



WORK INSTRUCTION

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

Model Code/Part Number: **910B / 7L0126-7023** Customer: **TRQSS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

April 17, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-636A

Revision No.:

1

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PARTS:

1. All parts: Connector 6189-0451 (W); AVSSf 0.3 Y-OR wires L=329±2mm; AVSSf 0.3 G-B wires L=709±3mm; AVSSf 0.3 V wire L=807±3mm; Black SV tube (Vinyl) Ø7 L=56±3mm; Black SV tube (Vinyl) Ø7 L=189±3mm; Connector 6188-0066 (GR); Black SV tube (Vinyl) Ø7 L=94±3mm; Black tape [1pc.]

JIG:

1. Insertion jig with switch cover
2. Insertion jig
3. Locking jig
4. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

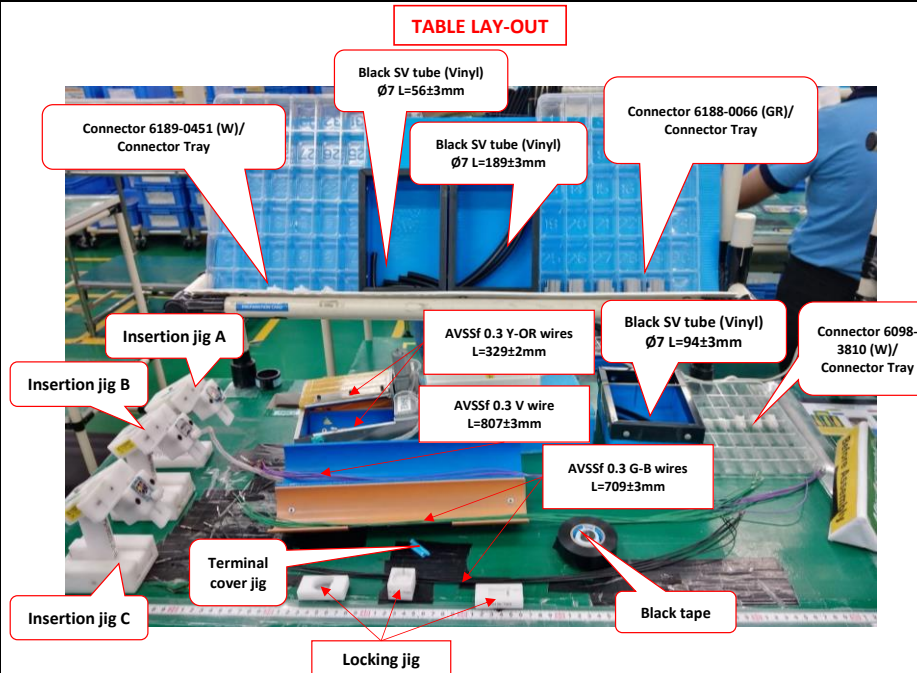
TOOLS/PPE

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.

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/17/23	1	Document purpose from prelaunch to masspro. Change taping: From VM tube sunprene to wire near terminal to Spot taping (Brown tape). Additional table layout. Improve work procedure due improvement. Align quality checkpoints to finished assy parts.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
03/02/23	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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PARTS:

1. Connector 6189-0451 (W)

JIG

1. Insertion jig with switch cover

NO.

