

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

Effectivity Date:

**January 13, 2023**Model Code/Part Number: **300D / 7N0124-7020**Customer: **TRJ**

Validity Date:

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

Document No.:

**WI-ENG-PDE-604A**

Revision No.:

**1**

Page No.:

**1 of 10****PARTS:**

1. All parts: Connector 6098-3802 (W); AVSSf 0.3 wires V-B L=816±3mm; Black COT (no slit) ø5 L=239±3mm; AVSSf 0.3 wires G L=668±3mm; Black COT (no slit) ø5 L=90±3mm; Connector 6098-3810 (W); Black corrugated tube (no slit) ø5 L=414±4mm; Black tape

JIG:

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

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****1 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

**Revision History**

Prepared by

Reviewed by

Approved by

Noted by

01/13/23

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. Catapang

J. Loterte

C. Villanueva

A. Arañes

12/09/22

0

Initial issue

M. Catapang

J. Loterte

C. Villanueva

A. Arañes

Eff. Date

Rev. No.

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

December 09, 2022

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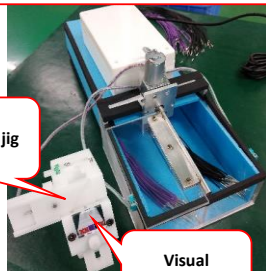
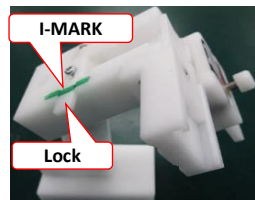


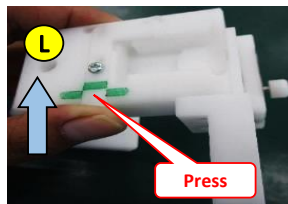
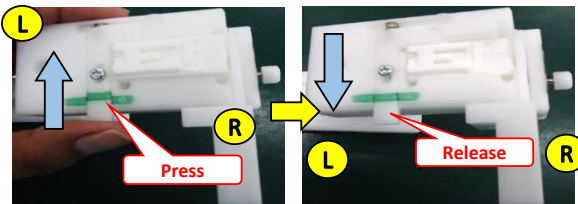
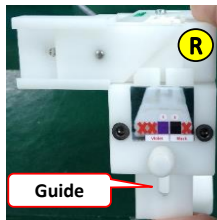
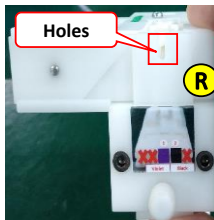
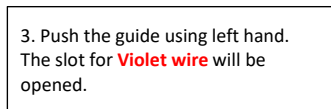



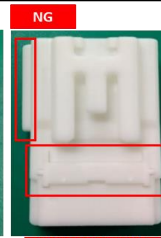



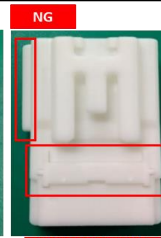
## TAPING ASSEMBLY PROCESS

Effectivity Date:	January 13, 2023		
Validity date	n/a		
Document No.:	WI-ENG-PDE-604A		
Revision No.:	1	Page No.:	2 of 10

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

Model Code/Part Number: **300D / 7N0124-7020** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

