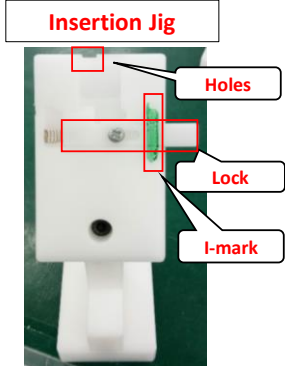
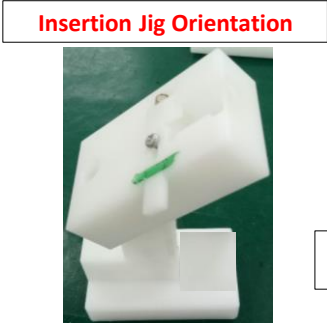
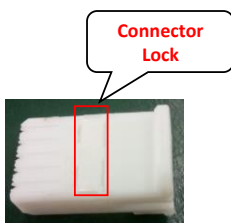

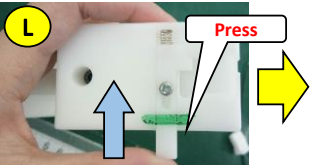
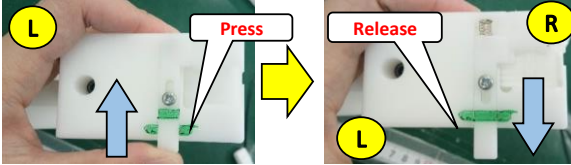








	WORK INSTRUCTION				Effectivity Date: July 06, 2021	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date: n/a	
	Product Name/Code: 948B / 7L0096-7021		Customer: TRQSS		Document No.: WI-ENG-PDE-068A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 3		Page No.: 1 of 4	

PARTS: 1. Connector 6098-3810 (W)		JIG: 1. Insertion jig	
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Connector Setting to Insertion jig 6098-3810 (W)	<div>     </div> <div>    </div>	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Connector Orientation Illustration</p> <div>   </div> <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						Prepared by	Reviewed by	Approved by	Noted by	
07/06/21	3	Removal of validity date.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	 J. Loterte	 C. Villanueva	 A. Shimamura	 A. Arañes
01/09/21	2	Change connector color in accordance to standardization for plastic parts; Change quality pointer 2x pulling to Pull-Push-Pull-Push for insertion process; Change procedure/illustration of taping on dia.4 vinyl tube	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
06/22/20	1	Change effectivity and validity date: Change the dimension of Vinyl to terminal tip from 54mm to 55mm and tape to terminal tip from 34mm to 35mm	J. Loterte	A. Shimamura	A. Arañes	n/a				
03/13/20	0	Initial issue.	J. Loterte	A. Shimamura	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change			Revise	Check	Approve	Note	Est. Date:	March 13, 2020

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **948B / 7L0096-7021**Customer: **TRQSS**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

July 06, 2021

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Document No.:

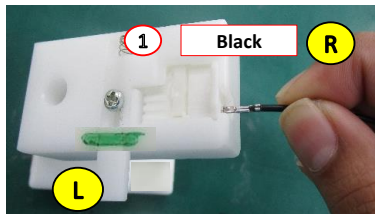
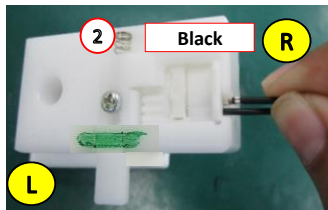

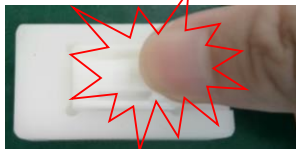


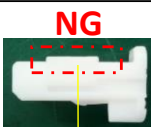


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PARTS:		1. AVSSf 0.3 Wires B L=413mm (2pcs)			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Wire Insertion to Connector 6098-3810 (W)	<div><div></div><div></div><div></div><div>1. Get the first Black wire and insert to Slot 1 of connector using right hand. Conduct 2x push pull after wire insertion.</div><div>2. Get the 2nd Black wire and insert to Slot 2 of connector using right hand. Conduct 2x push pull after wire insertion.</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> <td>n/a</td> <td>1. No loose insertion 2. No wrong dimension 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Make sure wires are properly inserted Conduct Pull-Push-Pull-Push after insertion Do not exert extra force.</td>		n/a	1. No loose insertion 2. No wrong dimension 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Make sure wires are properly inserted Conduct Pull-Push-Pull-Push after insertion Do not exert extra force.
3		Connector lock	<div></div> <div>1. Put the connector into locking jig using right hand then press to lock 2x. <i>Refer to GL-PRO-ASY-017 for verification of connector lock.</i></div> <div><div></div><div></div></div>		LOCKING JIG 	1. No unlocked/half-locked connector 2. Use provided jig tool to lock the connector NOTE: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK

