



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	October 6, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-043B		
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Process Name/Title: **500B / 7L0084-7021** Customer: **TRQSS**

Model code/Part number: **500B / 7L0084-7021**

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	P2	<p>Connector setting to Insertion jig 6098-3810 (W)</p> <p>INSERTION JIG</p> <p>Holes</p> <p>Lock</p> <p>INSERTION JIG ORIENTATION</p> <p>I-MARK</p> <p>CONNECTOR ORIENTATION</p> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 6098-3810 (W) into jig using right hand and release the lock.</p> <p>Note: Follow the connector orientation.</p> <p>3. Check the holes/terminal slot for B/B wires.</p>		<p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping</p> <p>1. Maintain and always practice 5's.</p> <p>2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Connector Orientation Illustration</p> <p>I-mark was align</p> <p>2 holes were only open</p> <p>GOOD</p> <p>I-mark is NOT align</p> <p>All holes were open</p> <p>NG</p> <p>1. Use the provided jig per model</p> <p>2. No wrong orientation of connector</p> <p>3. No wrong use of connector</p> <p>4. No damaged connector</p>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
10/06/21	4	Change part number from 7L0084-7020A to 7L0084-7021 due to design change. Additional guidelines for Pull-Push-Pull-Push method (Refer to GL-PRO-ASY-029 for Pull-Push procedure).	D.Castillo	J.Loterte	C.Villanueva	A. Arañes	
02/20/21	3	Remove cycle time; Change 2x pulling to Pull-Push-Pull-Push; Change connector colors in accordance with color standardization for plastic parts (Please refer to GL-COM-003)	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	
10/28/19	0	Initial issue	J. Loterte	A. Shimamura	A. Arañes	-	
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date: October 28, 2019

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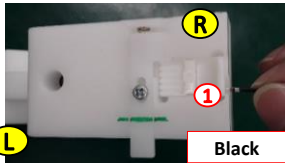
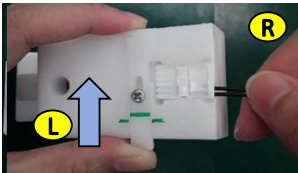

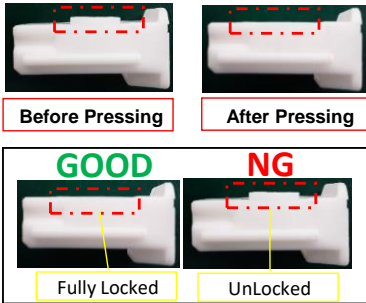

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PARTS:		1. AVSSf 0.3 wires B L=710mm [2pcs.] 2. Assy parts		JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to connector 6098-3810 (W)	<div>WIRE FACING</div> <div><div>1. Get the 1st Black wire then insert to connector slot 1 using right hand. <i>Note: insertion process must be from left to right.</i></div><div>2. Get the 2nd Black wire then insert to connector slot 2 using right hand.</div></div> <div><div>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.</div></div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>4 <i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></div>
3	Connector lock	<div><div>Put the connector into locking jig using both thumb then press to lock 2x. Touch the connector lock if properly locked. <i>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</i></div></div> <div><div>Before Pressing After Pressing</div><div>GOOD NG</div><div>Fully Locked UnLocked</div></div>		<div>LOCKING JIG</div> 	<div>NOTE: MANUAL LOCKING MAY CAUSE</div> <div>1. Use the provided locking jig per model 2. No unlock/half-lock connector</div>