PROCESS NAME

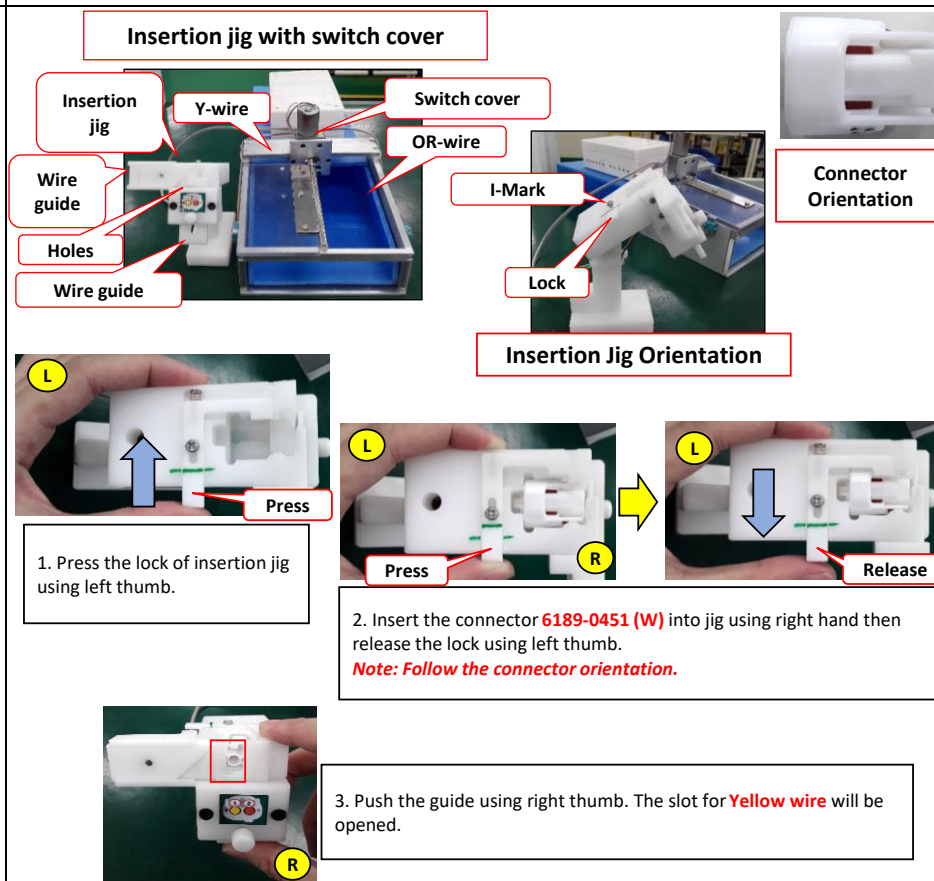
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P1

Connector setting to
insertion jig
6189-0451 (W)

n/a

Connector Orientation
IllustrationI-mark is
align

1 hole is open

GOOD

I-mark is
NOT align

1 hole is open

NG

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

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PARTS:

1. Assy parts

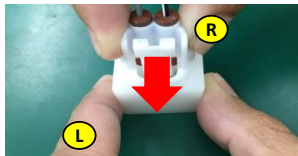







2. Black SV tube (Vinyl) Ø7 L=56±3mm

3. Black SV tube (Vinyl) Ø7 L=189±3mm

JIG

1. Locking jig

2. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Connector lock	   1. Put the connector into locking jig using right hand then press 2x . Touch the connector lock if properly locked.		Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR 1. Use the provided locking jig per model 2. No unlock/half-lock connector
5	Wire insertion to Black SV tube (Vinyl) Ø7 L=56±3mm Ø7 L=189±3mm	   1. Get the cover jig then insert to Y-OR wires using right hand. 2. Get the Black SV tube (Vinyl) Ø7 L=56±3mm using right hand then insert the Y-OR wires using left hand. 3. Get the Black SV tube (Vinyl) Ø7 L=189±3mm using right hand then insert the Y-OR wires using left hand. 4. After insertion, remove the cover jig using right hand.		1. No wrong usage of parts 2. No damaged rubber seal

