

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

Effectivity Date:

**September 17, 2021**Product Name/Code: **922B / 7L0123-7021**Customer: **TRQSS**

Validity Date:

**n/a**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-265B**

Revision No.:

**1**

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**1 of 8****PARTS:**

1. All parts (Connector 6098-3810 (W); B-B wires L=709±3mm; Black vinyl tube Ø7 L=95±3mm; Black tape; Red tape)

JIG:

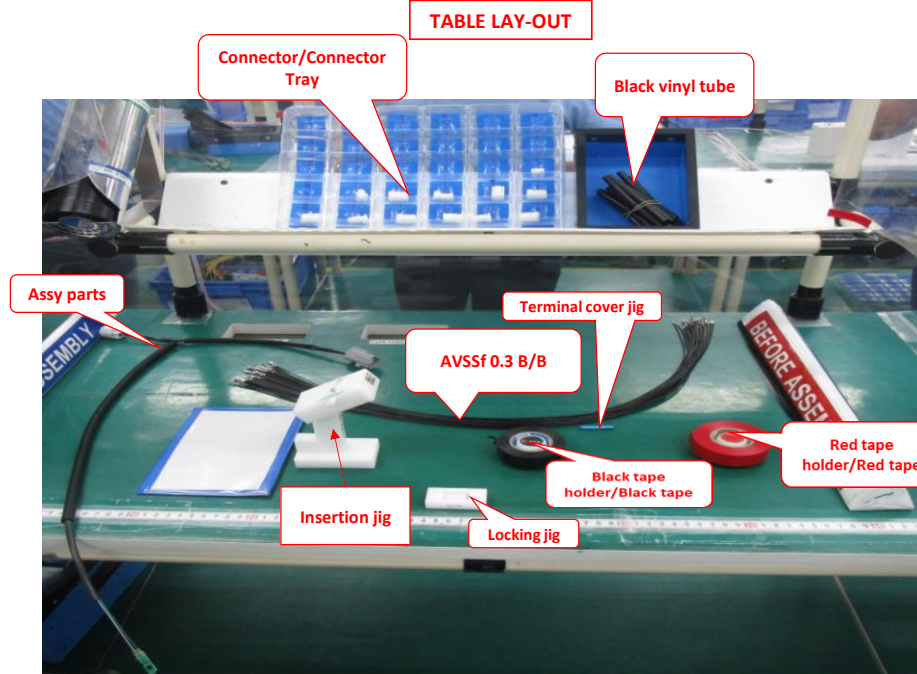
1. Insertion jig
2. Locking jig
3. Terminal cover jig

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

1

P2

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

**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
3. No wrong position of parts/tools

## Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Checked	Checked	Approved	Est. Date:	Prepared by	Reviewed by	Reviewed by	Noted by
09/17/21	1	Revise due to additional quality pointers on wire insertion process; Change pre-launch to masspro.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes					
06/04/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes		M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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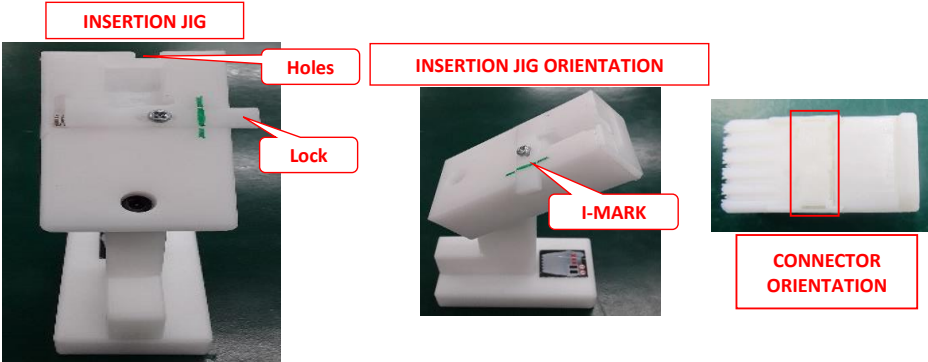
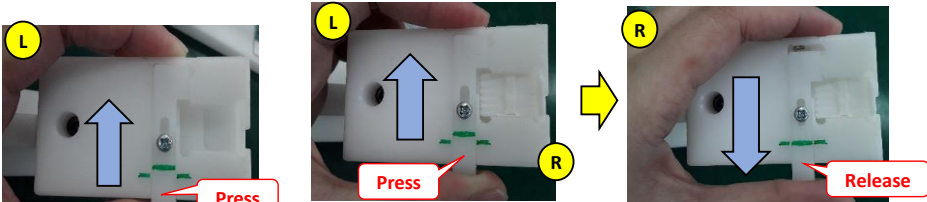

