title:						Validity Date: <b>n/a</b>	
	Model Code/Part Number: <b>200D / 7R0130-7022</b>			Customer: <b>TRMX</b>			Document No.: <b>WI-ENG-PDE-563A</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.: <b>5</b> Page No.:    1 of 8	

<b>PARTS:</b>		1. Connector 6098-6662(W); AVSSf 0.3 Y-OR wires L=746±3mm; Black corrugated tube (No slit) Ø5 L=119±3mm; Black Corrugated tube (No slit) Ø7 L=311±3mm; Black Corrugated tube (No slit) Ø13 L=45±3mm; Black Corrugated tube (No slit) Ø5 L=200±3mm; AVSSf 0.3 B wires L=576±3mm; Black tape				JIG		1. Insertion jig with switch cover 2. Locking jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
1	P1	<div style="text-align: center;"> <b>TABLE LAY-OUT</b> </div> 				<div style="border: 1px dashed red; padding: 5px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Housekeeping</b>            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>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>		<b>Document reference/s:</b> 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to WI-ENG-PDE-566 for Offline Assembly Process 3. Refer to TW-PRO-ASY-031A for new process distribution.	

Revision History						Prepared by		Reviewed by		Approved by		Noted by	
06/14/23	5	Changed table lay-out; Changed Quality Checkpoints; Changed MP from 3MP to 4M; Transferred process of Connector setting to insertion jig 7282-1060 (W) and Wire insertion to 7282-1060 (W) from P1 to P2 due to new process distribution.				M. Ariola	J. Loterte	C. Villanueva	A.Arañes				
12/02/22	4	Transfer process no.11- Connector setting to insertion jig and process no.12 Wire insertion to Connector 7282-1060 (W) to P2 due to Process Improvement. Change table lay-out.				M.Ariola	J. Loterte	C. Villanueva	A.Arañes				
09/23/22	3	Change of tolerance from 35+/-3mm to 35(+3/-1mm) as countermeasure of encountered NG dimension from end of tape up to terminal tip.				M.Ariola	J. Loterte	C. Villanueva	A.Arañes				
Eff.Date	Rev.No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	July 14, 2022		

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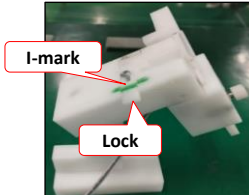
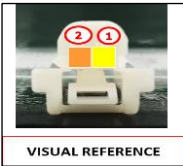
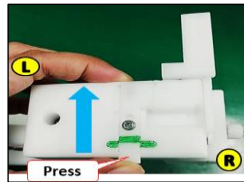
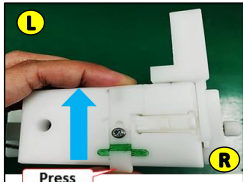
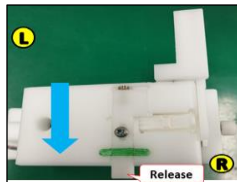
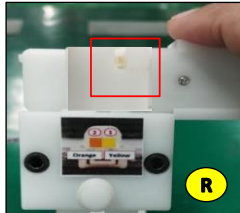
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**2 of 8****PARTS:**

1. Connector 6098-6662(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 (6098-6662W)	<div><div><p>CONNECTOR ORIENTATION</p></div><div><p>INSERTION JIG ORIENTATION</p></div><div><p>VISUAL REFERENCE</p></div><div><p>Press</p></div><div><p>Press</p></div><div><p>Release</p></div><div><p>R</p></div><div><p>1. Press the lock of insertion jig using left hand.</p></div><div><p>2. Get the connector <b>6098-6662 (W)</b> using right hand then insert to insertion jig. Release the lock after insertion. <i>Note: Follow the connector orientation.</i></p></div><div><p>3. Push the lower wire guide upward using right hand. Slot for <b>Yellow wire</b> will be opened.</p></div></div>	n/a	<div>1. Use the provided jig per model</div> <div>2. No wrong orientation of connector</div> <div>3. No wrong use of connector</div> <div>4. No damaged connector</div>

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Document No.:

**WI-ENG-PDE-563A**

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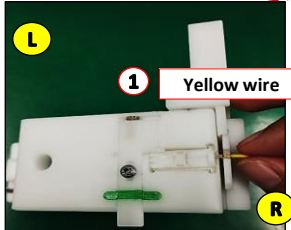
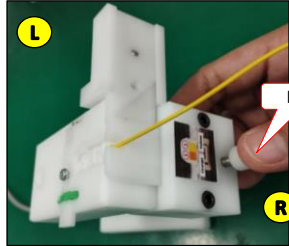
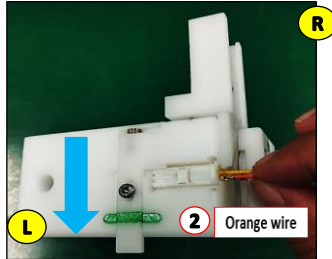
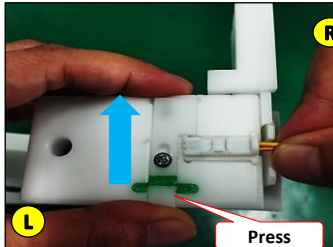
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**3 of 8****PARTS:**

