



WORK INSTRUCTION

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

Product Name/Code: **240B / 7M0516-7020C**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 23, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-024A


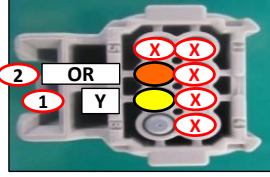
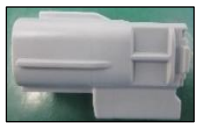


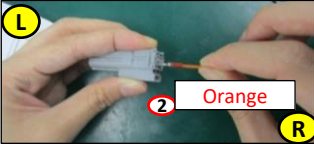


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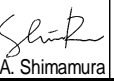
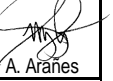


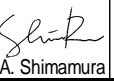
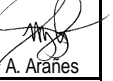
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PARTS:	 1. Connector 6188-0779 (GR) 2. Black Corrugated tube $\Phi 7$ L=408 \pm 4mm (no slit) , $\Phi 5$ L=275 \pm 3mm (no slit)	JIG:	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Wire Insertion to Connector 6188-0779 (GR) 	     1. Hold the connector using left hand and insert yellow wire using right hand, above of dummy seal. 2. Hold the connector using left hand and insert orange wire using right hand, above of yellow wire.	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.	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing 6. No wrong orientation of connector 7. Check the presence of dummy seal Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
2	Wire insertion to Corrugated tube $\Phi 7$ L=408 \pm 4mm (no slit) $\Phi 5$ L=275 \pm 3mm (no slit)	  1. Get the corrugated tube $\Phi 7$ L=408 \pm 4mm(no slit) using right hand then insert the Orange and Yellow wire using left hand. 2. Get the corrugated tube $\Phi 5$ L=275 \pm 3mm (no slit) using right hand then insert the Orange and Yellow wire using left hand.		1. No wrong usage of parts 2. No deformed terminal

Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/23/21	5	Change connector colours in accordance with color standardization for plastic parts refer to GL-COM-003 Put assy parts on pg. 5	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
09/30/20	4	Additional information for locking of connector 6098-2220 (N); Removal of cycle time; Apply some improvements	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
03/06/18	n/a	Previously established Engineering instruction (EI-ENG-PDE-022). Initial issue.	J. Loterte	R. Alcantara	A. Arañes	n/a	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
Established Date: September 24, 2018										

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Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

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

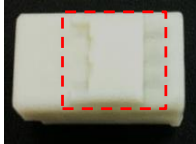
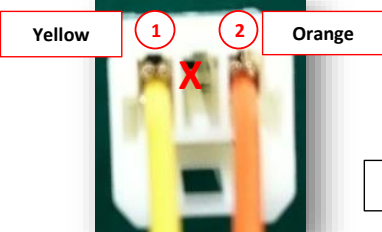
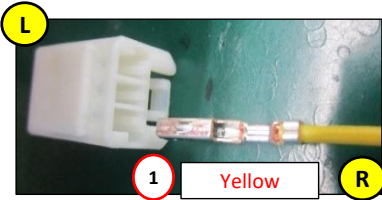
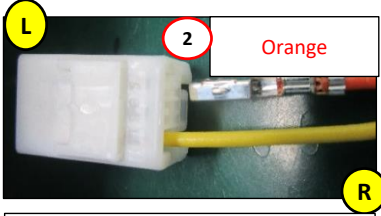
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PARTS:  1. Connector 6098-2220 (W)

JIG

N/A

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1  Wire insertion to Connector 6098-2220 (W)	<div><p>CONNECTOR ORIENTATION</p><p>WIRE FACING</p><p>1. Hold the connector using left hand and insert yellow wire using right hand.</p><p>2. Hold the connector using left hand and insert orange wire using right hand.</p></div>	N/A	<ol style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deformed terminal5. No wrong wire facing6. No wrong orientation of connector <p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p>

