



WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Product Name/Code: **100B / 7M0593-7020B** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

April 17, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-154B

Revision No.:

3

Page No.:

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PARTS:

1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

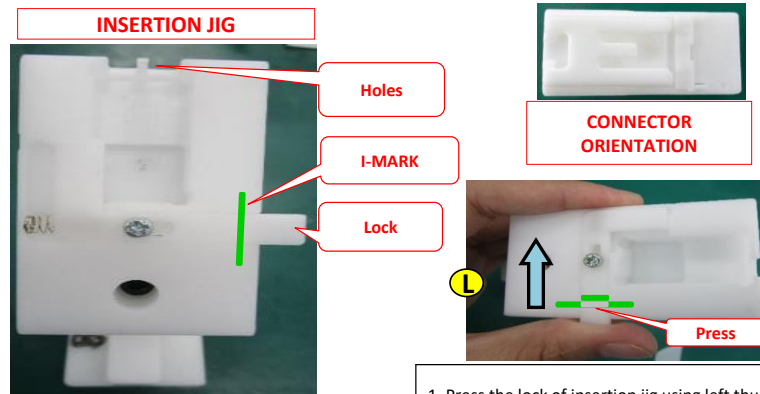
TOOLS/PPE

QUALITY POINTERS

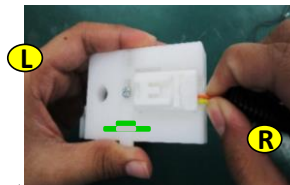
1

P2

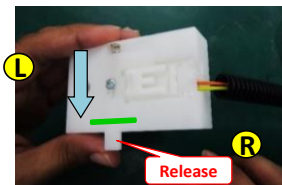
Connector setting to insertion jig (assy parts)
3 6098-3802 (W)



1. Press the lock of insertion jig using left thumb.



2. Insert the connector 6098-3802 (W) (assy parts) to insertion jig using right hand then release the lock using left hand.
Note: Follow the connector orientation



Release



3. Check the terminal holes for B/B wires.

Safety Instruction

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

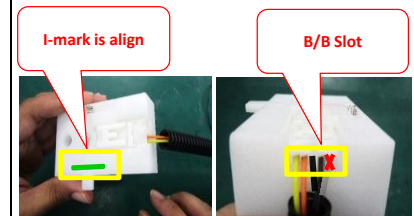
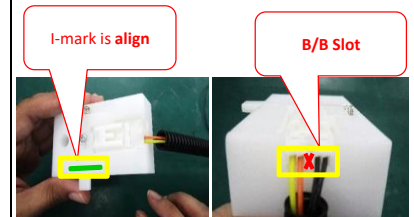
Housekeeping

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.

Connector Orientation Illustration



1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/17/21	3	Revise due to standardize the color of connector in accordance with color standardization of plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts). Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
09/30/20	2	Changed effectivity and validity date. Remove cycle time.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
04/10/18	0	Previously established as Engineering instruction. Initial issue	J. Loterte	R. Alcantara	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	April 10, 2018		

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☐ PRE-LAUNCH

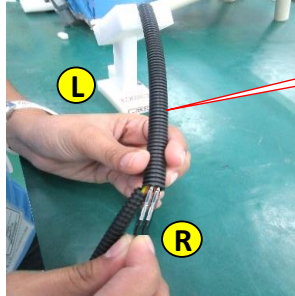
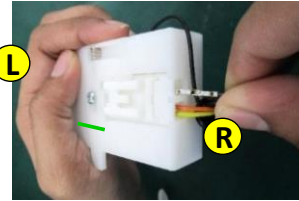
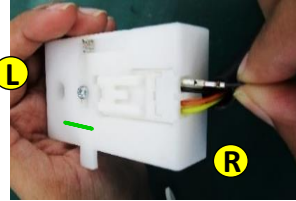

☒ MASSPRO

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PARTS:		JIG		
1. Assy parts 2. AVSSf 0.3 B/B wires L=749±3mm [2pcs.]		1. Insertion jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to assy parts	 <p>1. Get the B/B wires L=749±3mm using right hand then hold the COT Φ7 L=163±3mm (assy parts) using left hand then insert the wires using right hand.</p>	n/a	1. No wrong use of parts 2. No damaged terminal
3	Wire insertion to connector 6098-3802 (W)	  <p>1. Hold the insertion jig using left hand and insert the 1st B wire using right hand. Note: Insertion of wire must be from left to right.</p> <p>2. Hold the insertion jig using left hand and insert the 2nd B wire using right hand.</p>  <p>3. After insertion, press the lock using left hand and remove the connector from jig using right hand.</p>	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.