1. Connector 6098-6662 (W)
2. AVSSf 0.3 Y-OR wires L=746±3mm

**JIG**

1. Insertion jig with switch cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Wire Insertion to connector 6098-6662 (W)	<div><p>WIRE FACING</p></div> <div><p>1. Hold the insertion jig using left hand. Get the <b>Yellow</b> then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot <b>2</b> for <b>Orange</b> wire will be opened.</p></div> <div><p>3. Get the <b>Orange</b> wire 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>	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>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please hold the wire near terminal during insertion.</li><li>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</li></ol> <p><b>Document reference/s:</b></p> <ol style="list-style-type: none"><li>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</li><li>2. Refer to GL-PRO-ASY-029 for Pull-Push procedure</li></ol>

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# WORK INSTRUCTION

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Effectivity Date:

June 14, 2023

Model Code/Part Number: **200D / 7R0130-7022**

Customer: **TRMX**

Validity Date:

n/a

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

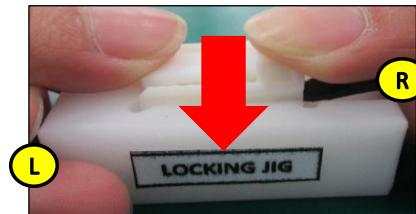
TOOLS/PPE

QUALITY POINTERS

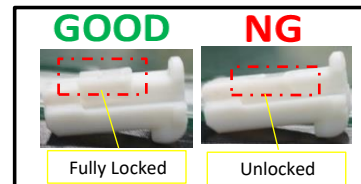
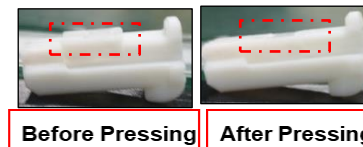
4

P1

Connector lock



1. Put the connector into locking jig using both hands then press **2x** to lock using both hands. Touch the connector lock to confirm if properly locked.



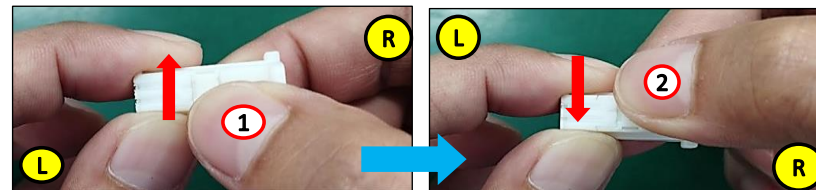
LOCKING JIG



**Important reminders/Note/s:**

1. Manual locking may cause damaged connector lock.

1. Use provided jig tools per model  
2. No unlocked/half-locked connector



2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

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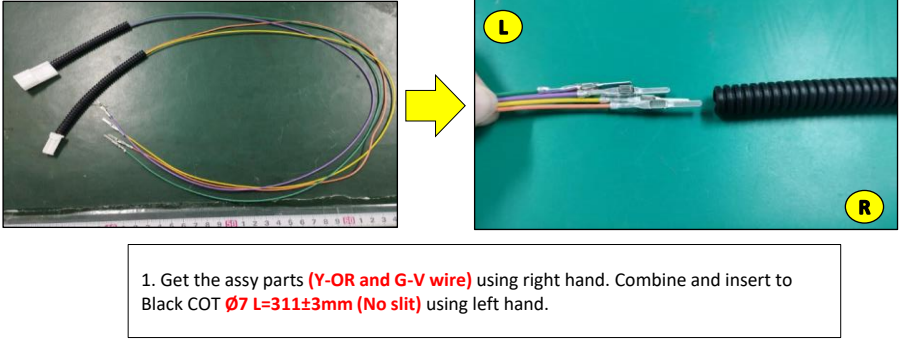
1. Assy parts

2. Black corrugated tube (No slit) Ø5 L=119±3mm

3. Black corrugated tube (No slit) Ø7 L=311±3mm

**JIG**

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to Black Corrugated tube (No slit) Ø5 L=119±3mm		n/a	1. No wrong use of parts 2. No deformed terminal
6	Wire insertion to Black Corrugated tube (No slit) Ø7 L=311±3mm		n/a	1. No wrong use of parts 2. No deformed terminal

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## TAPING ASSEMBLY PROCESS

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### PARTS:

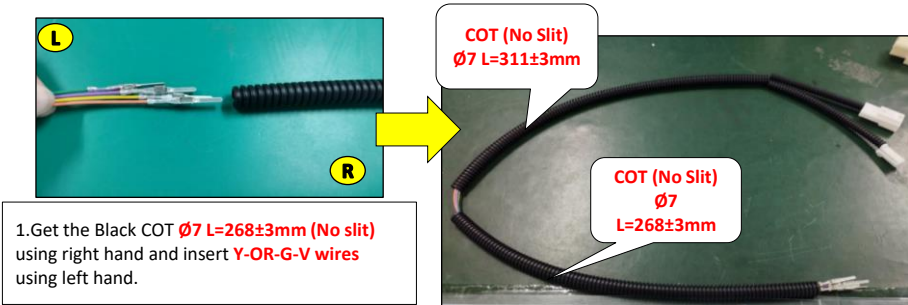
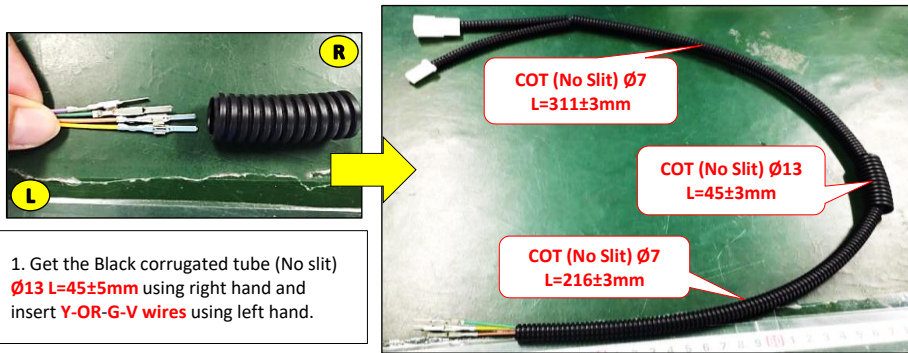
1. Assy parts

2. Black Corrugated tube (No slit) Ø7 L=268±3mm

3. Black Corrugated tube (No slit) Ø13 L=45±3mm

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	Wire insertion to Black Corrugated tube (No slit) Ø7 L=268±3mm	 <p>1. Get the Black COT Ø7 L=268±3mm (No slit) using right hand and insert Y-OR-G-V wires using left hand.</p>	n/a	1. No wrong use of parts 2. No deformed terminal
8	Wire insertion to Black Corrugated tube (No slit) Ø13 L=45±3mm	 <p>1. Get the Black corrugated tube (No slit) Ø13 L=45±3mm using right hand and insert Y-OR-G-V wires using left hand.</p>	n/a	1. No wrong use of parts 2. No deformed terminal

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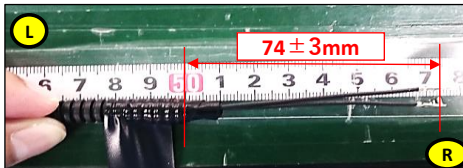

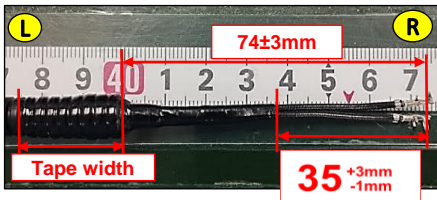

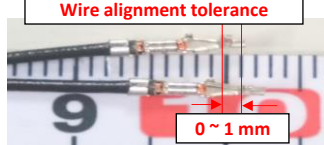
### PARTS:

1. Assy parts
2. Black Corrugated tube (No slit)  $\varnothing 5$  L=200 $\pm$ 3mm

3. AVSSf 0.3 B wires L=576 $\pm$ 3mm [2pcs]
4. Black tape

### JIG

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
13	Wire insertion to Black Corrugated tube(No slit) $\varnothing 5$ L=200 $\pm$ 3mm	 <p>1. Get the Black COT <math>\varnothing 5</math> L=200<math>\pm</math>3mm (No Slit) using right hand and insert B-B wires using left hand.</p>	n/a	<b>Important reminders/Note/s:</b>  1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.  1. No wrong usage of parts. 2. No deformed Terminal
14	Taping 1 COT to Wire near terminal	 <p>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</p>  <p>2. Measure the end of the COT up to the end of the terminal pointed tip 74mm using both hands.</p>  <p>3. Measure the end of the tape up to terminal pointed tip 35mm using both hands.</p>  <p>4. After taping, check the measurement, terminal appearance and taping condition.</p>	<b>MEASURING TAPE</b> 	<b>Important reminders/Note/s:</b>  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  1. Please use calibrated/verified measuring tape when getting the measurement  <b>Documents reminders/Note/s:</b>  1. Refer to WI-PRO-ASY-001 for taping procedure.  

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Model Code/Part Number: **200D / 7R0130-7022**

Customer: **TRMX**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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PARTS:

n/a

JIG

n/a



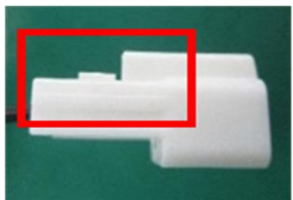
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P1

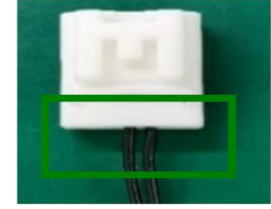
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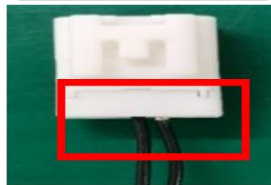
GOOD



NO GOOD



GOOD



NO GOOD

1 No Unlock/  
Halflocked Connector  
(2 connector)

2 3 No wrong insert

4 No Missing tape

5 No Terminal backing out

6 No Deformed terminal

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