

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

July 17, 2021

Product Name/Code:

**900B / 7N0114-7020A**

Customer:

**TRJ**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-274A**

Revision No.:

1

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**PARTS:**

1. Pre-assy from Kitting (Connector 6189-0451 (W); AVSSf 0.3 Y-OR wires L=328±2mm; Black vinyl tube Ø7 L=57±3mm); Connector 6188-0066 (GR); Connector 6098-3810 (W); AVSSf 0.3 G-B wires L=677mm; AVSSf 0.3 V wire L=800mm; Black vinyl tube Ø7 L=189±3mm; Black vinyl tube Ø5 L=69±3mm; Black tape [1pc.]

JIG:

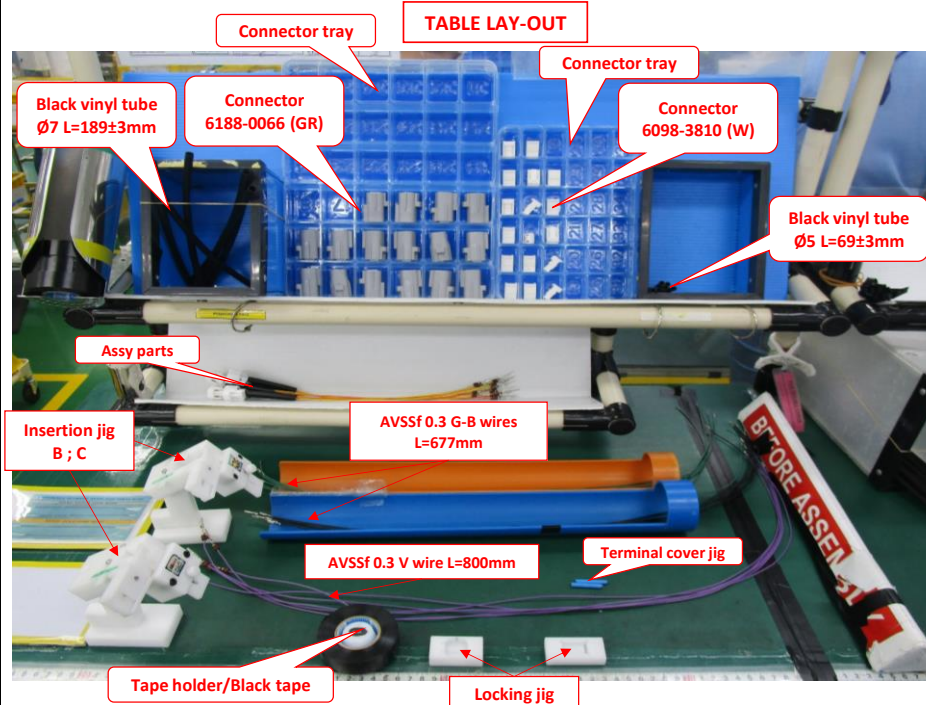
1. Insertion jig
2. Locking jig
3. Terminal cover jig

**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

**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	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/17/21	1	Removal of validity date. Change document status from pre-launch to masspro.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
07/12/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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## PARTS:

1. Assy parts
2. Black tape

JIG

n/a

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

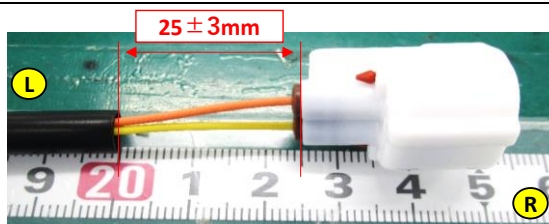
## TOOLS/PPE

## QUALITY POINTERS

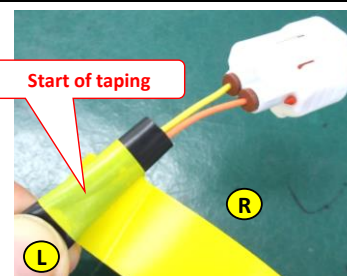
2

P1

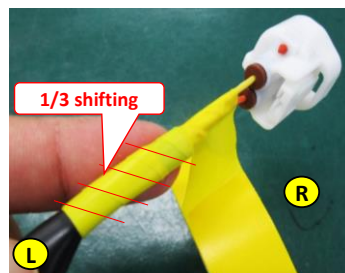
Taping 1  
Black vinyl tube to wire  
near connector



