



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

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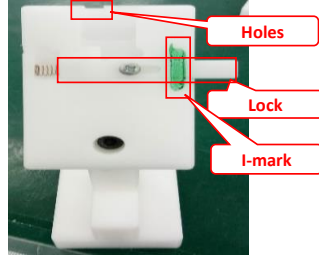


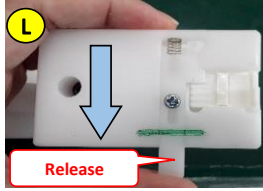
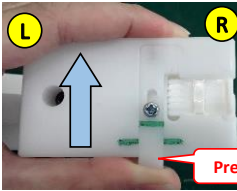
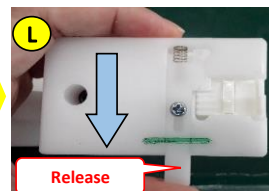
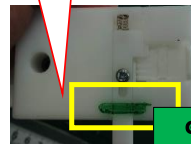
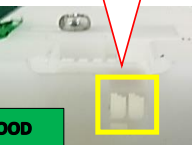
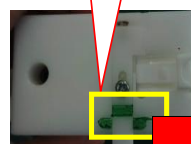
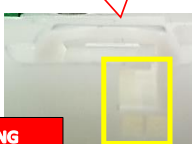
Process Name/Title: **TAPING ASSEMBLY PROCESS**

Product Name/Code: **370B / 7L0043-7022** Customer: **TRQSS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS: 1. Connector 6098-3810 (W)

JIG: 1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Connector setting to insertion jig 6098-3810 (W)	<p>INSERTION JIG</p>  <p>INSERTION JIG ORIENTATION</p>  <p>1. Press the lock of insertion jig using left thumb.</p> <p>Connector lock</p>  <p>Connector orientation</p>  <p>2. Get the connector 6098-3810 (W) using right hand then insert to jig using right hand and release the lock using left thumb. Note: Follow the connector orientation.</p> <p>Press</p>  <p>Release</p>  <p>3. Check the holes/terminal slot for B/B wires.</p>	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Connector Orientation</p> <p>I-mark is align</p>  <p>2 Holes are widely open</p>  <p>GOOD</p> <p>I-mark is not align</p>  <p>2 holes are partially open.</p>  <p>NG</p> <p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Checked	Approved	Prepared by	Reviewed by	Reviewed by	Approved by
09/07/21	1	Transfer process owner from Production WI (WI-PRO-ASY-070) to Engineering WI (WI-ENG-PDE-334A). Improve all process illustration, parts and quality pointers.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
05/10/18	0	Initial issue	A. Morcozo	W. Carbillon	-	O. Merin	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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PARTS:

1. AVSSf 0.3 B L=317±3mm [2pcs.]

JIG

1. Insertion jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to connector 6098-3810 (W)	<p>1. Get the 1st Black wire then insert to terminal slot 1 using right hand. Note: Insertion of wires must be from left to right.</p> <p>2. Get the 2nd Black wire then insert to terminal slot 2 using right hand.</p> <p>3. After insertion, push the lock using left thumb, then hold the wires and gently pull out the connector from jig using right hand.</p>	n/a	<p>1. No loose insertion 2. No wrong dimension 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>
3	Connector lock	<p>1. Put the connector into locking jig using both hands then press 2x using both hands. Touch the connector lock to confirm if properly locked. Refer to GL-PRO-ASY-017 for the verification of lock.</p>	<p>LOCKING JIG</p>	<p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</p> <p>1. Use the provided locking jig per modle 2. No unlocked/half-locked connector 2. No damaged lock</p>

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PARTS:

1






1. Assy parts

2. Black corrugated tube (no slit) $\phi 5$ L=224 \pm 3mm

3. Black vinyl tube $\phi 4$ L=35 \pm 3mm

JIG

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to corrugated tube (no slit) $\phi 5$ L=224 \pm 3mm P1	   <p>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B/B wires using left hand.</p> <p>2. Get the corrugated tube (no slit) $\phi 5$ L=224\pmmm using right hand then insert the B/B wires using left hand.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>	TERMINAL COVER JIG 	1. No wrong usage of parts 2. No deformed terminal
5	Wire insertion to Black vinyl tube $\phi 4$ L=35 \pm 3mm	 <p>1. Get the Black Vinyl tube $\phi 4$ L=35\pm3mm using right hand then insert the B/B wires.</p>	n/a	1. No wrong usage of parts 2. No deformed terminal

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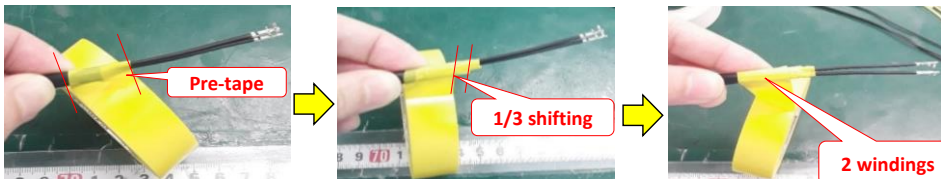
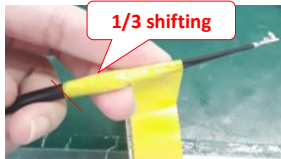
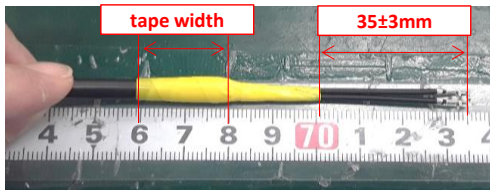

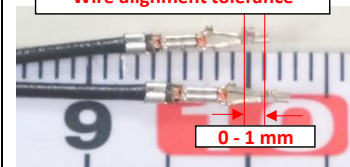
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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 Black vinyl tube to wire near terminal	 <p>1. Measure from end of vinyl tube up to terminal pointed tip 55mm.</p>  <p>2. Get the Black tape, conduct pre-taping between vinyl tube and wires. Make 1/3 shifting going to Vinyl tube then make 2 winds (must be tape width).</p>  <p>3. Make 1/3 shifting going to wires then make 3 windings of tape before cut. Note: Do not fold the vinyl tube since it's φ4.</p>  <p>4. After taping, check the measurement, wire alignment and taping condition.</p>	 <p>MEASURING TAPE</p>	<p>NOTE: USED <u>YELLOW TAPE</u> FOR EASY VISUALIZATION OF TAPE SHIFTING BUT ACTUAL SHOULD BE <u>BLACK TAPE</u></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>Wire alignment tolerance</p>  <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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