

	WORK INSTRUCTION				Effectivity Date:		February 28, 2023	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model Code/Part Number: 310B / 7M0530-7020C		Customer: TRJ		Document No.: WI-ENG-PDE-035A	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		8	Page No.: 1 of 7

PARTS:	1. Assy parts: Connector 6098-6663 (B); AVSSf 0.3 B wire L=518±3mm; Black vinyl tube ø5 L=20±3mm; Black corrugated tube (no slit) ø5 L=360±3mm; Gray tape			JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	P1 Table Lay-out	<div style="text-align: center; border: 1px solid black; padding: 5px; margin-bottom: 10px;">Table Lay-out</div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	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
02/28/23	8	Set new std. taping of Vinyl tube 24mm and above. Change taping measurement of Process no.8 procedure no.3 taping of vinyl tube near connector from tape width to 15±3mm. Inclusion of Quality Checkpoints on page no. 7	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	
08/18/22	7	Additional table lay-out. Improve: Work procedure and illustration in process no.6, no.7 and no.8. Quality pointers and notes in process no.1, 3, 5, 6, 7 and 8. Change: Tape color from Black tape to Gray tape. Measurement from 25±3mm to 23±3mm as process improvement.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	
05/18/21	6	Removal of validity date. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: July 02, 2018

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PARTS:1. Black vinyl tube $\phi 5$ L=20 \pm 3mm2. Black corrugated tube (no slit) $\phi 5$ L=360 \pm 3mm3. AVSSf 0.3 B wire L=518 \pm 3mm**JIG**

n/a

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

2

Wire insertion to
Black vinyl tube
 $\phi 5$ L=20 \pm 3mm

1. Get the vinyl tube $\phi 5$ L=20 \pm 3mm using right hand and insert **Y wire** using left hand.



2. Continue to insert **B wire** using left hand.



n/a

1. No wrong usage of parts
2. No deformed terminal

3

Wire insertion to
Black corrugated tube
(no slit)
 $\phi 5$ L=360 \pm 3mm

1. Get the **B wire** L=518 \pm 3mm using left hand and combine to **Y wire**.



2. Get the corrugated tube (no slit) $\phi 5$ L=360 \pm 3mm using right hand and insert the **B-Y wires** using left hand.

n/a

Document reference/s:
1. Refer to WI-PRO-CNC-017 for **Wire and Strip Length Tolerance**

1. No wrong usage of parts
2. No deformed terminal

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PARTS:

1. Connector 6098-6663 (B)

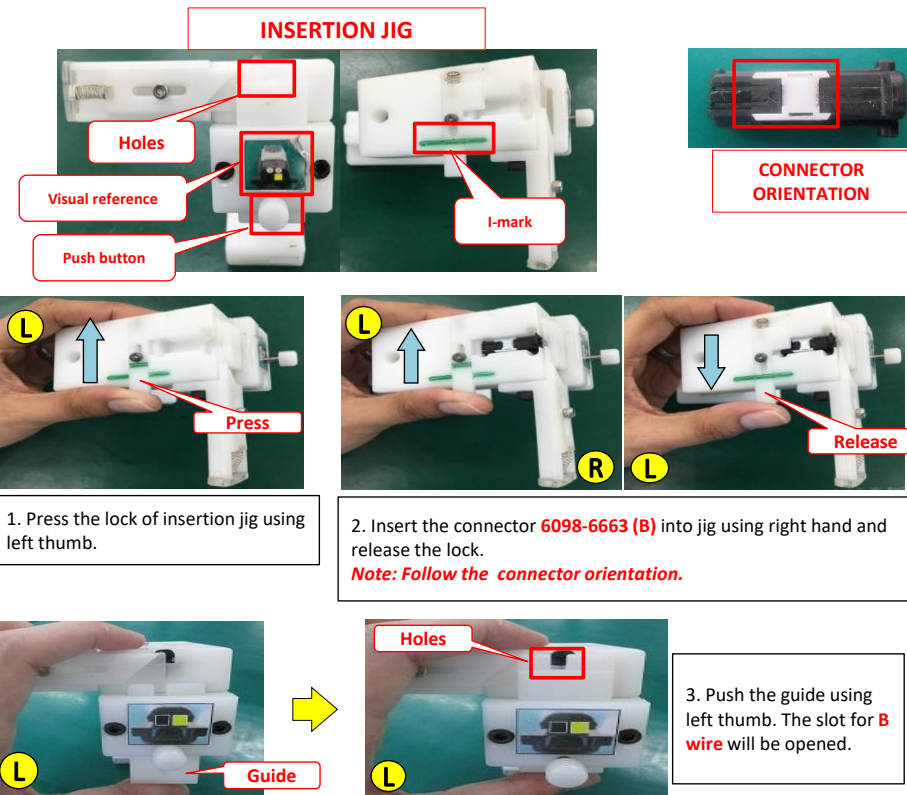
JIG

1. Insertion jig

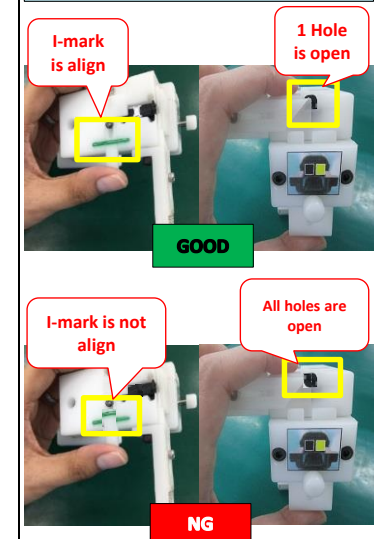
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

P1

Connector setting to
insertion jig
6098-6663 (B)

n/a

**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

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PARTS:

1. Assy parts

JIG

1. Insertion jig

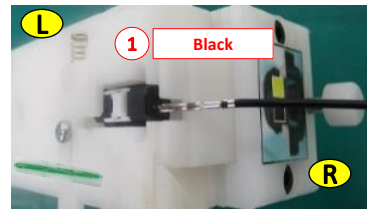
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

P1

Wire insertion to
connector
6098-6663 (B)

Wire facing



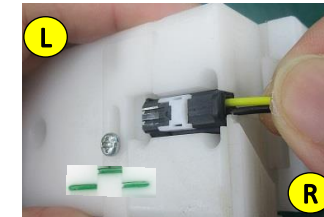
1. Get the **B wire** and insert to terminal slot **1** using right hand.