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

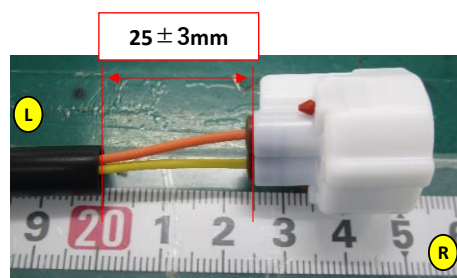
TOOLS/PPE

QUALITY POINTERS

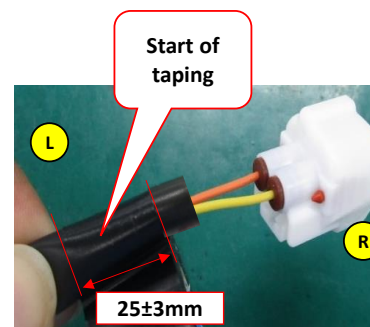
6

P1

Taping 1
Black SV tube (Vinyl) to
wire near connector

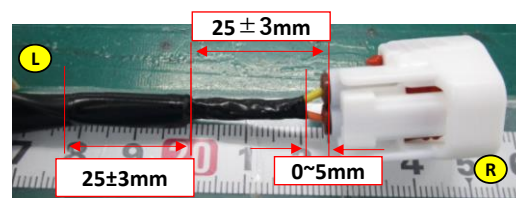


1. Measure from end of Black SV tube (Vinyl) up to edge of connector $25 \pm 3\text{mm}$ using both hands.



2. Get the **Black tape** using right hand then start taping process using both hands.

MEASURING TAPE



3. After taping, check the measurement, wire alignment and taping condition.

**NOTE: SET ASIDE THE
ASSY PARTS**

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 use of tape
6. No wrong dimension

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PARTS:

1. Connector 6188-0066 (GR)

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

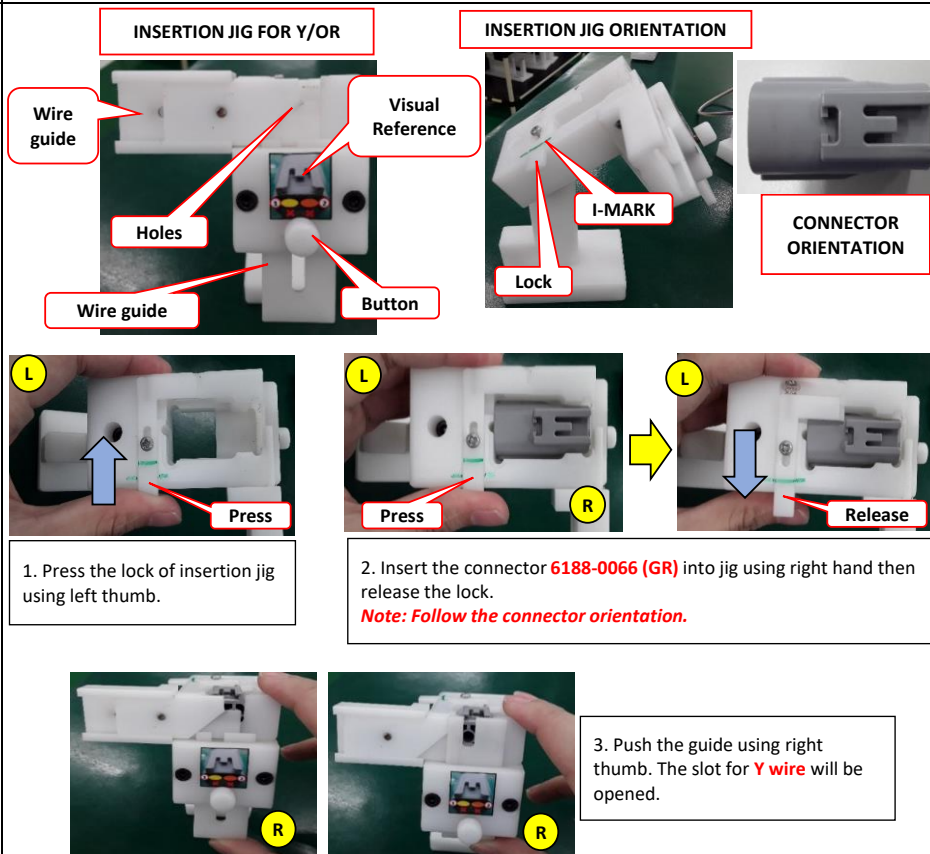
TOOLS/PPE

QUALITY POINTERS

7

P1

Connector setting to
insertion jig
6188-0066 (GR)