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

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


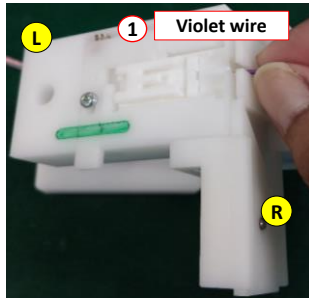
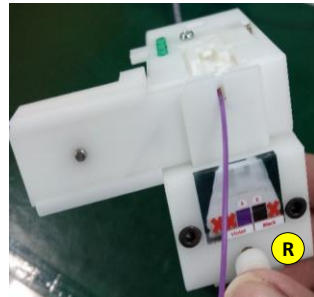
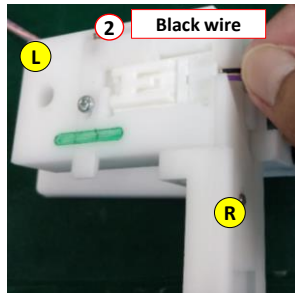
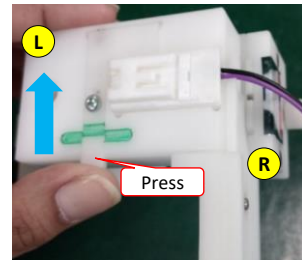
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PARTS:		1. AVSSf 0.3 wires V-B L=816±3mm		JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
3	P1 <div>1</div> Wire insertion to connector 6098-3802 (W)	<div><div></div><div><div></div><div></div><div></div><div></div></div><div><p>1. Hold the insertion jig using left hand. Get the <b>Violet wire</b> then insert to terminal slot <b>1</b> using right hand.</p><p>2. Press the button using right thumb. The slot for <b>Black wire</b> will be opened.</p><p>3. Get the <b>Black wire</b> then insert to terminal slot <b>2</b> using right hand.</p><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>		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><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div> <div><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></div>

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☐ PROTOTYPE

☐ PRE-LAUNCH


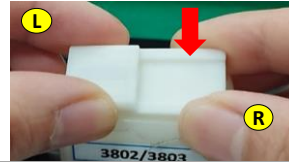



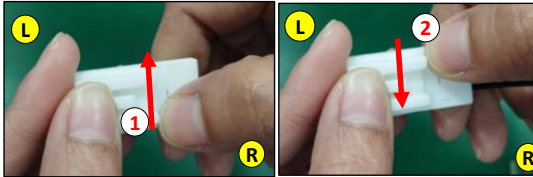

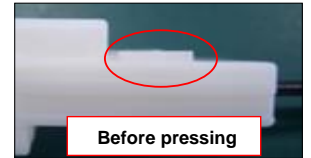


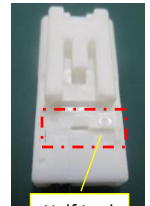
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PARTS:		1. Assy parts		JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
4	P1 Connector Lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. 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>		 <p>LOCKING JIG</p>	<div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><div><p>Full Lock</p></div><div><p>Half Lock</p></div></div> <p><b>GOOD</b> <b>NG</b></p> <p><b>Important reminders/Note/s:</b> <b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></p> <p>1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector</p>

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Purpose:



PROTOTYPE



PRE-LAUNCH




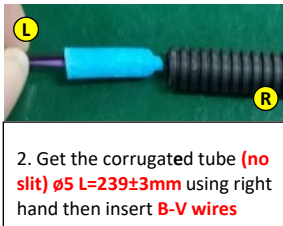


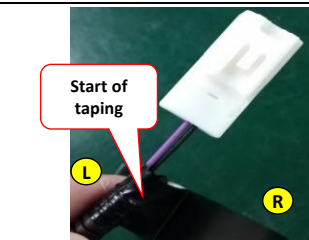
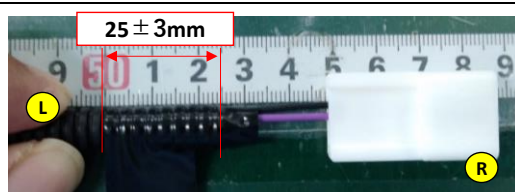
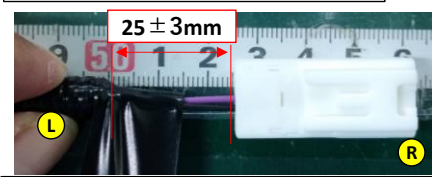
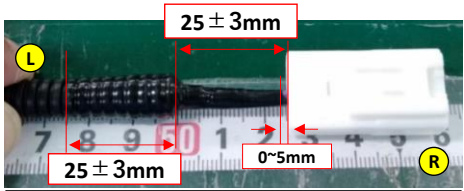