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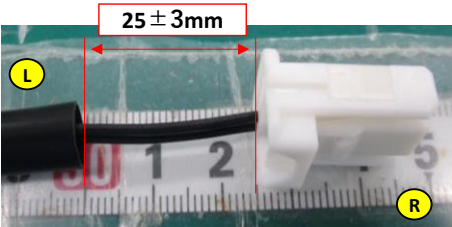
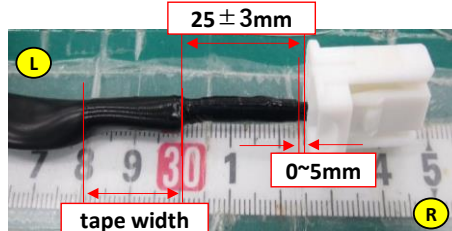
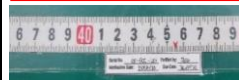
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PARTS:		1. Black Vinyl tube Ø7 L=95±3mm 2. Black tape			3. Assy parts	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
4		Wire Insertion to Vinyl tube Ø7 L=95±3mm	 <p>1. Get the black vinyl tube Ø7 L=95 ± 3mm using right hand and insert the Black wires.</p>			n/a	1. No wrong usage of parts
5	P2	Taping 1 Vinyl tube to wire near connector	 <p>1. Measure from end of vinyl tube up to edge of connector 25±3mm using both hands.</p>  <p>2. Get the Black tape using right hand then start taping process using both hands. Note: Please refer to WI-PRO-ASY-001 for taping procedure.</p> <p>3. After taping, check the measurement and taping condition.</p>			 <p>MEASURING TAPE</p>	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension

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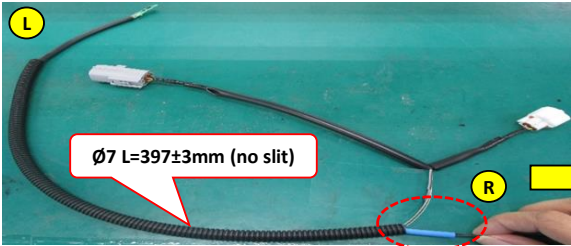
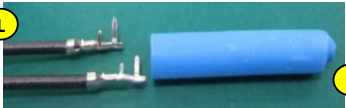

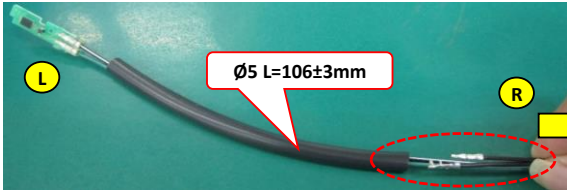
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PARTS:		1. Assy parts			JIG	1. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
6	P2	Wire insertion to assy parts (Black corrugated tube Ø7 L=397±3mm) (no slit)	 <p>1. Get the cover jig then insert to B/B wires using right hand.</p>  <p>Ø7 L=397±3mm (no slit)</p> <p>2. Hold the corrugated tube Ø7 L=397±3mm (no slit) using left hand then insert the assy parts using right 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 wrong insertion NOTE: USE TERMINAL COVER JIG TO AVOID TERMINAL DEFORMATION
7		Wire insertion to assy parts (Black sunprene tube Ø5 L=106±3mm)	 <p>Ø5 L=106±3mm</p> <p>1. Hold the Black sunprene tube Ø5 L=106±3mm using left hand then continue to insert the assy parts using right hand.</p>			n/a	1. No wrong usage of parts 2. No wrong insertion

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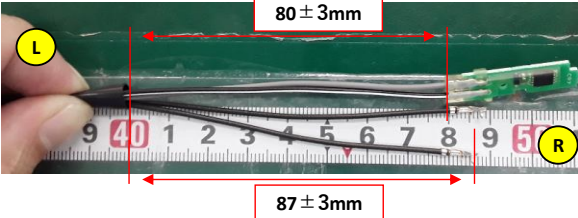
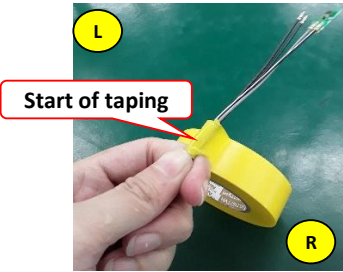
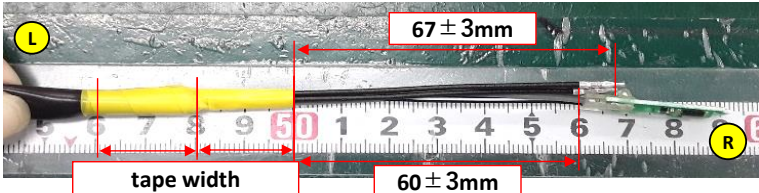