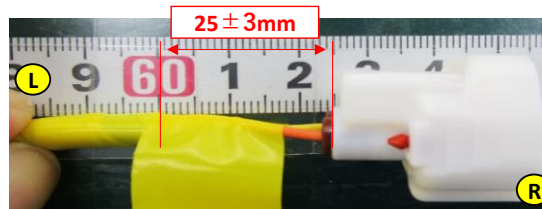
1. Measure from end of vinyl tube up to edge of connector  $25 \pm 3\text{mm}$  using both hands.



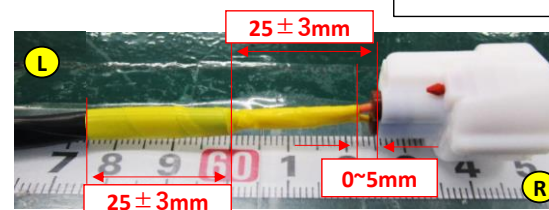
2. Get the **Black tape** using right hand then start taping process using both hands.



3. Wind **1/3 shifting** going to wires using both hands.



4. Confirm measurement from end of vinyl tube up to edge of connector  $25 \pm 3\text{mm}$  using both hands. Make **3 windings** of tape before cut.



3. After taping, check the measurement 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 use of tape
6. No wrong dimension

**Note:**

Please use calibrated/verified measuring tape when getting the measurement.

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☐ PRE-LAUNCH


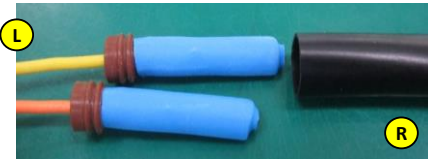


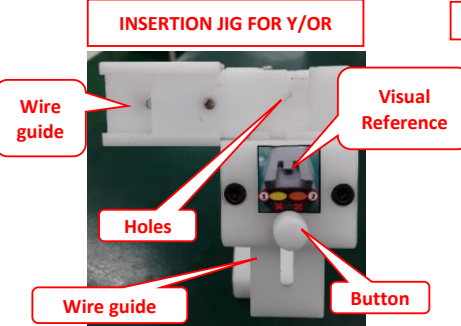
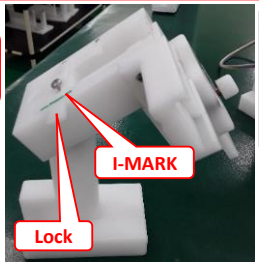

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PARTS:		1. Assy parts 2. Black vinyl tube Ø7 L=189±3mm 3. Connector 6188-0066 (GR)	JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to Black vinyl tube Ø7 L=189±3mm	 <p>1. Get the cover jig then insert to <b>Y-OR wires</b> using right hand.</p>  <p>2. Get the vinyl tube <b>Ø7 L=189±3mm</b> using right hand then insert the <b>Y-OR wires</b> using left hand.</p>  <p>3. After insertion, remove the cover jig using right hand.</p>	<b>TERMINAL COVER JIG</b> 	1. No wrong usage of parts 2. No damaged rubber seal
4	Connector setting to insertion jig 6188-0066 (GR)	 <p><b>INSERTION JIG FOR Y/OR</b></p>  <p><b>INSERTION JIG ORIENTATION</b></p>  <p><b>CONNECTOR ORIENTATION</b></p>	n/a	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

