

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**Model Code/Part Number: **101D / 7N0097-7020A**

Customer:

**TRJ**

Effectivity Date:

**June 10, 2022**

Validity Date:

**n/a**

Docu WI-ENG-PDE-239B

**WI-ENG-PDE-534B**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

**1**

Page No.:

**1 of 7****PARTS:**

1. Assy parts

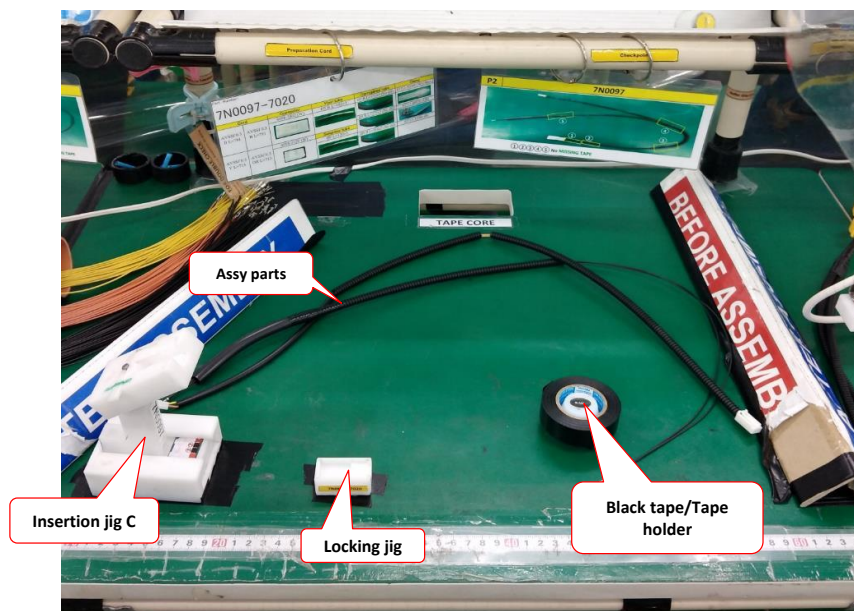
JIG:

1. Insertion jig  
2. Locking jig**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P2

Table Lay-out

**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.

1. No missing parts/tools
2. No excess parts/tools

**Revision History**

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
6/10/2022	1	Change purpose from Pre-launch to Masspro.	K. Doria	J. Loterte	C. Villanueva	A. Arañes
6/2/2022	0	Initial Issue	K. Doria	J. Loterte	C. Villanueva	A. Arañes

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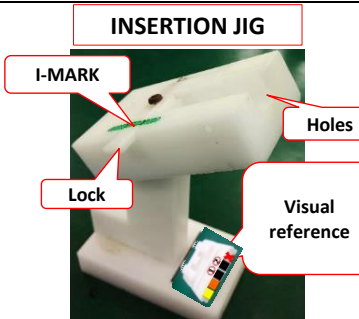
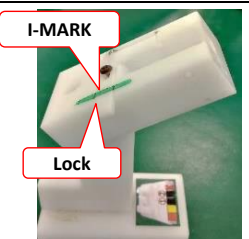

