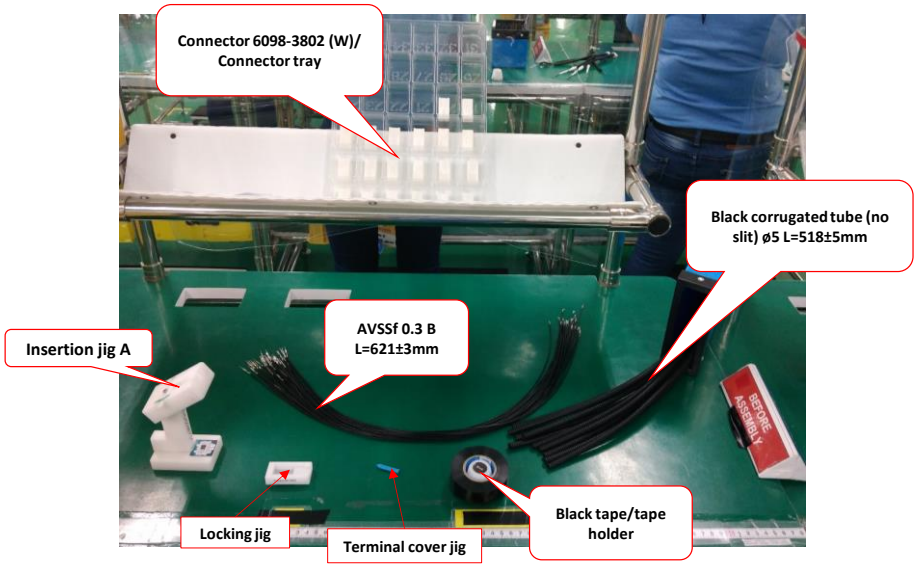
	WORK INSTRUCTION			Effectivity Date:	May 05, 2022
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model Code/Part Number:	740BW / 7H0423W7020	Customer: NBS	Document No.:	WI-ENG-PDE-479A
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 Page No.: 1 of 5

PARTS:	1. Connector 6098-3802 (W); AVSSf 0.3 B L=621±3mm; Black corrugated tube (no slit) ø5 L=518±5mm; 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	1 **Table Lay-out**  	**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.	*Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance* 1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted
05/05/22	1	Change document purpose from pre-launch to masspro. Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
04/20/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

Prepared by	Reviewed by	Reviewed by	Approved by
M. Catapang	J. Loterte	C. Villanueva	A. Arañes
Est. Date:	April 20, 2022		