n/a

Connector Orientation Illustration

I-mark
is align

1 hole is open

GOOD

I-mark is
NOT align

2 holes are
open

NG

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

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

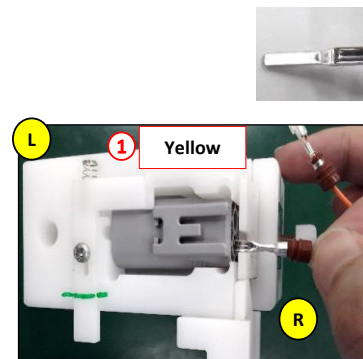
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

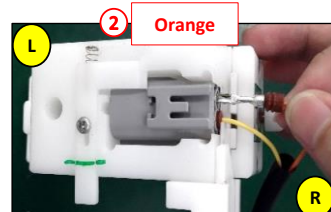
QUALITY POINTERS

8

P1

Wire insertion to Connector
6188-0066 (GR)

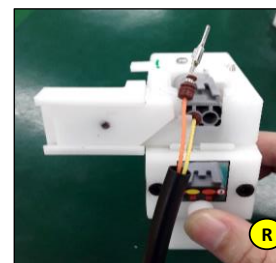
1. Hold the insertion jig using left hand. Get the assy parts, insert the **Yellow wire** to connector slot **1** using right hand.



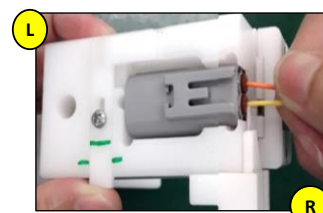
3. Get **Orange wire** then insert to connector slot **2** using right hand.



WIRE FACING



2. Press the button using right thumb, slot for **Orange wire** will be opened.



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. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deform terminal
5. No wrong wire facing

Important reminders/Note/s:

1. **Please hold the wire near terminal.**
2. **Make sure wires are properly inserted.**
- Conduct **Pull-Push-Pull-Push** after insertion.
- Do not exert extra force.**
3. **Insertion of wires must be from left to right**

Document references:

1. **Refer to GL-PRO-ASY-029 for Pull-Push procedure.**

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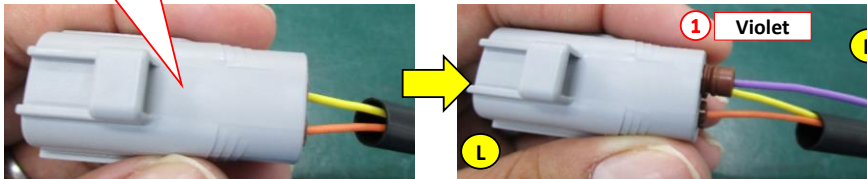
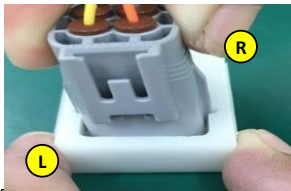





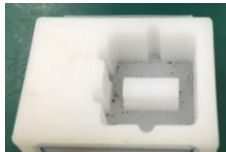
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PARTS:

1. Assy parts
2. AVSSf 0.3 V wire L=807±3mm

JIG

1. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	Wire insertion to connector 6188-0066 (GR)	<div><div>CONNECTOR ORIENTATION</div><div><div>WIRE FACING</div></div><div></div><div><div>1. Get the Violet wire L=807±3mm then insert to empty slot using right hand. Note: Follow the connector orientation.</div></div></div>	n/a	<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please hold the wire near terminal.2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.3. Insertion of wires must be from left to right <p>Document references:</p> <ol style="list-style-type: none">1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
10	Connector Lock	<div><div></div><div><div>1. Put the connector into locking jig using right hand then press 2x. Touch the connector lock if properly locked.</div></div><div><div><div>BEFORE PRESSING</div></div><div><div>AFTER PRESSING</div></div></div><div><div>Connector Cross Sectional View</div><div><div>NG</div><div>NG</div><div>GOOD</div></div><div><div><div>Unlock Condition</div></div><div><div>Half Lock Condition</div></div><div><div>Full Lock Condition</div></div></div></div></div>	<div>Locking jig</div> <div></div>	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR <ol style="list-style-type: none">1. No wrong usage of parts2. No damaged rubber seal

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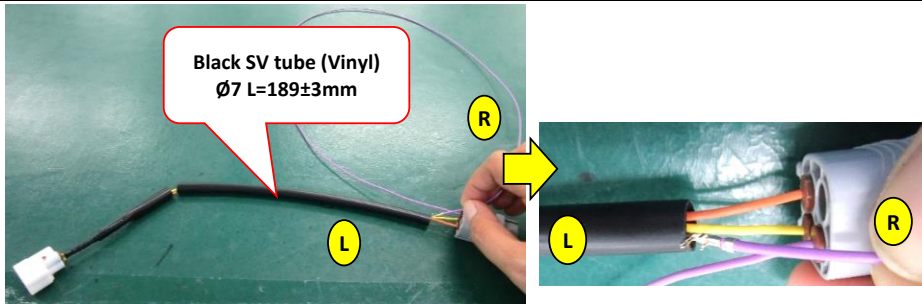

1. Assy parts

2. AVSSf 0.3 G-B wires L=709±3mm

3. Black SV tube (Vinyl) Ø7 L=94±3mm

JIG

n/a

NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	Wire insertion to assy parts Black SV tube (Vinyl) Ø7 L=189±3mm	 <p>1. Hold the Violet wire using right hand, hold the Black SV tube (Vinyl) Ø7 L=189±3mm using left hand then insert the Violet wire using right hand.</p> <p>NOTE: SET ASIDE THE ASSY PARTS</p>	n/a	1. No wrong insertion of parts 2. No deformed terminal
12	Wire insertion to Black SV tube (Vinyl) Ø7 L=94±3mm	 <p>1. Get the Black Vinyl tube Ø7 L=94±3mm using left hand then insert the G-B wires L=709±3mm using right hand.</p>	n/a	1. No wrong usage of parts 2. No damaged rubber seal