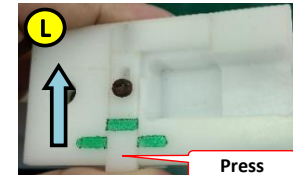


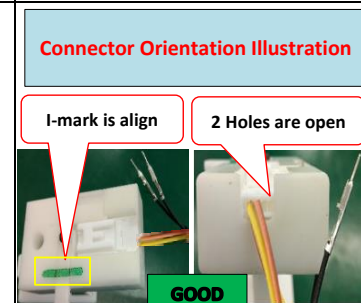
☒ MASSPRO

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PARTS:		1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to assy parts	  <p>1. Hold the corrugated tube (no slit) <b>Ø5 L=171±3mm</b> using left hand then insert the assy parts using right hand.</p> <p>2. Hold the vinyl tube <b>Ø5 L=182±3mm</b> using left hand then insert the assy parts using right hand.</p>			n/a	1. No wrong use of parts 2. No deformed terminal 3. No wrong insertion
3	Connector setting to insertion jig 6098-3802 (W) (Assy parts)	      <p><b>INSERTION JIG</b></p> <p><b>I-MARK</b></p> <p><b>Lock</b></p> <p><b>Holes</b></p> <p><b>Visual reference</b></p> <p><b>INSERTION JIG ORIENTATION</b></p> <p><b>CONNECTOR ORIENTATION</b></p> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector <b>6098-3802 (W)</b> into jig using right hand and release the lock.</p> <p>3. Check the holes for <b>B/B wires</b>, it must be opened.</p>			n/a	 <p><b>Connector Orientation Illustration</b></p> <p><b>I-mark is align</b></p> <p><b>2 Holes are open</b></p> <p><b>GOOD</b></p> <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>

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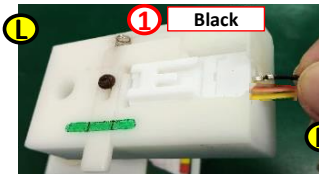
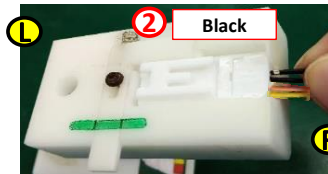
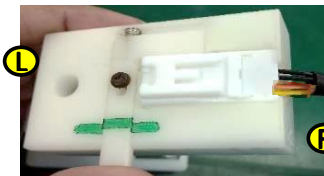
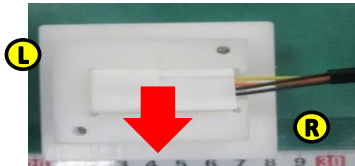


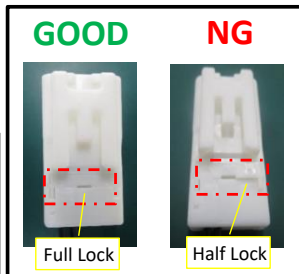

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts			JIG	1. Insertion jig 2. Locking jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
4	P2	Wire insertion to connector 6098-3802 (W) (Assy parts)	<div><div>Wire facing</div></div> <div><div>1 Black</div><div>1. Get the assy part and hold the <b>B wire</b> then insert to terminal slot <b>1</b> using right hand. <i>Note: Insertion of wires must be from left to right</i></div></div> <div><div>2 Black</div><div>2. Hold the <b>B wire</b> then insert to terminal slot <b>2</b> 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	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 <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.	
5		Connector lock	<div><div>1. Put the connector into locking jig using right hand then press <b>2x</b> to lock. Check the connector lock to confirm 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</div></div> <div><div>After pressing</div></div> <div><div><b>GOOD NG</b> Full Lock Half Lock</div></div>		<div><div>LOCKING JIG</div></div>	<b>NOTE:</b> <b>MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</b> 1. Use the provided locking jig per model 2. No unlock/half-lock connector	

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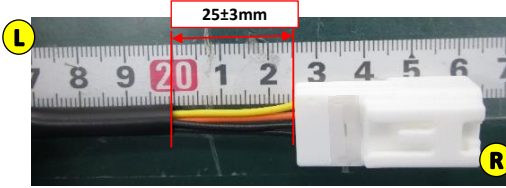
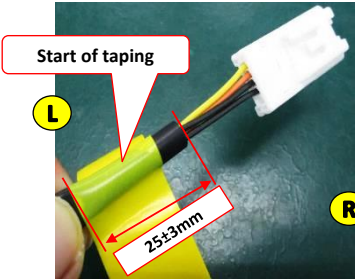
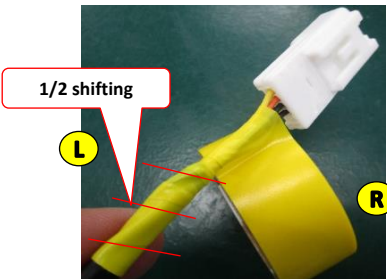
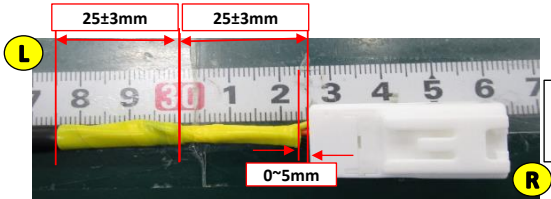