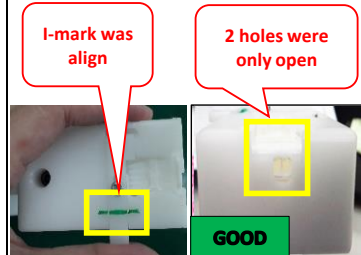

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PARTS:		1. Connector 6098-3810 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	<p>Connector setting to Insertion jig 6098-3810 (W)</p>   <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 6098-3810 (W) into jig using right hand and release the lock. <b>Note: Follow the connector orientation.</b></p>  <p>3. Check the holes/terminal slot for B/B wires.</p>		n/a	<p><b>Connector Orientation Illustration</b></p>   <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>

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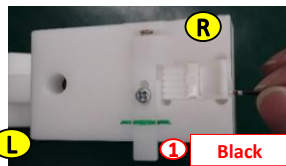

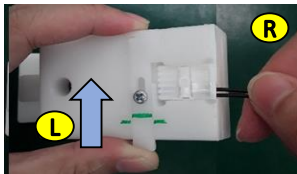






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PARTS:		1. AVSSf 0.3 wires B L=709±3mm [2pcs.]			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Wire insertion to connector 6098-3810 (W)	<div><div>WIRE FACING</div></div> <div><div>1. Get the <b>1st Black wire</b> then insert to connector slot <b>1</b> using right hand. <i>Note: insertion process must be from left to right.</i></div></div> <div><div>2. Get the <b>2nd Black wire</b> then insert to connector slot <b>2</b> using right hand.</div></div> <div><div>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.</div></div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Note: Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</div> <div>1 Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>
4		Connector lock	<div><div>Put the connector into locking jig using both thumb then press to lock <b>2x</b>. Check the connector lock if properly locked. <i>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</i></div></div> <div><div><div>Before Pressing</div></div><div><div>After Pressing</div></div><div><div><div>GOOD Fully Locked</div></div><div><div>NG UnLocked</div></div></div></div>		<div>LOCKING JIG</div> 	<div>Note: MANUAL LOCKING MAY CAUSE</div> <div>1. Use the provided locking jig per model 2. No unlock/half-lock connector</div>

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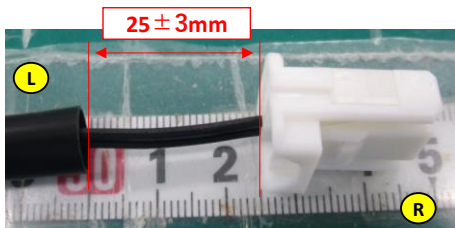
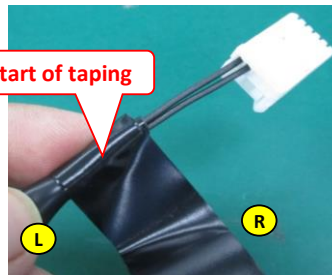
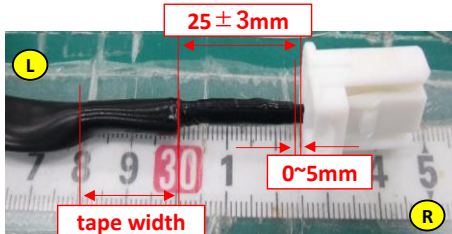

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PARTS:		1. Assy parts 2. Black vinyl tube Ø7 L=95±3mm 3. Black tape		JIG	n/a	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to Black vinyl tube Ø7 L=95±3mm		<div><div></div><div>1. Get the black vinyl tube <b>Ø7 L=95 ± 3mm</b> using right hand and insert the wires.</div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal
6	P2	Taping 1 Vinyl tube to wire near connector	<div><div><div></div><div>1. Measure from end of vinyl tube up to edge of connector <b>25±3mm</b> using both hands.</div></div><div><div></div><div>2. Get the <b>Black tape</b> using right hand then start taping process using both hands. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></div></div><div><div><div></div><div>3. After taping, check the measurement and taping condition.</div></div></div></div>		<div><div>MEASURING TAPE</div></div>	<div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</div>

