

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**Product Name/Code: **740A / Z03-81090-R740A**Customer: **NBC-HAYASHI**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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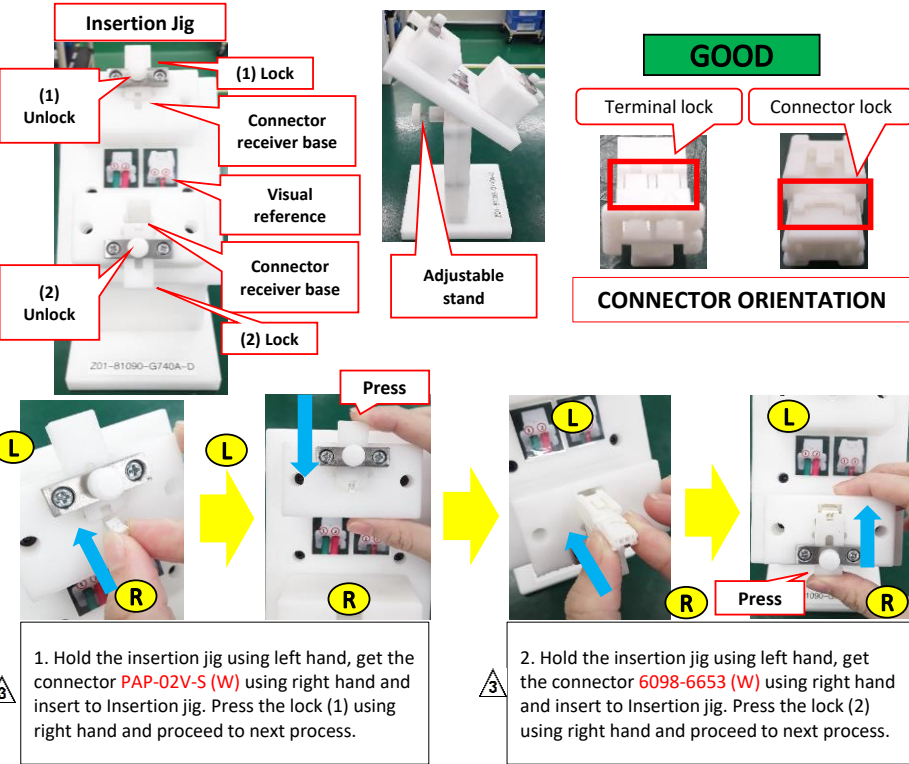
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
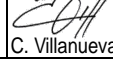
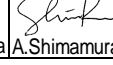
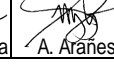

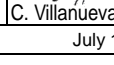
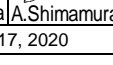
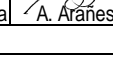
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**PARTS:**   
1. Connector PAP-02V-S (W)  
2. Connector 6098-6653 (W)**JIG:** 1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Connector setting to Insertion jig	 <p><b>GOOD</b></p> <p><b>CONNECTOR ORIENTATION</b></p> <p><b>Terminal lock</b></p> <p><b>Connector lock</b></p> <p><b>Adjustable stand</b></p> <p><b>Press</b></p> <p><b>1. Hold the insertion jig using left hand, get the connector PAP-02V-S (W) using right hand and insert to Insertion jig. Press the lock (1) using right hand and proceed to next process.</b></p> <p><b>2. Hold the insertion jig using left hand, get the connector 6098-6653 (W) using right hand and insert to Insertion jig. Press the lock (2) using right hand and proceed to next process.</b></p>	<p><b>Safety Instruction</b></p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b></p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>NG</b></p> <p><b>Connector orientation</b></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	Revise	Check	Approve	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/29/21	3	Change connector color in accordance with color standardization for plastic parts refer to GL-COM-003 Put measuring tape illustration and instruction in Measurement	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
10/13/20	2	Change Part number only from Z01-81090-R740A-D to Z03-81090-R740A; remove cycle time; Apply some improvements	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
07/17/20	0	Initial issue.	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				