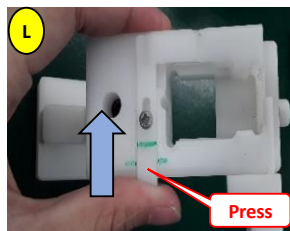
### TOOLS/PPE

### QUALITY POINTERS

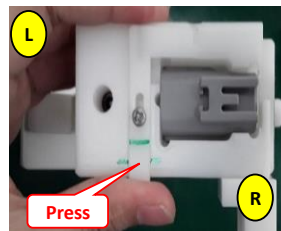
5

P1

Connector setting to  
insertion jig  
6188-0066 (GR)

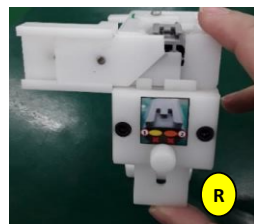
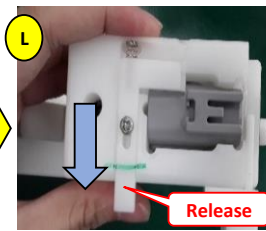


1. Press the lock of insertion jig  
using left thumb.



2. Insert the connector **6188-0066 (GR)** into jig using right hand  
then release the lock.

**Note: Follow the connector orientation.**



3. Push the guide using right  
thumb. The slot for **Y wire** will be  
opened.

n/a

#### Connector Orientation Illustration

I-mark is  
align

1 hole is open



I-mark is  
NOT align

2 holes are  
open



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**

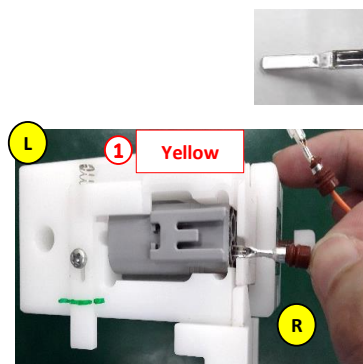
1. Insertion jig

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

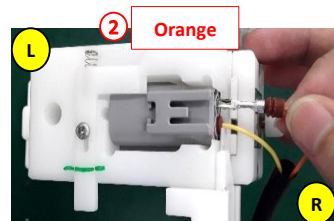
6

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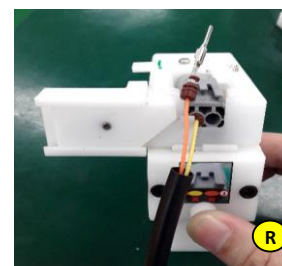
Wire insertion to  
Connector  
6188-0066 (GR)



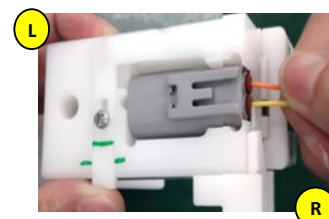
1. Hold the insertion jig using left hand. Get the assy parts, insert the **Yellow wire** to connector slot **1** using right hand.