2. After insertion of **B wire** press the button using right hand. The slot for **Y wire** will be opened.



3. Get the **Y wire** then insert to terminal slot **2** using right hand.



4. After insertion , push the lock using left hand and then hold the wire 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.

Document references:

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

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PARTS:

1. Assy parts
2. Gray tape

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

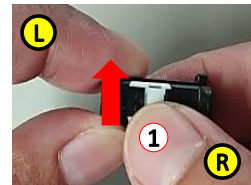
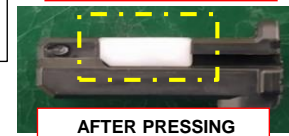
QUALITY POINTERS

6

Connector Lock



1. Put the connector into locking jig using right hand then press to lock **2x** using both hands. Touch the connector lock if properly locked.



2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

LOCKING JIG



Important reminders/Note/s:
1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR

1. Use the provided jig tool to lock the connector.
2. No unlock/half-locked connector

7

P1

Spot taping



1. Hold the wires using both hands and measure from wire up to terminal pointed tip **120±3mm**.

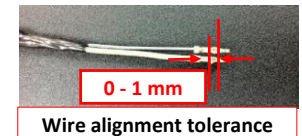


2. Hold the wires using left hand, get **Gray tape** then start taping using both hands. Make **2 windings of tape** then cut the tape.



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

MEASURING TAPE



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

Important reminders/Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

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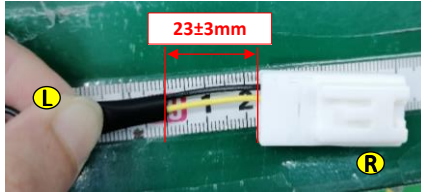
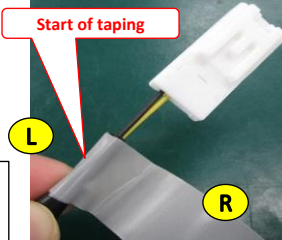
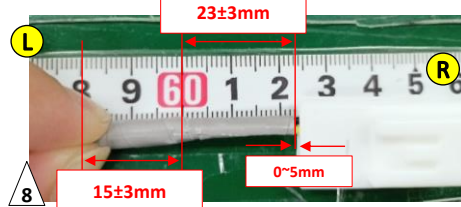

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PARTS:

1. Assy parts
2. Gray tape

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	Taping 1 Black vinyl tube to wire near connector	 <p>1. Hold the vinyl tube using left hand and measure from end of vinyl tube up to connector 23±3mm using both hands.</p>  <p>2. Hold the vinyl tube using left hand, get Gray tape then taping using both hands.</p>  <p>3. After taping, check the measurement and taping condition.</p>		<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.2. Refer to WI-PRO-ASY-001 for taping procedure.

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PARTS:

n/a

JIG:

n/a



QUALITY CHECKPOINTS

P1

7M0530-7020C



GOOD



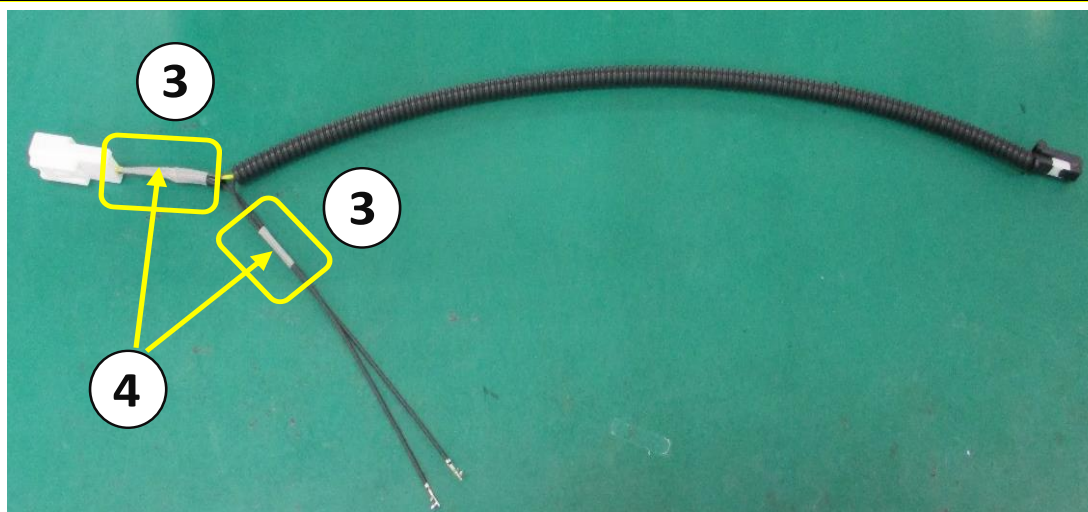
GOOD



NO GOOD



NO GOOD



GOOD



NO GOOD

1 No Unlock/
Halflock Connector
(2 connector)

2 No Wrong Insert

3 No Missing Tape

4 No Wrong Used of
Tape (gray tape)

5 No Terminal Backing
Out

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