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:

<b>PARTS:</b>	1. Assy parts 2. Black tape		<b>JIG</b>	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2  Taping 1 Black vinyl tube to wire near connector	 <p>1. Measure from end of vinyl tube up to connector <b>25mm</b> using both hands.</p>  <p>2. Get the <b>Black tape</b> using right hand then attach at <b>25mm</b> in measure of vinyl tube, make <b>2 windings</b> of tape at vinyl tube using both hands.</p>  <p>3. Make <b>1/2 shifting</b> using both hands going to wire side then make <b>3 windings</b> of tape then cut the tape.</p>  <p>4. After taping, check the taping condition and measurement.</p>	<p><b>MEASURING TAPE</b></p> 	<p><b>NOTE:</b> <b>USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</b></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> <p><b>Note:</b> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p>

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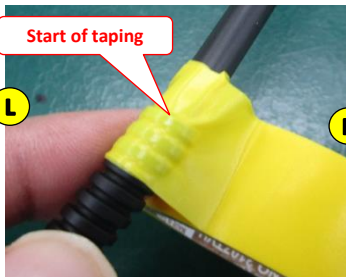
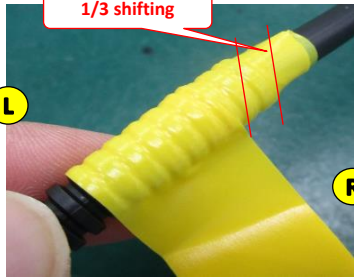
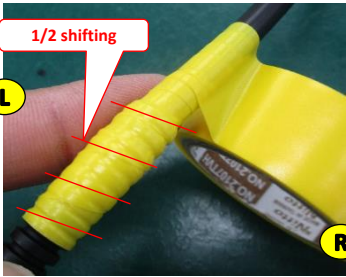
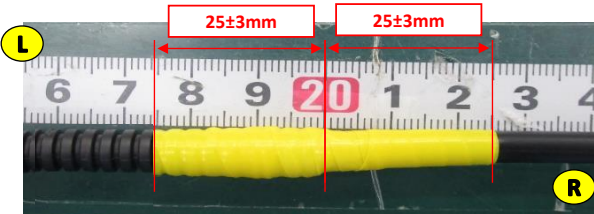

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P2 Taping 2 Black Corrugated tube to Black vinyl tube near connector	<div><p>1. Get the <b>Black tape</b> using right hand then make <b>2 windings</b> of tape at the middle of COT and vinyl using both hands.</p></div> <div><p>2. Make <b>1/3 shifting</b> using both hands going to the side of COT until it reach <b>25mm</b> then make <b>2 windings</b> of tape before shifting to other side.</p></div> <div><p>3. Make <b>1/2 shifting</b> using both hands going to other side of vinyl tube then make <b>3 windings</b> of tape and cut the tape.</p></div> <div><p>4. After taping, check the taping condition and measurement.</p></div>	<div><b>MEASURING TAPE</b></div> 	<p><b>NOTE:</b> <b>USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE <u>BLACK TAPE</u>.</b></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> <p><b>Note:</b> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p>

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### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