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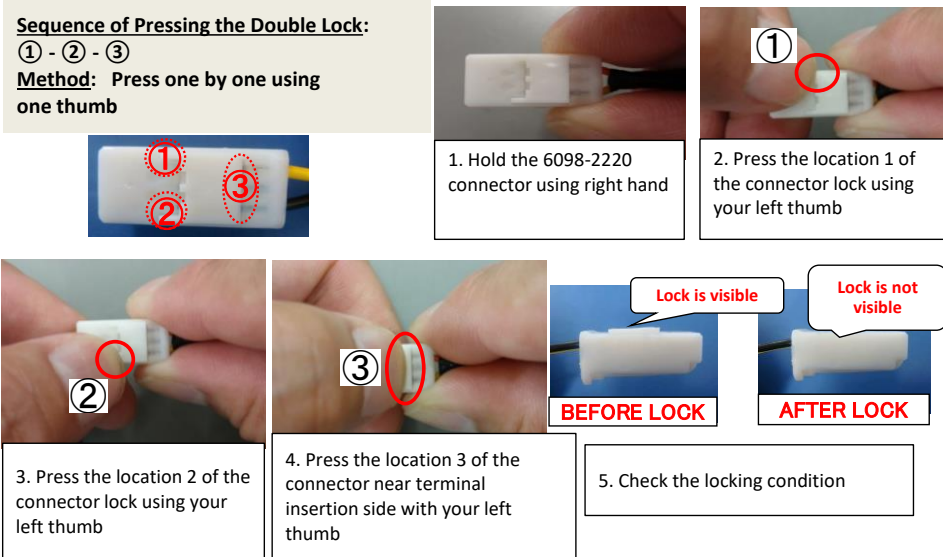
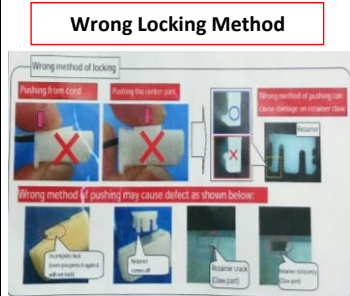
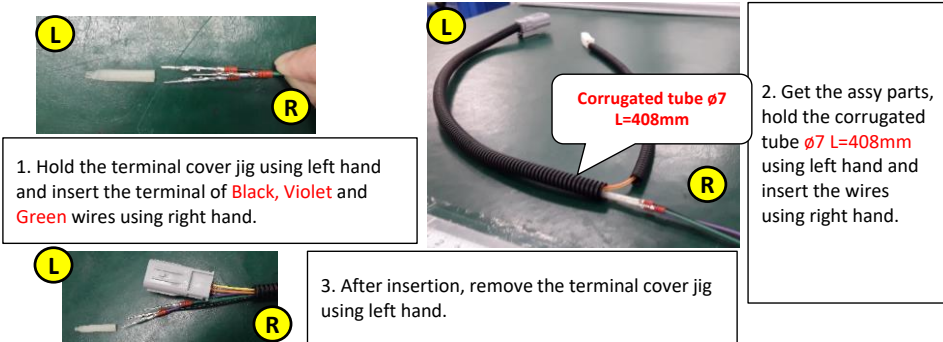

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PARTS:		1. Assy parts 2. AVSSf 0.3 wires G L=809mm; V L=809mm; B L=809mm			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P1	<p>Sequence of Pressing the Double Lock: ① - ② - ③ Method: Press one by one using one thumb</p>  <p>1. Hold the 6098-2220 connector using right hand</p> <p>2. Press the location 1 of the connector lock using your left thumb</p> <p>3. Press the location 2 of the connector lock using your left thumb</p> <p>4. Press the location 3 of the connector near terminal insertion side with your left thumb</p> <p>5. Check the locking condition</p> <p>Lock is visible Lock is not visible</p> <p>BEFORE LOCK AFTER LOCK</p>			n/a	<p>Wrong Locking Method</p>  <p>1. No unlocked/half-locked connector 2. No one time pressing of double lock 3. Make sure not to hit the portion ③ (bottom side) when pressing ① & ②</p>
5		 <p>1. Hold the terminal cover jig using left hand and insert the terminal of Black, Violet and Green wires using right hand.</p> <p>2. Get the assy parts, hold the corrugated tube φ7 L=408mm using left hand and insert the wires using right hand.</p> <p>3. After insertion, remove the terminal cover jig using left hand.</p> <p>Corrugated tube φ7 L=408mm</p>			<p>TERMINAL COVER JIG</p> 	<p>1. No wrong use of parts 2. No wrong insertion to assy 3. No deformed terminal</p>

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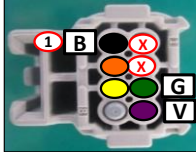


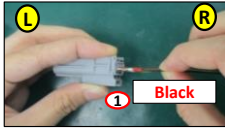
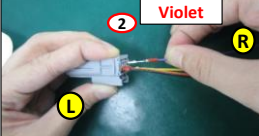
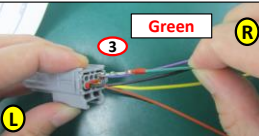