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PARTS:		1. Assy parts 2. Black COT (no slit) $\phi 5$ L=239 $\pm$ 3mm	3. Black tape	JIG	1. Terminal cover jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
5	1 Wire insertion to Black corrugated tube $\phi 5$ L=239 $\pm$ 3mm (no slit)	 1. Get the terminal cover jig using right hand then insert the B-V wires using left hand.  2. Get the corrugated tube (no slit) $\phi 5$ L=239 $\pm$ 3mm using right hand then insert B-V wires using left hand.  3. After insertion, remove the terminal cover jig using right hand.		TERMINAL COVER JIG 	1. No wrong use of parts 2. No deformed terminal
6	P1 Taping 1 Black COT to wire near connector	 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 $\pm$ 3mm from end of tape up to COT then continue the taping process using both hands.  3. Measure from end of COT up to edge of connector 25 $\pm$ 3mm then continue the taping process using both hands.  4. After taping, check the measurement and taping condition. <b>NOTE: SET ASIDE THE ASSY PARTS</b>		MEASURING TAPE 	<b>Important reminders/Note/s:</b> 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

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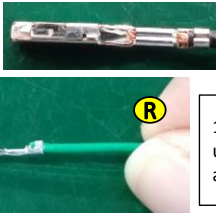
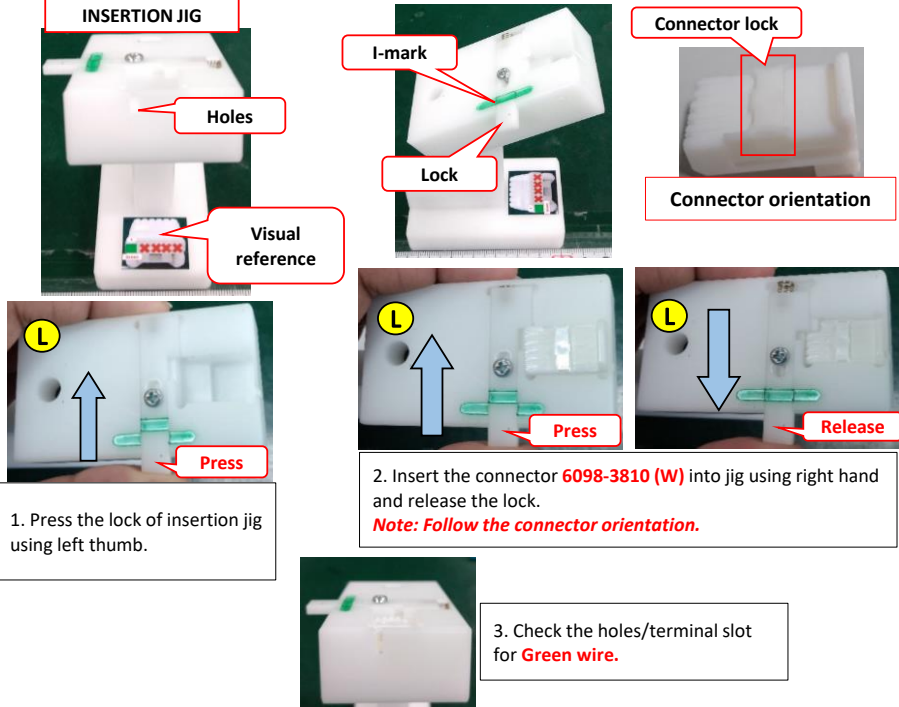
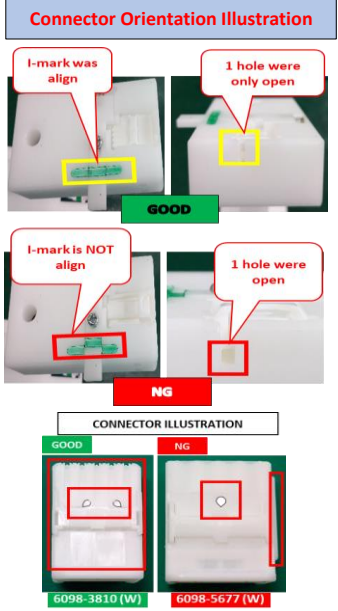
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	Model Code/Part Number: <b>300D / 7N0124-7020</b>		Customer: <b>TRJ</b>	Document No.:		<b>WI-ENG-PDE-604A</b>	
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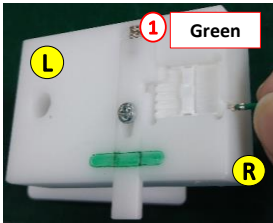
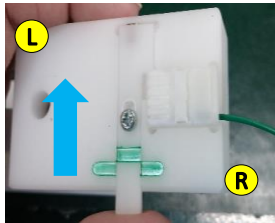