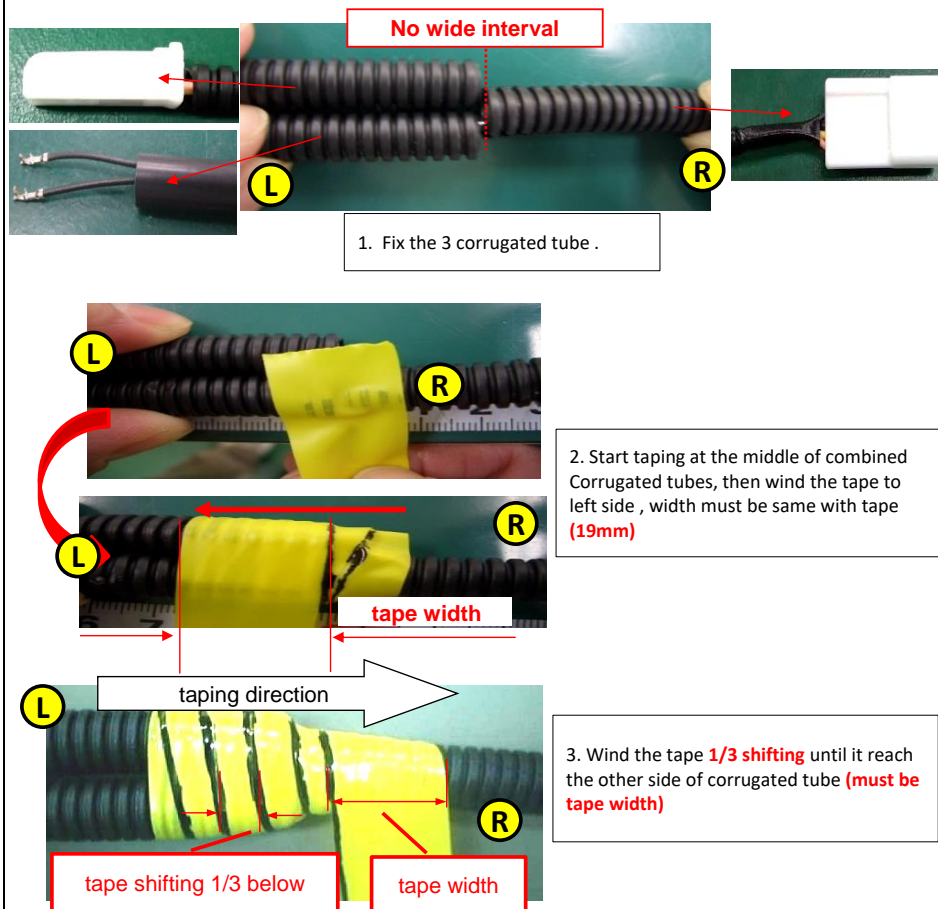
TOOLS/PPE

QUALITY POINTERS

8

P2

Y-Taping



n/a

### NOTE:

USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK 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

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### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

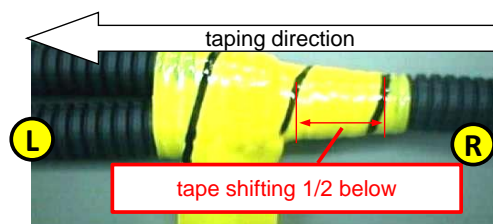
TOOLS/PPE

QUALITY POINTERS

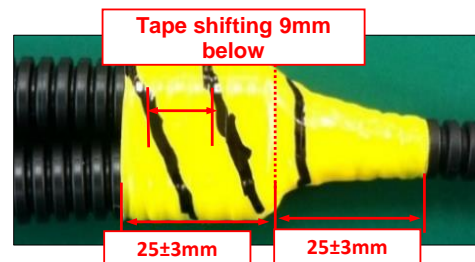
8

P2

Y-Taping  
(Continuation)



4. Wind the tape backward **1/2 shifting**



5. Wind the tape **1/2 shifting** going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.

MEASURING TAPE



**NOTE:**  
**USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.**

1. No flip-out tape
2. No peel-off tape
3. No loose tape
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