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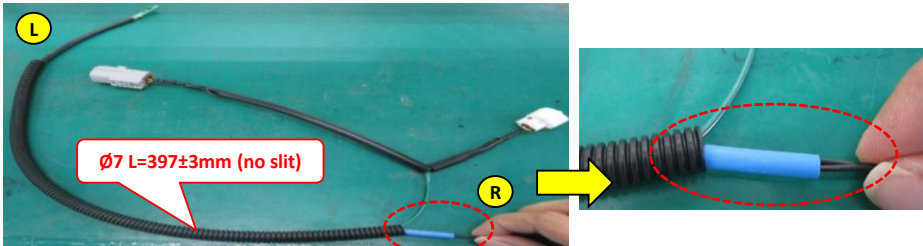
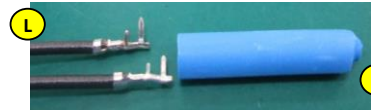

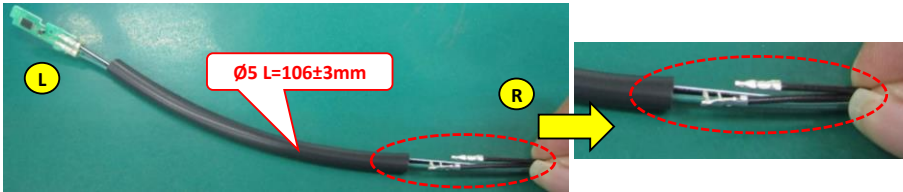
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PARTS:		1. Assy parts			JIG	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
7	P2	Wire insertion to assy parts ( Black corrugated tube Ø7 L=397±3mm) (no slit)	<div><div>1. Get the cover jig then insert to <b>B/B wires</b> using right hand.</div></div> <div><div>2. Hold the corrugated tube <b>Ø7 L=397±3mm (no slit)</b> using left hand then insert the assy parts using right hand.</div></div> <div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div>	<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No wrong insertion	
8		Wire insertion to assy parts (Black sunprene tube Ø5 L=106±3mm)	<div><div>1. Hold the Black sunprene tube <b>Ø5 L=106±3mm</b> using left hand then continue to insert the assy parts using right hand.</div></div>	n/a	1. No wrong usage of parts 2. No wrong insertion	

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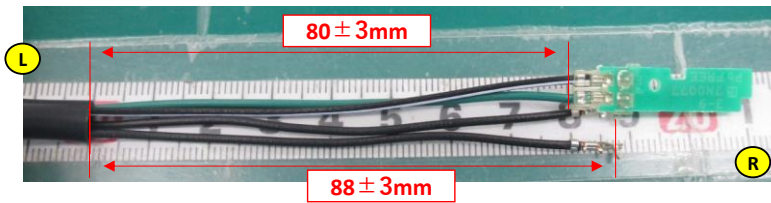
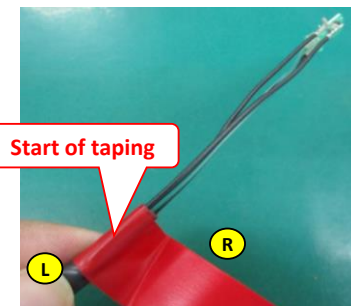
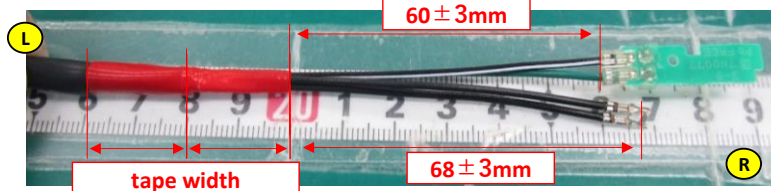

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PARTS:		1. Assy parts 2. Red tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P2 Taping 2 Black sunprene tube to wire near hotmelted wires and terminal pointed tip	 <p>1. Measure from end of sunprene tube up to edge of hotmelted wire <math>80\pm 3\text{mm}</math> and up to terminal pointed tip <math>88\pm 3\text{mm}</math> using both hands.</p>  <p>2. Get the <b>Red tape</b> using right hand then start taping process using both hands. <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><b>MEASURING TAPE</b></p> 	<p><b>NOTE:</b> <b>USE RED TAPE only.</b></p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p> <p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p>