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PARTS:

1. Assy parts
2. Black tape

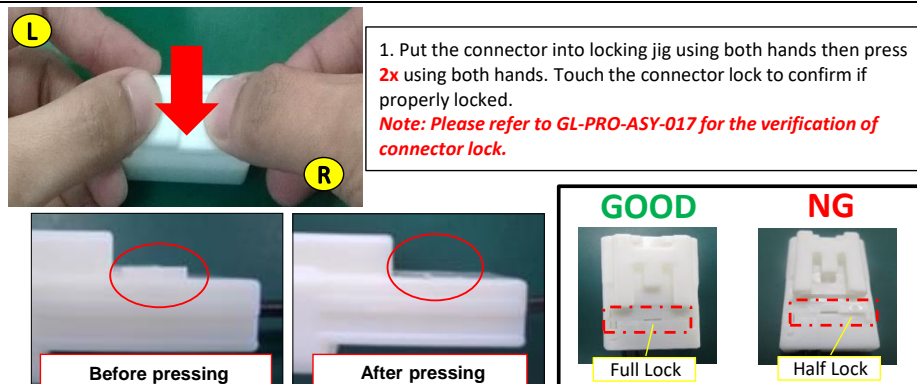
JIG

1. Locking jig

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

4

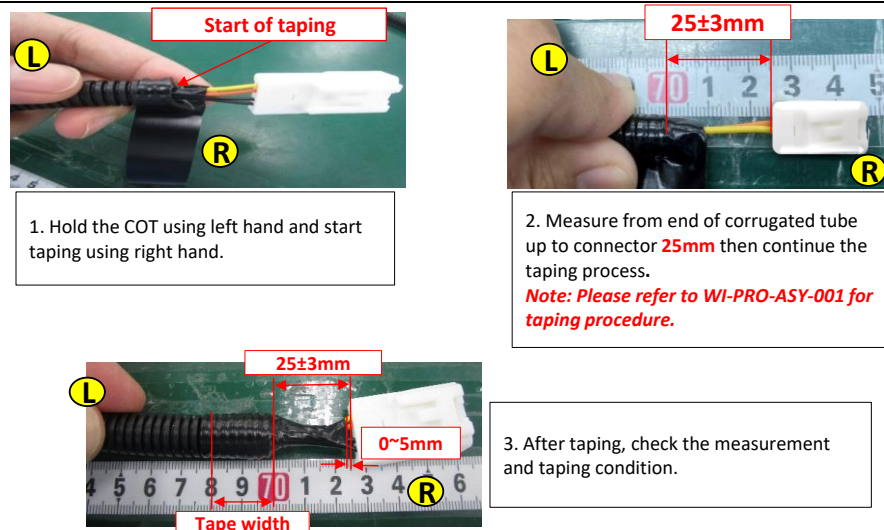
Connector Lock

**LOCKING JIG****NOTE:**
MANUAL LOCKING MAY CAUSE
DAMAGED LOCK.

1. Use the provided locking jig
2. No unlock/half-locked connector

5

P2

Taping 1
Black corrugated tube
(no slit)
to wire near connector**MEASURING TAPE****Note:**
Please use calibrated/verified
measuring tape when getting
the measurement.