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



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

**Note:** Please hold the wire near terminal during insertion.

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

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

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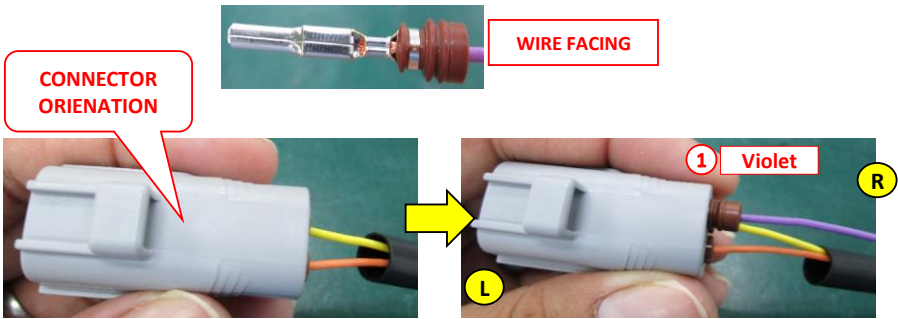
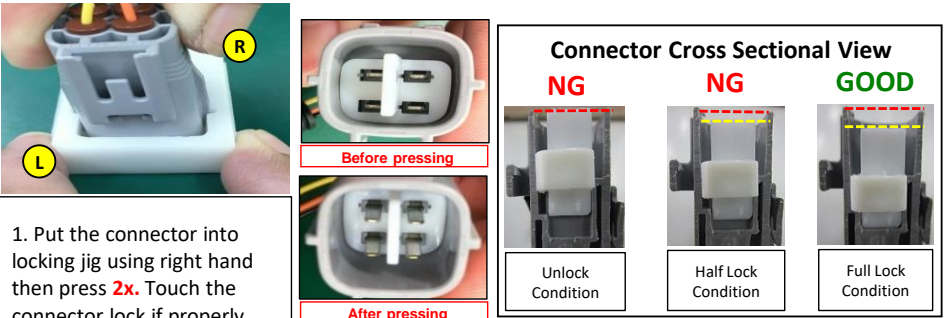
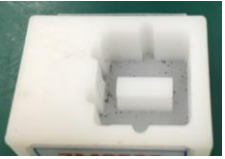
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**PARTS:**

1. Assy parts
2. AVSSf 0.3 V wire L=800±3mm

**JIG**

1. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	Wire insertion to connector 6188-0066 (GR)	 <p>1. Get the <b>Violet wire</b> then insert to empty slot using right hand. <b>Note: Follow the connector orientation.</b></p>	n/a	<p><b>Note:</b> Please hold the wire near terminal during insertion.</p> <ol style="list-style-type: none"><li>1. No loose insertion</li><li>2. No wrong insertion</li><li>3. One by one insertion</li><li>4. No deformed terminal</li><li>5. No wrong wire facing</li></ol> <p><b>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></p>
8	Connector Lock	 <p>1. Put the connector into locking jig using right hand then press <b>2x</b>. Touch the connector lock if properly locked.</p>		<p><b>NOTE:</b> MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p> <ol style="list-style-type: none"><li>1. Use the provided locking jig per model</li><li>2. No unlock/half-lock connector</li></ol>

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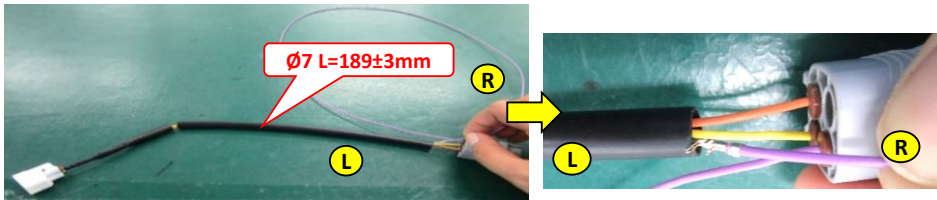
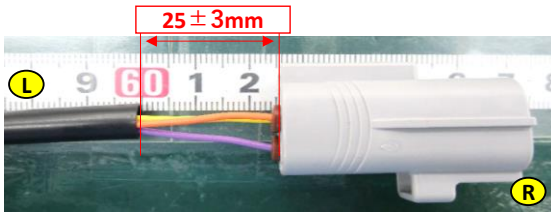
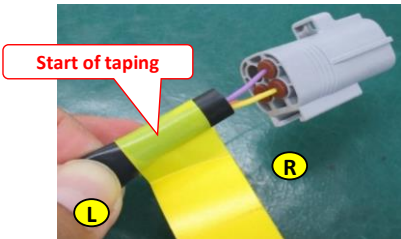

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## PARTS:

1. Assy parts
2. Black tape

## JIG

1. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	Wire insertion to assy parts Black vinyl tube Ø7 L=189±3mm	 <p>1. Hold the <b>Violet wire</b> using right hand, hold the vinyl tube <b>Ø7 L=189±3mm</b> using left hand then insert the <b>Violet wire</b> using right hand.</p>	n/a	<ol style="list-style-type: none"><li>1. No wrong insertion of parts</li><li>2. No deformed terminal</li></ol>
10	Taping 2 Black vinyl tube to wire near connector	 <p>1. Measure from end of vinyl tube up to edge of connector <b>25±3mm</b> using both hands.</p>  <p>2. Get the <b>Black tape</b> using right hand then start taping process using both hands.</p>	 <p><b>MEASURING TAPE</b></p>	<p><b>NOTE:</b> USED <b>YELLOW TAPE</b> FOR EASY VISUALIZATION OF SHIFTING LINE, 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> <p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p>

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## PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

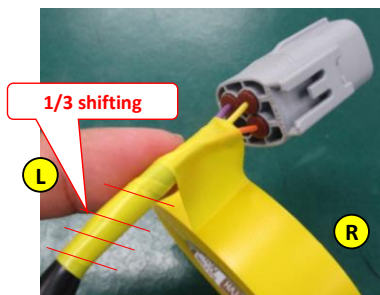
TOOLS/PPE

QUALITY POINTERS

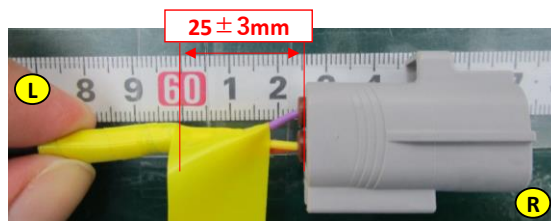
10

P1

Taping 2  
Black vinyl tube to wire  
near connector  
(Continuation)



3. Wind **1/3 shifting** going to wires using both hands.

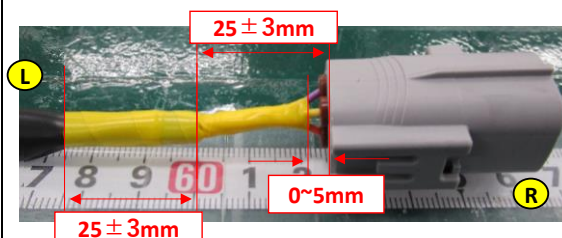


4. Confirm measurement from end of vinyl tube up to edge of connector **25±3mm** using both hands. Make **3 windings** of tape before cut.

MEASURING TAPE



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



5. After taping, check the measurement and taping condition.

**Note:**

Please use calibrated/verified measuring tape when getting the measurement.

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### PARTS:

1. Connector 6098-3810 (W)

### JIG

1. Insertion jig

### NO.

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### WORK PROCEDURE/ ILLUSTRATION

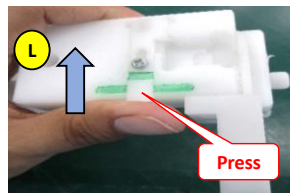
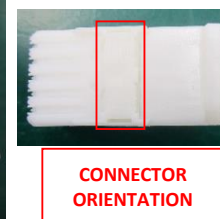
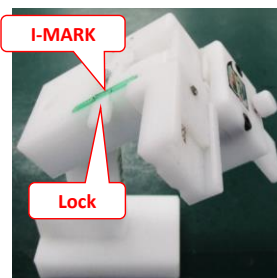
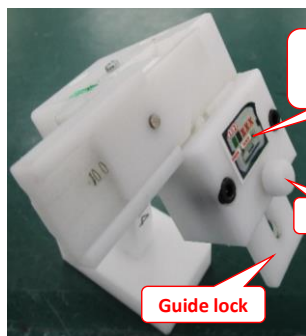
### TOOLS/PPE