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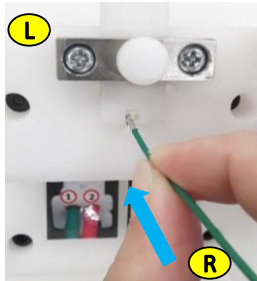
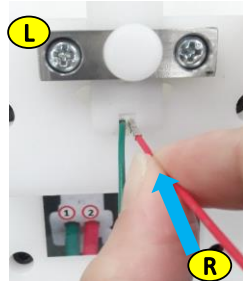
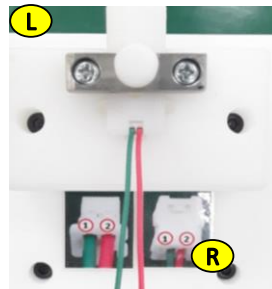
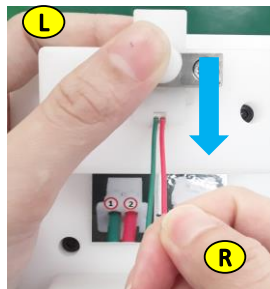

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**PARTS:** 1. AVSS 0.3 wires R L=158mm; G L=158mm**JIG**

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 3 Wire Insertion to Connector PAP-02V-S (W)	<div> <b>Wire facing</b></div> <div></div> <div></div> <div></div> <div></div> <div>1. Hold the insertion jig using left hand, get the <b>Green wire</b> using right hand and insert to connector. Conduct 2x push pull. Repeat the process for <b>Red wire</b>. <i>Note: Follow insertion sequence based on visual reference attached to jig.</i></div> <div>2. Check the wire insertion. Press the unlock button using left hand, hold the wires using right hand and slowly remove the assy parts from jig.</div>	n/a	<p><i>Note: Please hold the wire near terminal during insertion.</i></p> <ol style="list-style-type: none"><li>1. No loose insertion</li><li>2. No wrong insertion</li><li>3. One by one insertion</li><li>4. No deform terminal</li><li>5. No wrong wire facing.</li></ol> <p>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p> <div></div> <p><b>Note:</b> Terminal tip must be visible.</p>

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Process Name/Title:

Product Name/Code:

**740A / Z03-81090-R740A**

Customer:

**NBC-HAYASHI**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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**PARTS:**

1. Assy parts

**JIG**

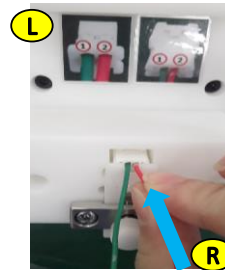
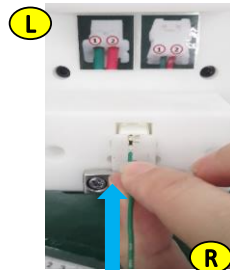
1. Insertion jig

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

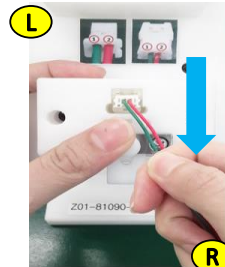
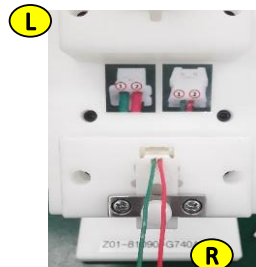
3

P1

3

Wire Insertion to  
Connector  
6098-6653 (W)**Wire facing**

1. Hold the insertion jig using left hand, get the **Green wire** using right hand and insert to connector. Conduct 2x push pull. Repeat the process for **Red wire**.  
*Note: Follow insertion sequence based on visual reference attached to jig.*



2. Check the wire insertion. Press the unlock button using left hand, hold the wires using right hand and slowly remove the assy parts from jig.

n/a

*Note: Please hold the wire near terminal during insertion.*

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.