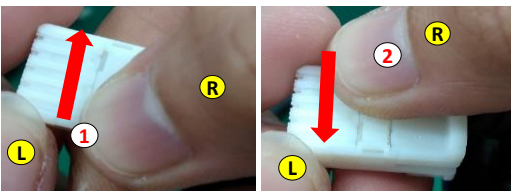

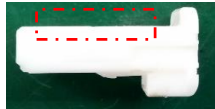

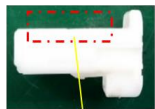
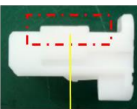
<b>PARTS:</b>	1. AVSSf 0.3 wires G L=668±3mm 2. Black COT (no slit) ø5 L=90±3mm 3. Connector 6098-3810 (W)			<b>JIG</b>	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>1 WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>1 QUALITY POINTERS</b>	
7	Wire insertion to Black corrugated tube ø5 L=90±3mm (no slit)	 <p><b>Wire facing</b></p> <p>1. Get the corrugated tube (no slit) ø5 L=90±3mm using left hand then get the G L=668±3mm wires and insert using right hand.</p>	n/a	1. No wrong use of parts 2. No deformed terminal  <b>Document reference/s:</b> 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance	
8	Connector setting to insertion jig 6098-3810 (W)	<p><b>1</b></p> <p>P1</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>Green wire</b>.</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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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:	7 of 10

<b>PARTS:</b>	1. Assy parts		<b>JIG</b>	1. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
9	<div>1</div> Wire insertion to connector 6098-3802 (W)	 <div>Wire facing</div>  <div>1. Get the <b>Green wire</b> then insert to terminal slot <b>1</b> using right hand.</div>  <div>4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div>	n/a	<div>1</div> <ol style="list-style-type: none"> <li>No loose insertion</li> <li>No wrong insertion</li> <li>One by one insertion</li> <li>No deform terminal</li> <li>No wrong wire facing</li> </ol> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"> <li><b>Please hold the wire near terminal.</b></li> <li><b>Make sure wires are properly inserted.</b></li> </ol> <p><b>Conduct Pull-Push-Pull-Push after insertion.</b></p> <p><b>Do not exert extra force.</b></p> <ol style="list-style-type: none"> <li><b>Insertion of wires must be from left to right</b></li> </ol> <p><b>Document references:</b></p> <ol style="list-style-type: none"> <li><b>Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></li> </ol>
10	<div>P1</div> <div>1</div> Connector lock	 <div>1. Put the connector into locking jig using right hand then press <b>2x</b> using both hands. Touch the connector lock to confirm if properly locked.</div>  <div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div> <div>  <div>Before Pressing</div>  <div>After Pressing</div> </div>	<div>LOCKING JIG</div> 	<p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"> <li><b>MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></li> </ol> <ol style="list-style-type: none"> <li>Use the provided locking jig per model</li> <li>No unlock/half-locked connector</li> </ol> <div>CONNECTOR LOCK CONDITION</div> <div> <div> <div>GOOD</div>  <div>Fully Locked</div> </div> <div> <div>NG</div>  <div>UnLocked</div> </div> </div>

