



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 18, 2021

Process Name/Title:

Product Name/Code: 291B / 7L0036-7020

Customer:

TRQSS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-198A

Revision No.:

2

Page No.:

1 of 4

PARTS:

- Connector 6188-0294 (GR)
- AVSSf 0.3 B/W-GR wires L=549±3mm

JIG:

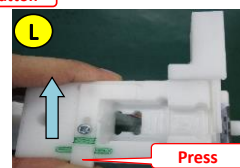
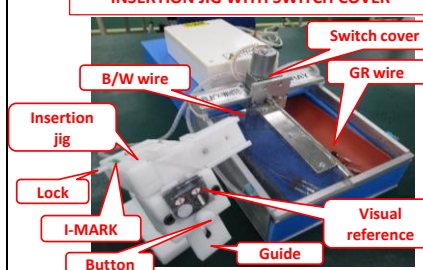
1. Insertion jig with switch cover

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

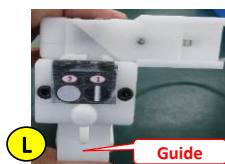
1

P1

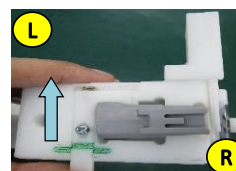
Connector setting to
insertion jig
6188-0294 (GR)

INSERTION JIG WITH SWITCH COVER

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



Revision History

**INSERTION JIG ORIENTATION**

2. Insert the connector 6188-0294 (GR) into jig using right hand and release the lock.

Note: Follow the connector orientation.

2

**CONNECTOR ORIENTATION**

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

Safety Instruction

Be sure to wear prescribed 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.

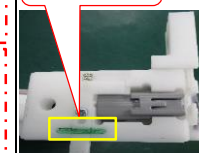
Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Connector Orientation Illustration

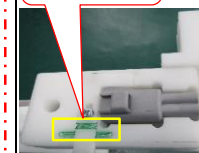
I-mark is align

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

05/18/21 2 Removal of validity date. Apply some improvements.

M. Catapang

C. Villanueva

A. Shimamura

A. Arañes

Prepared by

Reviewed by

Approved by

Noted by

11/17/20 1 Transfer process owner from Production (WI-PRO-ASY-048) to Engineering (WI-ENG-PDE-198A). Apply some improvements/pictures. Removal of marker on taping jig.

M. Catapang

R. Peñaloza

A. Shimamura

A. Arañes

07/10/17 0 Previously established as Production work instruction (WI-PRO-ASY-048). Initial issue

J. Montañito/
L. Bricenas

O. Merin

T. Sugiyama

n/a

Eff. Date

Rev. No

Details of Change

Revised

Checked

Approved

Noted

Est. Date:

July 10, 2017

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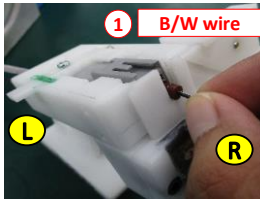
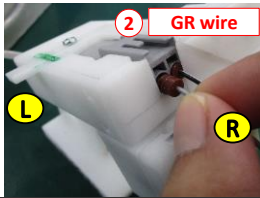

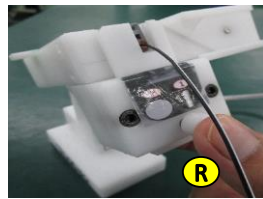
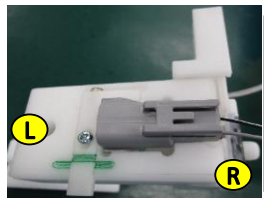
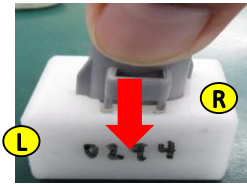


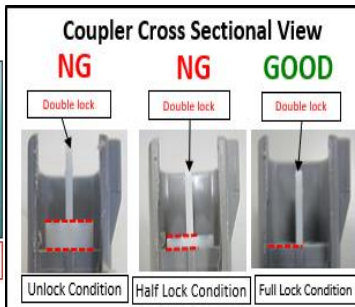

WI-ENG-PDE-198A

Revision No.:

2

Page No.:

2 of 4

PARTS:	n/a			JIG	1. Insertion jig with switch cover 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Wire insertion to connector 6188-0294 (GR)	<div><div><p>1. Get the B/W wire then insert to terminal slot 1 using right hand.</p></div><div><p>3. Get the GR wire then insert to terminal slot 2 using right hand.</p></div></div> <div><div><p>WIRE FACING</p></div><div><p>2. After insertion of B/W wire, press the button using right thumb. The slot for GR wire will be opened.</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>		n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing <div>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div>
3	Connector Lock	<div><div><p>1. Put the connector into locking jig using right hand then press 2x. Check the connector lock if properly locked.</p></div><div><div><p>Before Pressing</p></div><div><p>After Pressing</p></div></div><div><p>Coupler Cross Sectional View</p><p>NG NG GOOD</p><p>Double lock Double lock Double lock</p><p>Unlock Condition Half Lock Condition Full Lock Condition</p></div></div>		<div>LOCKING JIG</div> 	<div>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK</div> 1. Use the provided jig per model 2. No unlock/half-locked connector

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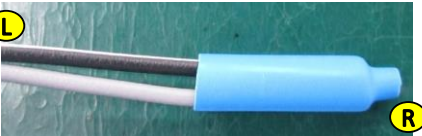

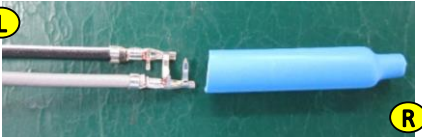
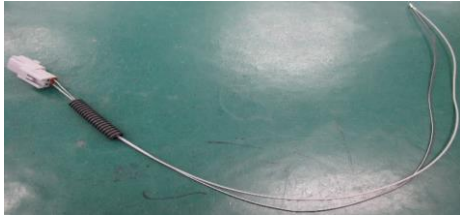



WI-ENG-PDE-198A

Revision No.:

2

Page No.:

3 of 4

PARTS:	1. Assy parts 2. Black corrugated tube (no slit) Ø7 L=50±3mm 3. Black vinyl tube Ø10 L=435±3mm			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black corrugated tube (no slit) Ø7 L=50±3mm P1	<div><p>1. Get the terminal cover jig using right hand and then insert the B/W-GR wires using left hand.</p></div> <div><p>2. Get the corrugated tube (no slit) Ø7 L=50±3mm using right hand and then insert the B/W-GR wires using left hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div> <div></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts 2. No deformed terminal
5	Wire insertion to Black vinyl tube Ø10 L=435±3mm	<div><p>1. Get the vinyl tube Ø10 L=435±3mm using right hand and then insert the B/W-GR wires using left hand.</p></div> <div></div>			1. No wrong use of parts

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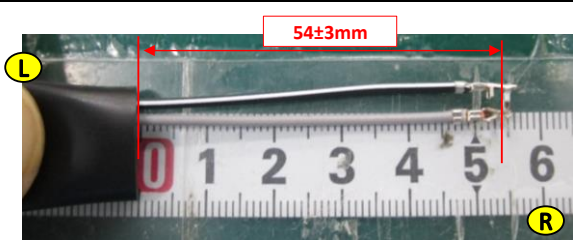
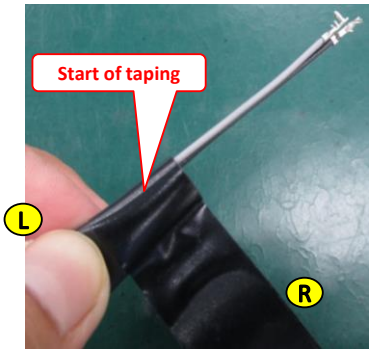
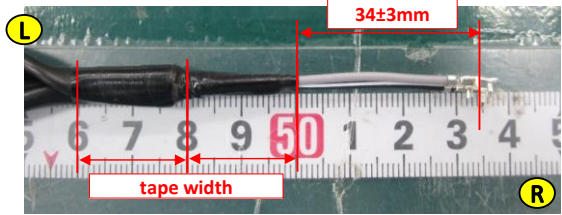

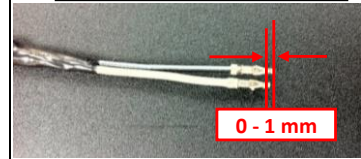
4 of 4

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 vinyl tube to wire near terminal	<div><p>1. Measure from end of the vinyl tube up to terminal pointed tip 54±3mm.</p></div> <div><p>2. Hold the vinyl tube using left hand then start taping using right hand . <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p></div> <div><p>3. After taping, check the measurement, wire alignment and taping condition.</p></div>	<div><p>MEASURING TAPE</p></div>	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div>

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