### QUALITY POINTERS

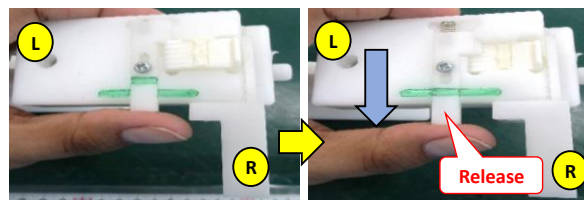
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Connector setting to  
insertion jig  
6098-3810 (W)

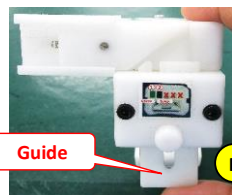


1. Press the lock of insertion  
jig using left thumb.



2. Insert the connector **6098-3810 (W)** into jig using right hand and  
release the lock.

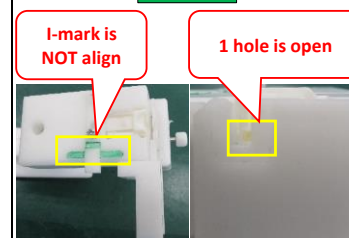
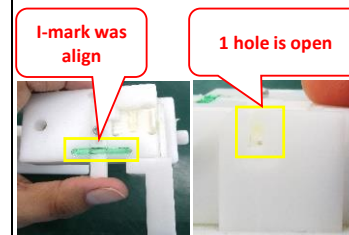
**Note: Follow the connector orientation.**



3. Push the guide using right hand.  
The slot for **Green wire** will be  
opened.

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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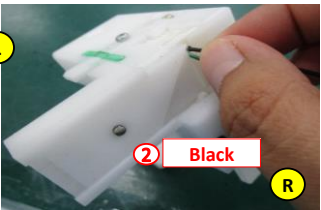
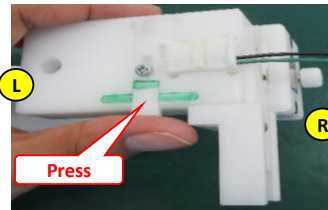
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PARTS:		1. AVSSf wires G and B wires L=677±3mm			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
12	P1	<div><b>WIRE FACING</b></div> <div><p>1. Hold the insertion jig using left hand, get <b>Green wire</b> and insert to connector slot <b>1</b> using right hand.</p></div> <div><p>2. Press the button using right thumb, slot for <b>Black wire</b> will be opened.</p></div> <div><p>3. Hold the insertion jig using left hand, get <b>Black wire</b> and insert to connector slot <b>2</b> 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>			n/a	<p><b>Note:</b> Please hold the wire near terminal during insertion.</p> <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><b>Note:</b> Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Product Name/Code:

900B / 7N0114-7020A

Customer:

TRJ

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

July 17, 2021

Validity Date:

n/a

Document No.:





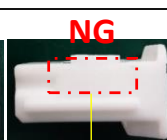


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PARTS:		1. Assy parts 2. Black vinyl tube Ø5 L=69±3mm		JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	Connector lock	<div></div> <div><p>Put the connector into locking jig using both thumb then press to lock <b>2x</b>. Touch the connector lock to confirm if properly pressed.</p><p><i>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</i></p></div> <div><div><p>Before Pressing</p></div><div><p>After Pressing</p></div><div><div><p>GOOD</p></div><div><p>NG</p></div><div><p>Fully Locked</p></div><div><p>UnLocked</p></div></div></div>		<div><p>Locking jig</p></div>	<div><p><i>Note: Use provided jig tool per model to avoid damaged lock.</i></p><p>1. Use the provided locking jig per model 2. No unlock/half-lock connector</p><div><p><b>NOTE:</b> <b>MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</b></p></div></div>
14	P1  Wire insertion to Black vinyl tube Ø5 L=69±3mm	<div></div> <div><p>1. Get the vinyl tube Ø5 L=69±3mm using right hand then insert the <b>G-B wires</b> using left hand.</p></div>		n/a	<p>1. No wrong usage of parts 2. No deformed terminal</p>