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

Effectivity Date:

July 06, 2021

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PARTS:		1. Black Corrugated tube $\phi 5$, L=320 \pm 3mm 2. Black Vinyl tube $\phi 4$ L=30 \pm 3mm	3. Assy parts	JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Wire Insertion to Corrugated tube $\phi 5$, L=320 \pm 3mm	<div><p>1. Get the terminal cover jig using right hand then insert the 2 Black wires.</p></div> <div><p>2. Get the Black corrugated tube $\phi 5$ L=320\pm3mm (no slit) using right hand and insert the 2 Black wires.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>	TERMINAL COVER JIG 	1. No wrong usage of parts 2. No deformed terminal
5		Wire Insertion to Vinyl tube $\phi 4$ L=30 \pm 3mm	<div><p>1. Get the Vinyl tube $\phi 4$ L=30\pm3 using right hand then insert the 2 Black wires.</p></div>	n/a	1. No wrong usage of parts 2. No deformed terminal

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WORK INSTRUCTION

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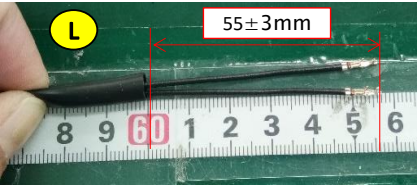
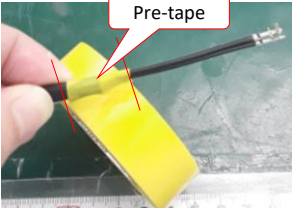
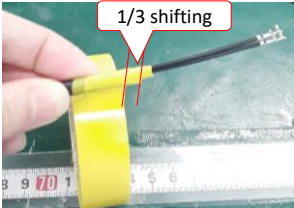
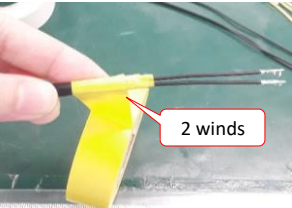
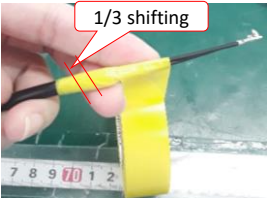
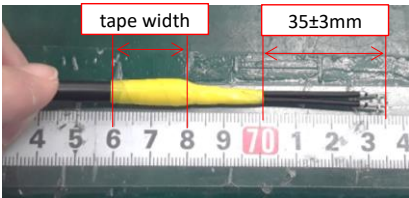

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PARTS:	1. Black tape 2. Assy parts			JIG	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	Taping 1 Vinyl tube to wire near terminal		MEASURING TAPE	<p>NOTE: USED YELLOW TAPE TO EASY VISUALIZE TAPE WINDINGS, BUT ACTUAL SHOULD BE BLACK.</p> <p>1. No loose tape 2. No flip-out tape 3. No peel-off tape</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Wire alignment tolerance</p>
		 <p>1. Hold the vinyl tube using left hand and measure from vinyl tube to terminal tip <u>55±3mm</u>.</p>  <p>Pre-tape</p>  <p>1/3 shifting</p>  <p>2 winds</p> <p>2. Get Black tape, conduct pre-taping between vinyl tube and wires. Make 1/3 shifting going to Vinyl tube then make 2 winds (must be tape width).</p>  <p>1/3 shifting</p>  <p>tape width</p> <p>35±3mm</p> <p>3. Make 1/3 shifting to wire. Note: No folding required for Vinyl tube with ø4. Make 3 winds on wire then cut the tape.</p> <p>4. After taping, check the measurement, wire alignment and taping condition.</p>		 <p>0 - 1 mm</p>	

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