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**WI-ENG-PDE-604A**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

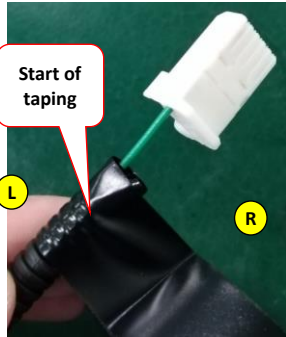
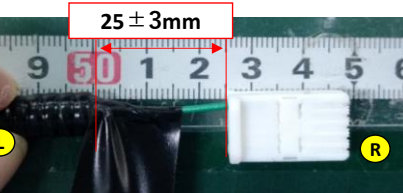
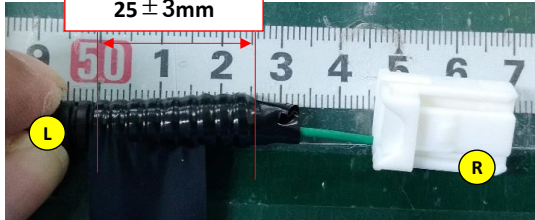

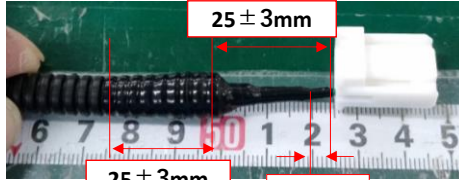

☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	1 QUALITY POINTERS
11	P1  Taping 2 Black COT to wire near connector	<div><p>Start of taping</p></div> <div><p>25 ± 3mm</p></div> <div><p>25 ± 3mm</p></div> <div><p>2. Confirm measurement of <b>25±3mm</b> from end of tape up to COT then continue the taping process using both hands.</p></div> <div><p>25 ± 3mm</p></div> <div><p>3. Measure from end of COT up to edge of connector <b>25±3mm</b> then continue the taping process using both hands.</p></div> <div><p>25 ± 3mm 0~5mm</p></div> <div><p>4. After taping, check the measurement and taping condition.</p></div>		<p>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</p> <p><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p>

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**WORK INSTRUCTION**

Effectivity Date:

January 13, 2023

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity date

n/a

Model Code/Part Number:

**300D / 7N0124-7020**

Customer:

**TRJ**

Document No.:

**WI-ENG-PDE-604A**

Purpose:



PROTOTYPE



PRE-LAUNCH




MASSPRO

Revision No.:

1

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PARTS:		1. Assy parts 2. Black tape		3. Black corrugated tube (no slit) ø5 L=414±4mm		JIG	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
12	<div><div>1</div><div>Wire insertion to Black corrugated tube ø5 L=414±4mm (no slit)</div></div> <div>P1</div>		<div><div><div><div>L</div><div>R</div></div><div>1. Combine the 2 assy parts then hold the wires using left hand, get the terminal cover jig using right hand then insert the <b>B-V-G wires</b> using left hand.</div></div><div><div><div>L</div><div>R</div></div><div>2. Get the corrugated tube <b>(no slit) ø5 L=414±4mm</b> using right hand then insert the <b>B-V-G wires</b> using left hand.</div></div><div><div><div>L</div><div>R</div></div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div></div>			<div>TERMINAL COVER JIG</div> <div></div>	1. No wrong use of parts 2. No deformed terminal

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WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Effectivity Date:	January 13, 2023		
Validity date	n/a		
Document No.:	WI-ENG-PDE-604A		
Revision No.:	1	Page No.:	10 of 10

Process Name/Title:  
Model Code/Part Number: **300D / 7N0124-7020** Customer: **TRJ**  
Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