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WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date: April 23, 2021
Validity Date: n/a
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Process Name/Title:
Product Name/Code: **240B / 7M0516-7020C** Customer: **TRJ**
Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	1. MRSW CP 7M0516-7040 2. Assy parts			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
6	Wire Insertion to Connector 6188-0779 (GR) P1	   <p>CONNECTOR ORIENTATION</p>    <p>1. Hold the connector using left hand and insert black wire above orange wire, violet wire beside dummy seal and green wire beside yellow wire.</p>	N/A	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing 6. No wrong orientation of connector Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.	
7	Wire insertion to assy (2)	   <p>Corrugated tube $\phi 7$ L=408mm</p> <p>1. Hold the terminal cover jig using left hand and insert the terminal of GR and B/W wires using right hand.</p> <p>2. Get the assy parts corrugated tube $\Phi 5$ L=275mm and $\Phi 7$ L=408\pm4mm using left hand then insert the MR SW CP 7M0516-7040 wires using right hand.</p> <p>3. After insertion, remove the terminal cover jig using left hand.</p>	TERMINAL COVER JIG 	1. No wrong insertion to assy 2. No deformed terminal	

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240B / 7M0516-7020C

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PARTS:

1. Assy parts

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

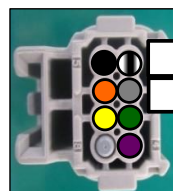
TOOLS/PPE

QUALITY POINTERS

8

P1

Wire insertion to
Connector
6188-0779
(GR)



2

B/W
GR

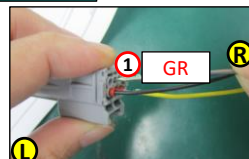
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CONNECTOR ORIENTATION



WIRE FACING

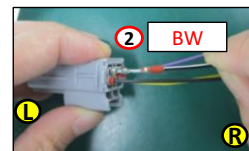


1 GR

L

R

1. Hold the connector using left hand and insert
gray wire above green wire.



2 BW

L

R

2. Hold the connector using right hand and
insert BW wire above gray wire.

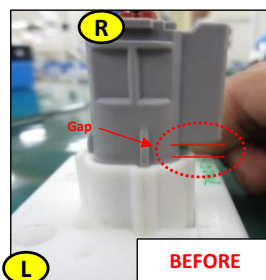
N/A

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong orientation of connector.

Make sure wires are properly inserted.
Conduct **Pull-Push-Pull-Push** after
insertion.
Do not exert extra force.

9

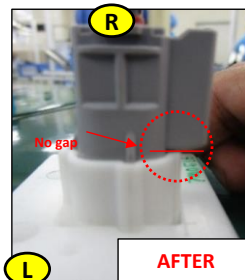
Connector Lock



R

L

BEFORE



R

L

AFTER

1. Hold the locking jig using left hand put the connector into
locking jig using right hand and push 2x.

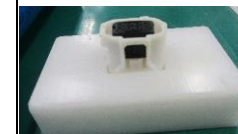


Unlock



Fully locked

LOCKING JIG



1. No Unlock/Half locked connector

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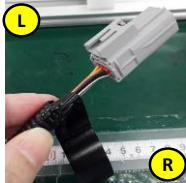
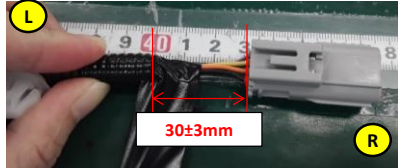
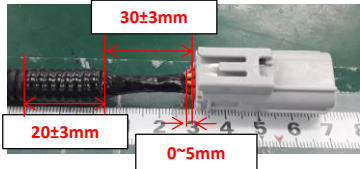

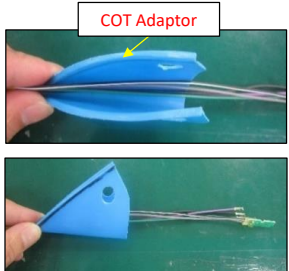
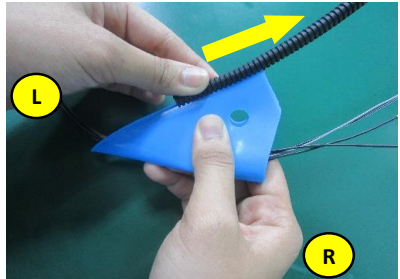

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PARTS:		1. Black tape 2. Corrugated tube $\phi 5$ L=237 \pm 3mm (with slit)	3. Assy parts	JIG	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	Taping (1) Corrugated tube to wire near connector	<div><p>1. Hold the corrugated tube using left hand and start pre- taping using right hand.</p></div> <div><p>2. Hold the corrugated tube using left hand and measure the COT to connector 30\pm3mm. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>		MEASURING TAPE 	1. No loose tape 2. No peel-off tape 3. No flip out tape <i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i>
11	P1 Wire insertion to Corrugated tube (with slit) $\phi 5$ L=237 \pm 3mm	<div><p>1. Put wires on COT adaptor and insert to corrugated tube (with slit)</p></div> <div><p>2. Hold the COT using left hand and COT adaptor using right hand. Push the adaptor and pull the COT in same timing. Make sure all wires are inserted.</p></div>		COT ADAPTOR 	1.No wrong use of parts 2.No wires left in between the COT slit.

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