1. No flip out tape
2. No tape peeling
3. No loose tape
4. No wrong use of tape
5. No wrong dimension

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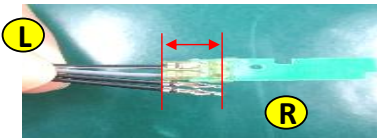
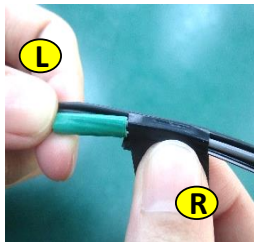
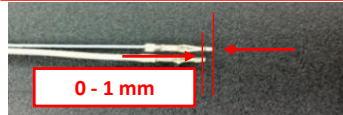
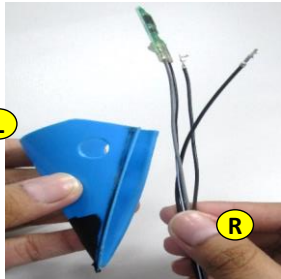
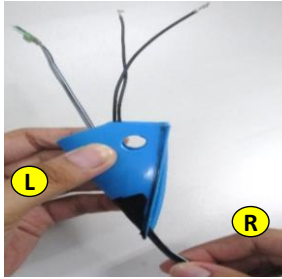
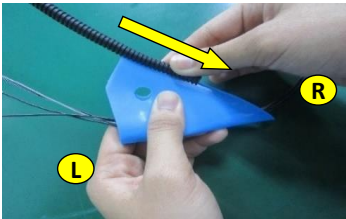

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PARTS:		1. Assy parts 2. Black tape 3. Black Corrugated tube (w/slit) $\varnothing 5$ L=410 \pm 4mm			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
6	Spot Taping	<div><div></div><div></div><div>2. Hold wires using left hand and begin taping using right hand. Tape location must be beside the BW/GR wire tape (Green tape). Make 2 winds then cut the tape. Check the wire alignment.</div></div> <div>1. Align the terminal pointed tip of hotmelted wires to B/B wires.</div>			n/a	<div>Wire alignment tolerance</div> <div></div> <div>1. No wrong use of tape</div>
7	P2 Wire insertion to Black Corrugated tube (w/slit) $\varnothing 5$ L=410 \pm 4mm	<div><div></div><div></div><div>1. Hold the COT adaptor using left hand and insert the wires using right hand.</div></div> <div><div></div><div>3</div><div>2. Hold the COT adaptor with wires using left hand, get the Black Corrugated tube (w/slit) $\varnothing 5$ L=410\pm4mm using right hand and then insert to COT adaptor. Push the adaptor and pull the COT (same timing) using both hands. Make sure all wires are inserted.</div></div>			<div>COT Adaptor</div> <div></div> <div>1. No wrong use of parts 2. No wires left in between the COT with slit</div>	

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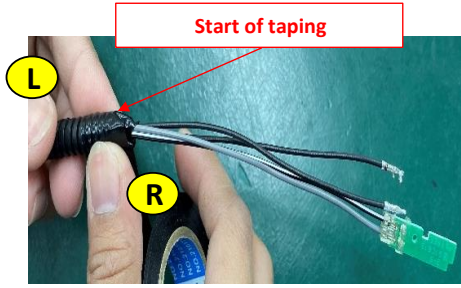
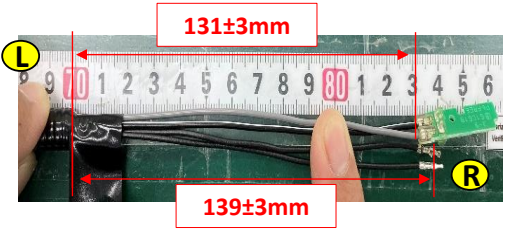
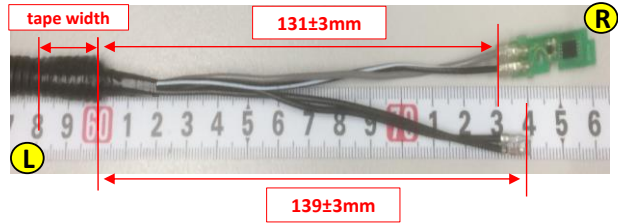

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P2 Taping 2 Black corrugated tube (with slit) to wire near terminal and hotmelted wire	 <p>Start of taping</p>  <p>131±3mm</p> <p>139±3mm</p>  <p>tape width</p> <p>131±3mm</p> <p>139±3mm</p> <p>3</p> <p>2. Measure from COT up to the hotmelted wire 131mm and COT up to terminal tip 139mm continue the taping process. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p> <p>3. After taping, check the measurement and taping condition.</p>	 <p>MEASURING TAPE</p>	<p><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No flip out tape2. No tape peeling3. No loose tape4. No wrong use of tape5. No wrong dimension

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