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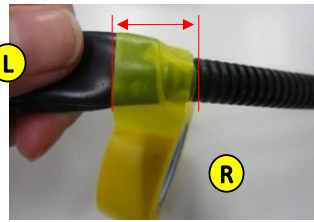
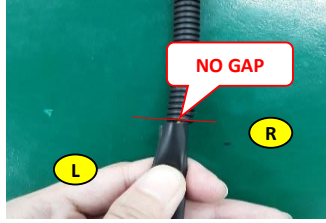
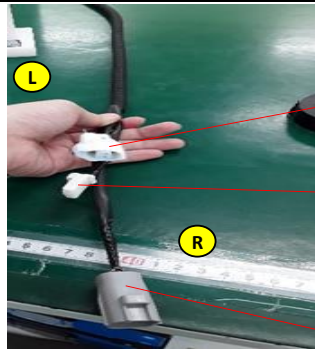
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NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P2	Y-Taping	<div><p>1. Conduct harness facing using both hands.</p><p>2. Fix the vinyl tube and corrugated tube. Make sure that there is no gap in between.</p><p>3. Get the <b>BLACK tape</b> using right hand then make <b>1 wind pre-taping</b> at the center of vinyl tube and corrugated tube using both hands. <b>Note: Do not exert extra force during taping</b></p></div>		n/a	<div><p><b>NOTE:</b> USED <b>YELLOW TAPE</b> FOR EASY VISUALIZATION OF SHIFTING LINES. BUT ACTUAL SHOULD BE <b>BLACK</b>.</p><p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p></div>

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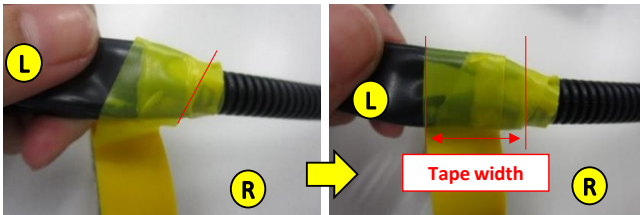
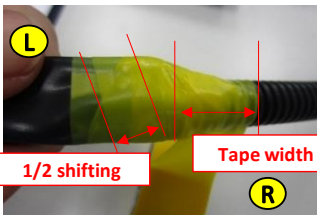
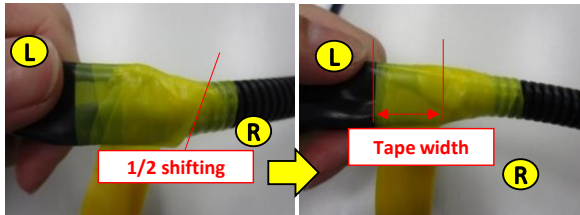
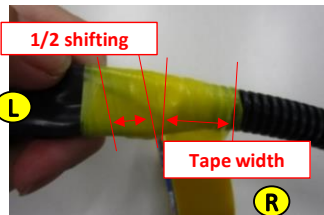
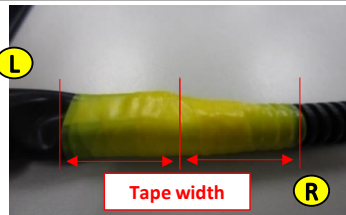

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P2 Y-Taping (Continuation)	<div><p>4. Make <b>1/3 shifting</b> going to vinyl tube until tape width then make <b>1 winding</b> of tape before shifting.</p></div> <div><p>5. Make <b>1/2 shifting</b> going to COT until tape width then make <b>1 winding</b> of tape before shifting.</p></div> <div><p>6. Make <b>1/2 shifting</b> going to vinyl tube until tape width then make <b>2 windings</b> of tape before final shifting.</p></div> <div><p>7. Make <b>1/2 shifting</b> going to COT until tape width then make <b>2 windings</b> of tape then cut the tape.</p></div> <div><p>8. After taping, check the measurement and taping condition.</p></div>	<div><b>MEASURING TAPE</b></div> 	<p><b>NOTE:</b> USED <b>YELLOW TAPE</b> FOR EASY VISUALIZATION OF SHIFTING LINES. BUT ACTUAL SHOULD BE <b>BLACK</b>.</p> <ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong use of tape</li><li>6. No wrong dimension</li></ol>

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