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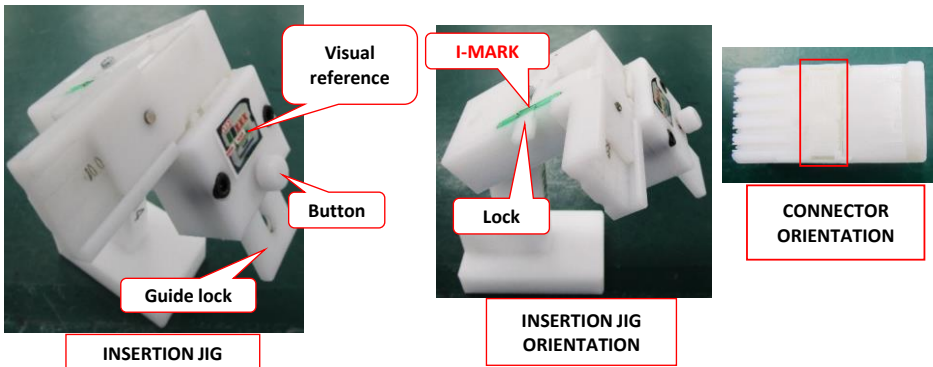
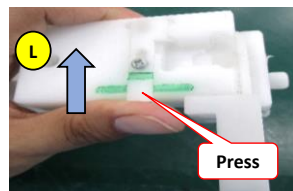
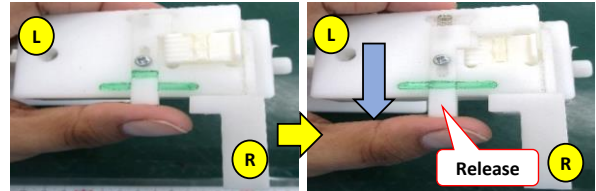
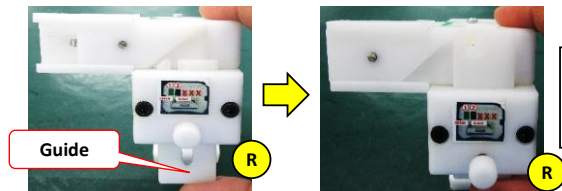
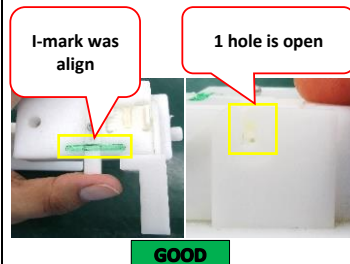
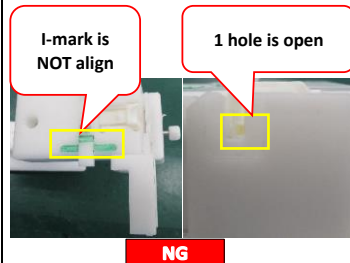
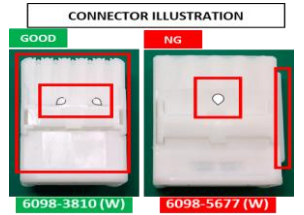
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PARTS:

1. Connector 6098-3810 (W)

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
13	P1 Connector setting to insertion jig 6098-3810 (W)	 <p>INSERTION JIG</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. <i>Note: Follow the connector orientation.</i></p>  <p>3. Push the guide using right hand. The slot for Green wire will be opened.</p>	n/a	<p>Connector Orientation Illustration</p>  <p>GOOD</p>  <p>NG</p> <p>CONNECTOR ILLUSTRATION</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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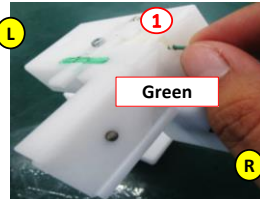

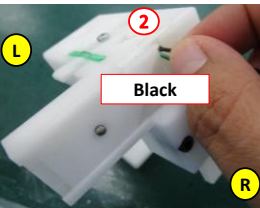
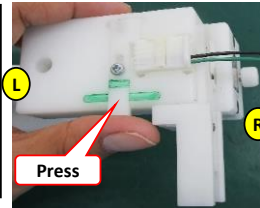
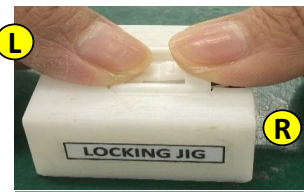
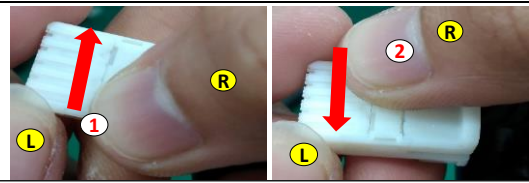
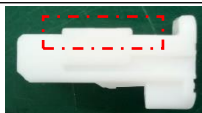