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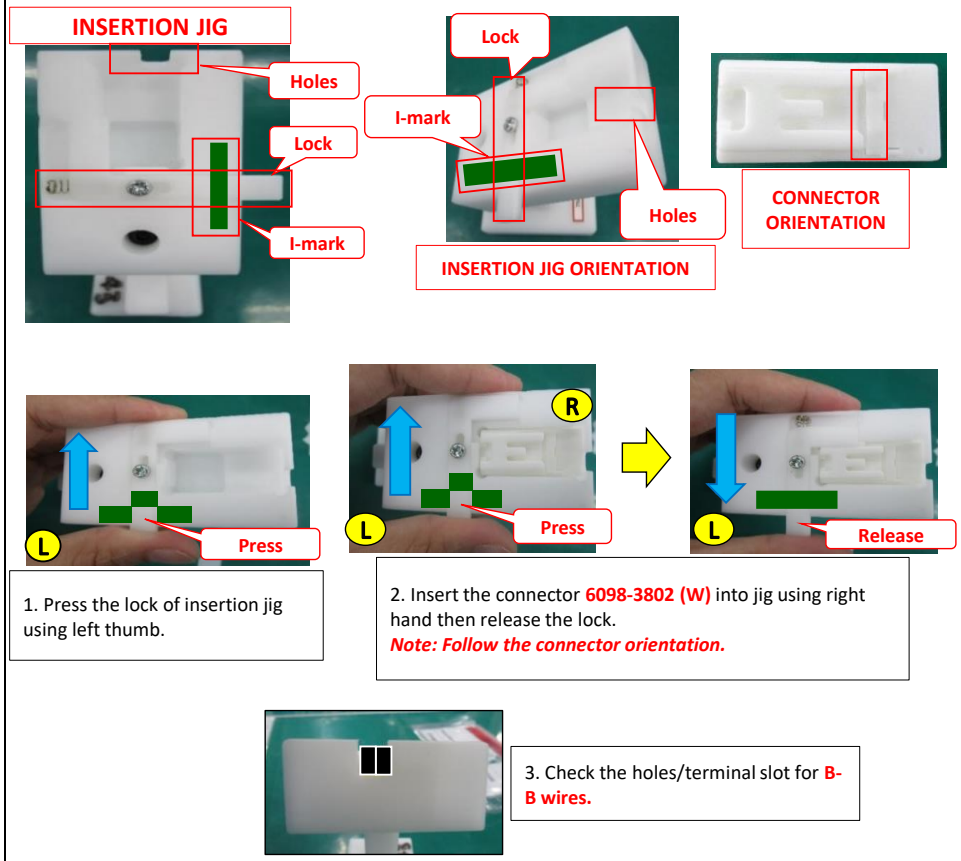
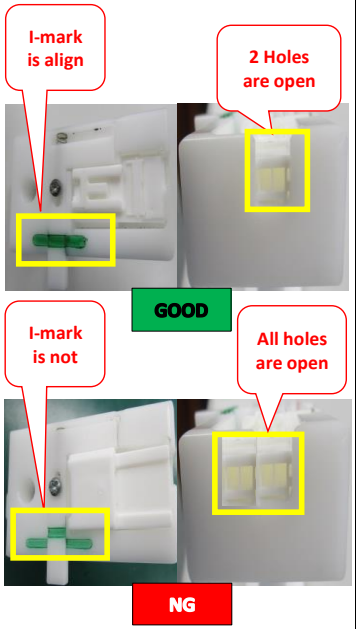
PARTS:	1. Connector 6098-3802 (W)	JIG	1. Insertion jig 2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6098-3802 (W)	 1. Press the lock of insertion jig using left thumb. 2. Insert the connector **6098-3802 (W)** into jig using right hand then release the lock. ***Note: Follow the connector orientation.*** 3. Check the holes/terminal slot for **B-B wires.**	n/a	**Connector Orientation Illustration**  1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

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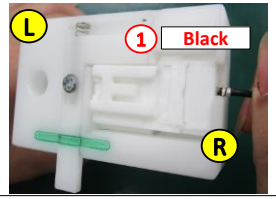
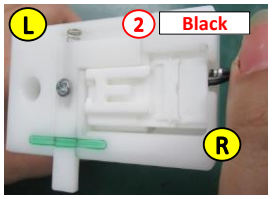
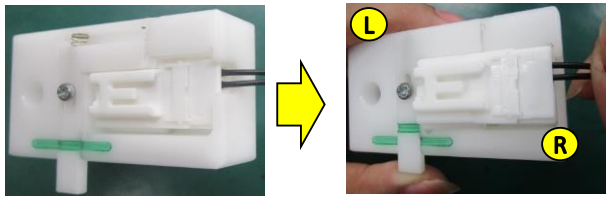
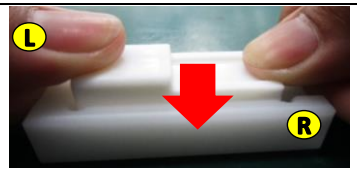
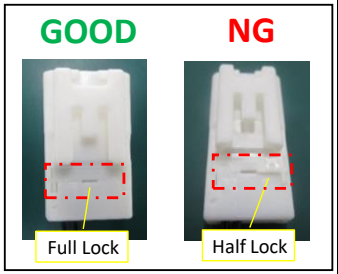
	Model Code/Part Number: 740BW / 7H0423W7020		Customer: NBS	Document No.:	WI-ENG-PDE-479A
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1 / Page No.: 3 of 5