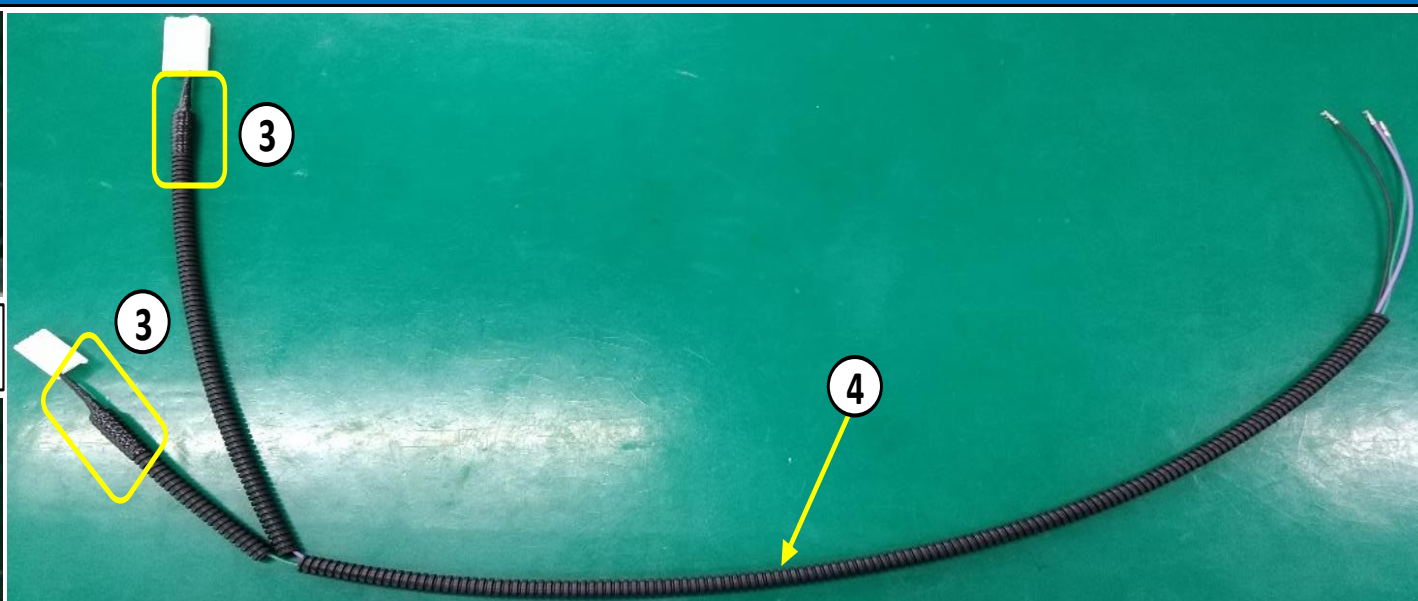
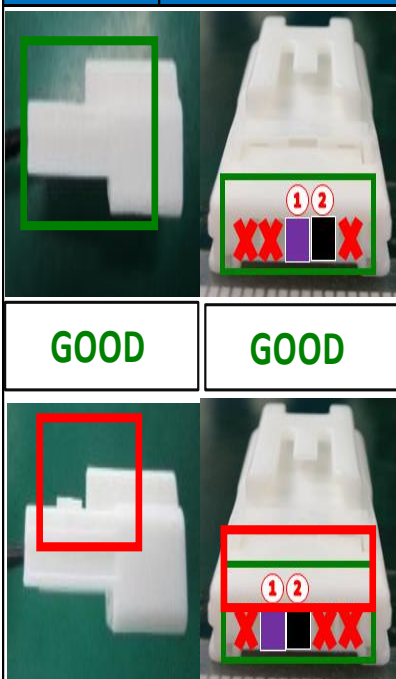
PARTS: 1. Assy parts

JIG n/a

1 QUALITY CHECKPOINTS

P1

7N0124-7020



1 2 No **WRONG INSERT**  
No **TERMINAL BACKING OUT**

3 No **MISSING TAPE** 4 No **MISSING COT**

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