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PARTS:		1. Assy parts			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	P1	Wire insertion to Connector 6098-3810 (W)	<div><div><p>WIRE FACING</p></div><div><p>1. Hold the insertion jig using left hand, get Green wire and insert to connector slot 1 using right hand.</p></div><div><p>2. Press the button using right thumb, slot for Black wire will be opened.</p></div><div><p>3. Hold the insertion jig using left hand, get Black wire and insert to connector slot 2 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></div> <div>n/a</div> <td><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>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 3. Insertion of wires must be from left to right</p><p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p></td>		<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>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 3. Insertion of wires must be from left to right</p> <p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>	
15		Connector lock	<div><p>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</p></div> <div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div> <div><p>Before Pressing</p></div> <div><p>After Pressing</p></div>		<div><p>LOCKING JIG</p></div>	<p>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided locking jig per model 2. No unlock/half-lock connector</p>

1. Use the provided locking jig per model
2. No unlock/half-lock connector

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PARTS:

1. Assy parts

JIG

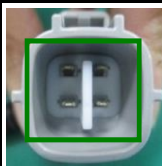
n/a



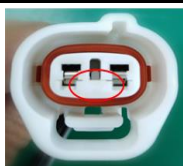
QUALITY CHECKPOINTS

P1

7L0126-7023



GOOD



GOOD



NO GOOD



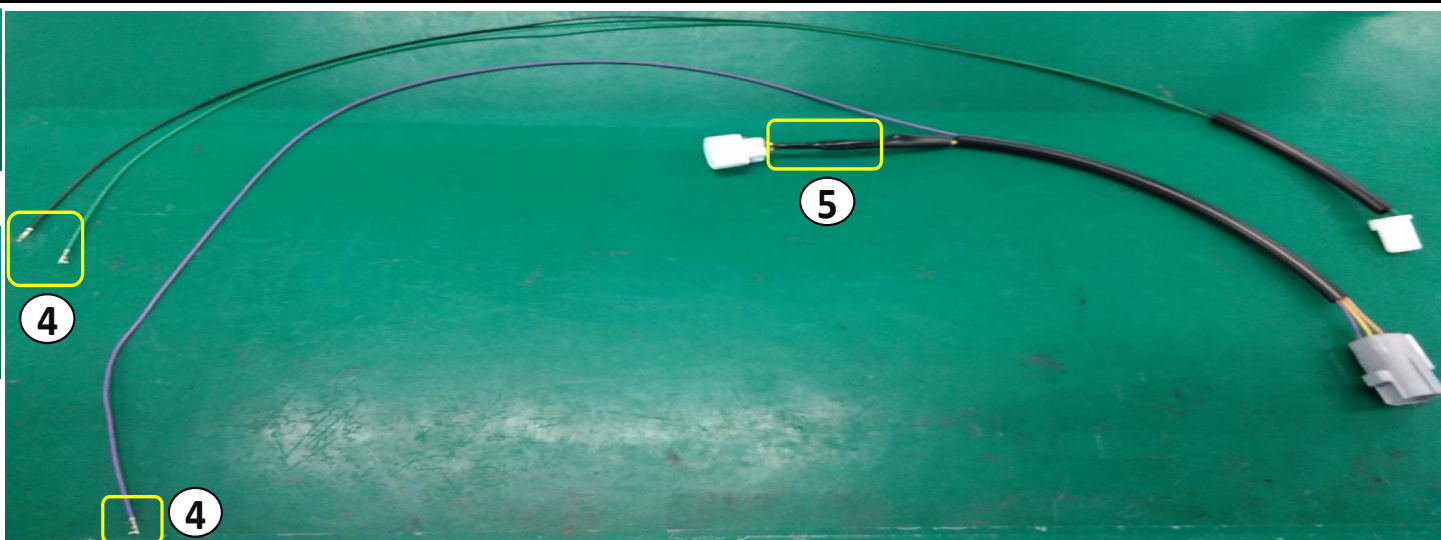
NO GOOD



GOOD



NO GOOD



GOOD



NO GOOD

1 No Unlock/Halflock Connector
(on 3 connector)

2 No Wrong Insert (on 3 connector)

3 No Missing Dummy Seal

4 No Deformed Terminal

5 No Missing Tape

6 No Terminal Backing Out

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