PARTS:	1. AVSSf 0.3 B L=621±3mm [2pcs.]	JIG	1. Insertion jig 2. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	Wire insertion to connector 6098-3802 (W)	  Wire facing  1. Get the **1st Black wire** then insert to terminal slot 1 of connector using right hand. ***Note: Insertion of wires must be from left to right*** 2. Get the **2nd Black wire** then insert to terminal slot **2** of connector using right hand.  3. 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: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance* 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force." ***Note:** Please hold the wire near terminal during insertion.*
4		Connector lock	 1. Put the connector into locking jig both hands then press **2x** to lock using both hands. Touch the connector lock to confirm if properly locked. ***Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.***  Before pressing  After pressing 	**LOCKING JIG** 	***NOTE: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK*** 1. Use the provided locking jig per modle 2. No unlocked/half-locked connector 2. No damaged lock

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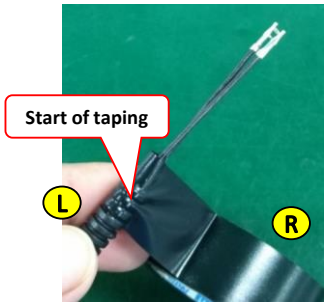
PARTS:	1. Assy parts 2. Black corrugated tube (no slit) ø5 L=518±5mm	**JIG**	1. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to corrugated tube (no slit) ø5 L=518±5mm	 1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the **B-B wires** using left hand.  2. Get the corrugated tube **(no slit) ø5 L=518±5mm** using right hand then insert the **B-B wires** using left hand.  3. After insertion, remove the terminal cover jig using right hand.	**TERMINAL COVER JIG** 	1. No wrong usage of parts 2. No deformed terminal
6		Taping 1 Black corrugated tube to wire near teminal	 1. Hold the COT using left hand, get the Black tape using right then start pre-taping at the middle of COT and wires using both hands.	n/a	1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension

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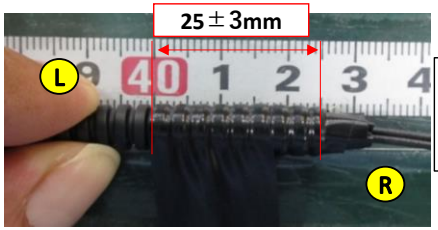
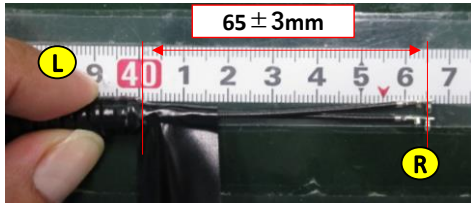
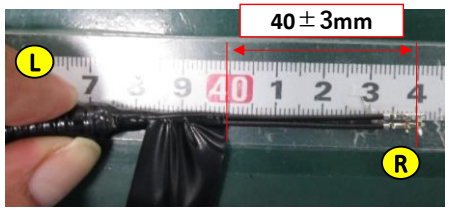
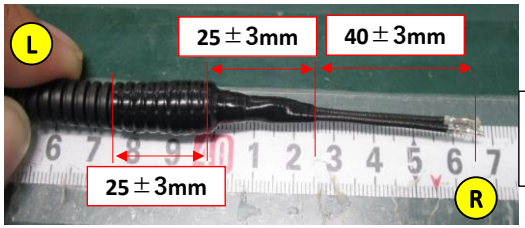
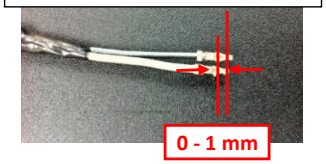
PARTS:	1. Assy parts 2. Black tape	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1	Taping 1 Black corrugated tube to wire near teminal (Continuation)	 2. Confirm measurement of **25±3mm** from end of tape up to COT then continue the taping process using both hands.  3. Measure from end of COT up to terminal pointed tip **L=65±3mm** then continue the taping process using both hands.  4. Confirm measurement of **40±3mm** from end of tape up to terminal pointed tip then continue the taping process using both hands.  5. After taping, check the measurement, terminal appearance and taping condition.	**MEASURING TAPE** 	**Wire alignment tolerance**  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 *Note:* *Please use calibrated/verified measuring tape when getting the measurement.*