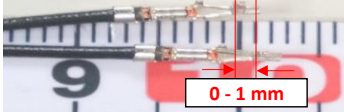
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PARTS:		1. Assy parts 2. Yellow tape			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
8	P2	<div><p>1. Hold vinyl tube using left hand, measure from Sunprene tube to end of hotmelted wire 80 ± 3mm and from sunprene tube to terminal tip 87 ± 3mm</p></div> <div><p>2. Get the Yellow tape using right hand then start taping process using both hands. <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>			<div>MEASURING TAPE</div> 	<div>NOTE: USE YELLOW TAPE only.</div> <div>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</div> <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Wire alignment tolerance</div> 

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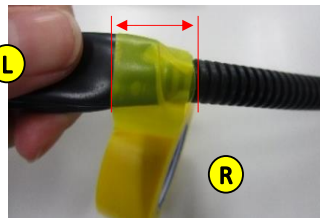
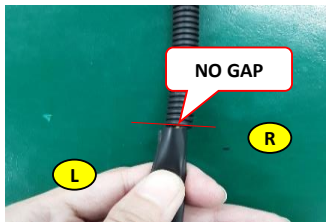
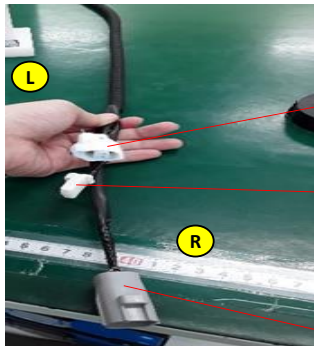
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PARTS:		1. Assy parts 2. Black tape			JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P2	Y-Taping	<div><p>1. Conduct harness facing using both hands.</p><p>2. Fix the vinyl tube and corrugated tube. Make sure that there is no gap in between.</p><p>3. Get the BLACK tape using right hand then make 1 wind pre-taping at the center of vinyl tube and corrugated tube using both hands. Note: Do not exert extra force during taping.</p></div>		n/a	<div><p>NOTE: USED YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES. BUT ACTUAL SHOULD BE <u>BLACK.</u></p><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>

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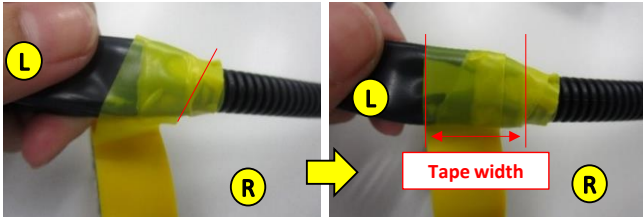
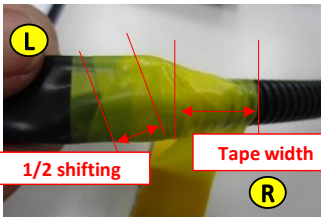
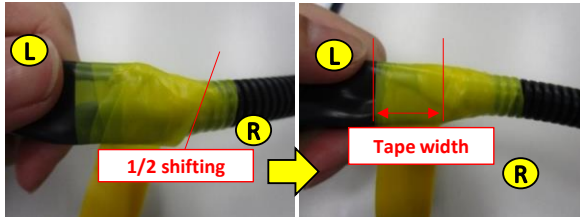
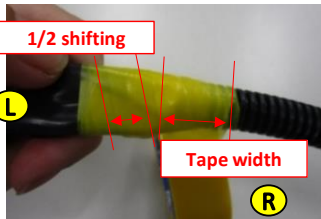
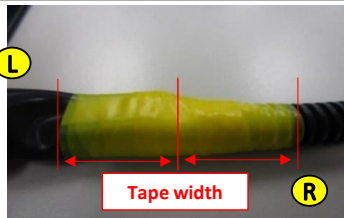

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P2 Y-Taping (Continuation)	<div><p>4. Make 1/3 shifting going to vinyl tube until tape width then make 1 winding of tape before shifting.</p></div> <div><p>5. Make 1/2 shifting going to COT until tape width then make 1 winding of tape before shifting.</p></div> <div><p>6. Make 1/2 shifting going to vinyl tube until tape width then make 2 windings of tape before final shifting.</p></div> <div><p>7. Make 1/2 shifting going to COT until tape width then make 2 windings of tape then cut the tape.</p></div> <div><p>8. After taping, check the measurement and taping condition.</p></div>	<div>MEASURING TAPE</div> 	<div>NOTE: USED YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES. BUT ACTUAL SHOULD BE BLACK.</div> <div>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</div>

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