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☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

n/a

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

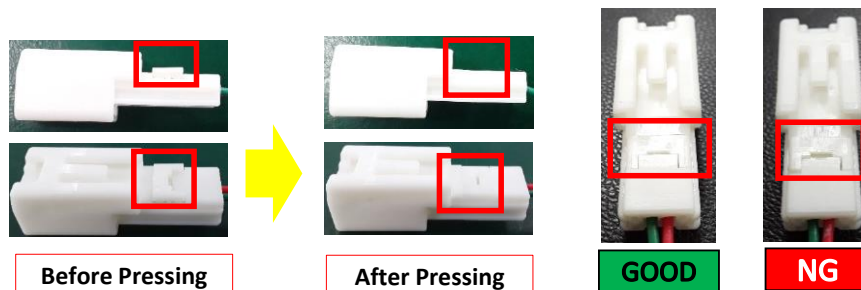
TOOLS/PPE

QUALITY POINTERS

4

P1

Connector lock



1. Put the connector into locking jig and press to lock using right thumb. Touch the connector lock to confirm if properly pressed.

*Refer to GL-PRO-ASY-017 Verification of Coupler lock.*

LOCKING JIG



1. No Unlock/Half-locked

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PARTS:

n/a

JIG

1. Continuity checker jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

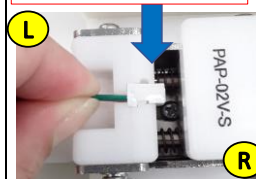
P1

Continuity checking

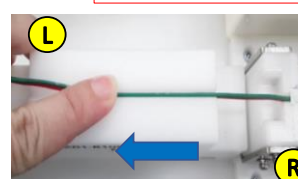
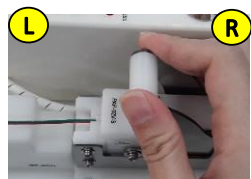
### Setting and Removal Sequence



#### Connector setting



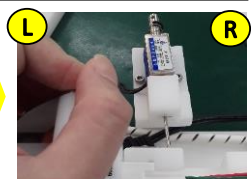
1. Get the assy parts using both hands. Put first the small connector PAP-02V-S to checker 1 and plug in using right hand.



2. Secondly, put the wires on wire guide. Straighten the wire and make sure no curve wires.



3. Lastly, put the connector 6098-6653 on checker 2 and plug in using left hand. Go sound will be heard after marking.



4. Plug-out the checker same as how to set the harness using both hands. Conduct **Point checking** and remove the assy parts carefully.

n/a

1. No wrong setting and attachment of harness to continuity test.  
2. If encountered problem, apply **STOP, CALL** and **WAIT**.

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**PARTS:**

n/a

**JIG**

n/a

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

6

Visual/By two's inspection

P1

1. Check the connector lock and presence of marking.  
*Refer to GL-ENG-PDE-013 for Traceability Marking matrix.*

2. Check the wire insertion if there is terminal backing out.



3. Compare to Master Sample.  
*Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.*

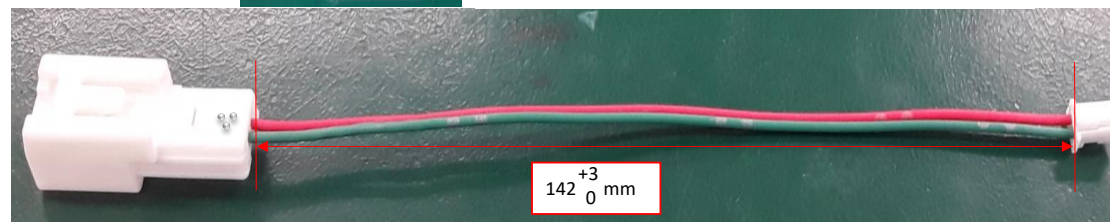
**MASTER SAMPLE**

7

Measurement



**Note:**  
*Please use calibrated/verified measuring tape when getting the measurement.*

**NOTE: HATSUMONO AND OWARIMONO**

1. No wrong dimension

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