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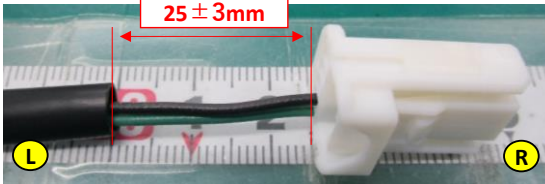
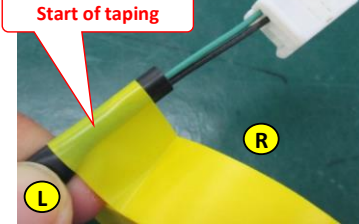


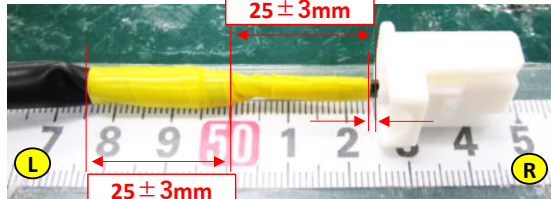

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### PARTS:

1. Assy parts
2. Black tape

### JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
15	P1 Taping 3 Black vinyl tube to wire near connector	<div><p>1. Measure from end of vinyl tube up to edge of connector <b>25±3mm</b> using both hands.</p></div> <div><p>2. Get the <b>Black tape</b> using right hand then start taping process using both hands.</p></div> <div><p>3. Wind <b>1/3 shifting</b> going to wires using both hands.</p></div> <div><p>4. Confirm measurement from end of vinyl tube up to edge of connector <b>25±3mm</b> using both hands. Make <b>3 windings</b> of tape before cut.</p></div> <div><p>5. After taping, check the measurement and taping condition.</p></div>	<div><p>MEASURING TAPE</p></div>	<div><p>NOTE: USED <b>YELLOW TAPE</b> FOR EASY VISUALIZATION OF SHIFTING LINE, BUT ACTUAL SHOULD BE <b>BLACK</b>.</p></div> <div><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> <div><p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p></div>

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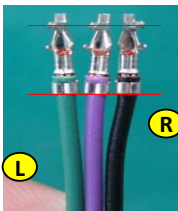

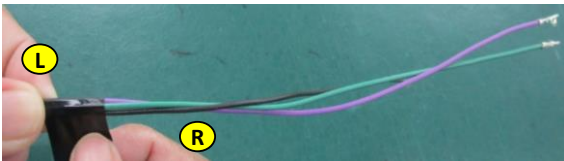
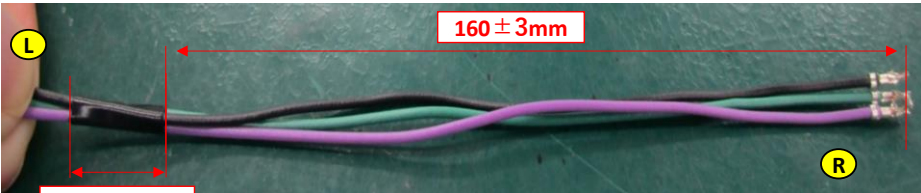


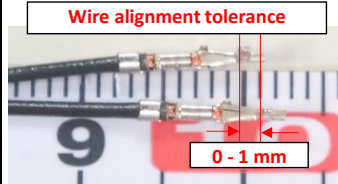
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### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
16	P1	Spot taping		
		 <p>1. Align the terminals using both hands.</p>  <p>2. Measure from wires up to terminal pointed tip <math>180 \pm 3\text{mm}</math> using both hands.</p>  <p>3. Get the <b>Black tape</b> then make <b>2 windings</b> of tape using both hands.</p>  <p>4. After taping, check the measurement, taping condition and wire alignment.</p>	 	<p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</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> <p><b>Wire alignment tolerance</b></p> 

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