

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 12, 2022

Model Code/Product Number: **749W / 7H0337W7020B**

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-489A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:

1. All parts; Connector 6098-3810(W); AVSSf 0.3 B wire L=402±3mm; AVSSf 0.3 V wire L=442±3mm; Black Corrugated tube Ø7 L=138±3mm (No slit); Black Corrugated tube Ø5 L=174±3mm (No slit); Black Vinyl tube Ø5 L=22±3mm; Black tape

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	<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<ol style="list-style-type: none">1. No missing parts/tools.2. No excess parts/tools.

Revision History

Eff. Date	Rev. No	Details of Change	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	Prepared by	Reviewed by	Approved by	Noted by
05/12/22	1	Change from Pre-Launch to Masspro. Additional table Lay-out.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
04/26/22	0	Initial Issue.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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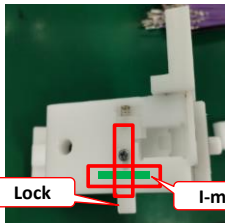
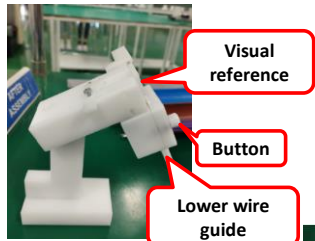
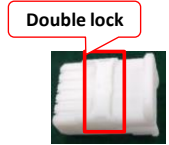

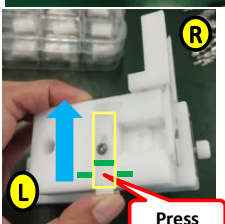
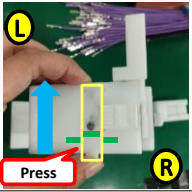
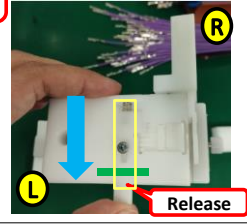

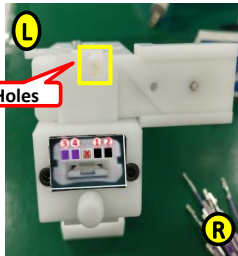

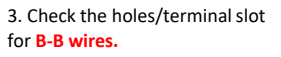


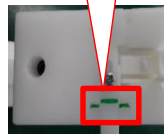

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PARTS:		1. Connector 6098-3810(W)			JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Connector Setting to Insertion jig 6098-3810(W)	<div><div><div>Insertion Jig</div><div>Lock</div><div>I-mark</div><div>Press</div></div><div><div>Insertion Jig Orientation</div><div><div>Visual reference</div><div>Button</div><div>Lower wire guide</div></div><div><div>Double lock</div></div><div><div>CONNECTOR ORIENTATION</div></div><div><div>Press</div><div>Release</div></div><div><div>Press</div><div>Release</div></div><div><div>Release</div></div><div><div>Press</div></div><div><div>Release</div></div><div><div>Release</div></div><div><div>Release</div></div></div><div><div>2. Insert the connector 6098-3810 (W) using right hand and release the lock using left hand. Note: Follow the connector orientation.</div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div>		n/a	<div><div><div>I-mark was align</div><div>GOOD</div></div><div><div>2 holes were only open</div><div>GOOD</div></div><div><div>I-mark is NOT align</div><div>NG</div></div><div><div>All holes were open</div><div>NG</div></div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>

1. Press the lock of insertion jig using left thumb.

2. Insert the connector 6098-3810 (W) using right hand and release the lock using left hand.
Note: Follow the connector orientation.

3. Check the holes/terminal slot for B-B wires.

n/a

I-mark was align

2 holes were only open

GOOD

I-mark is NOT align

All holes were open

NG

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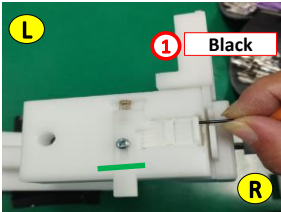
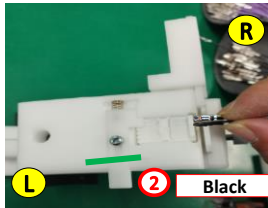
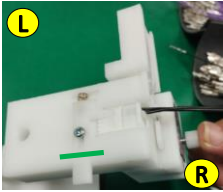
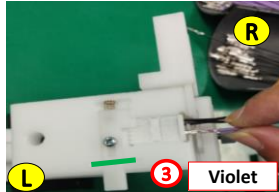
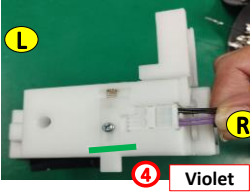
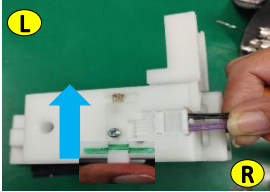

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Connector 6098-3810(W) 2. AVSSf 0.3 B wire L=402±3mm [2pcs.] 3. AVSSf 0.3 V wire L=442±3mm [2pcs.]			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to Connector (W)	<div><p>1. Get the 1st Black wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Get the 2nd Black wire then insert to terminal slot 2 using right hand.</p></div> <div><p>3. Press the button using right thumb. The slot for V-V wires will be opened.</p></div> <div><p>4. Get the 1st Violet wire then insert to terminal slot 3 using right hand.</p></div> <div><p>5. Get the 2nd Violet wire then insert to terminal slot 4 using right hand.</p></div> <div><p>6. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div> <div><p>Wire facing</p></div>			n/a	<p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p> <p><i>Note: Please hold the wire near terminal during insertion.</i></p> <ul style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deformed terminal5. No wrong wire facing <p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p><i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p>

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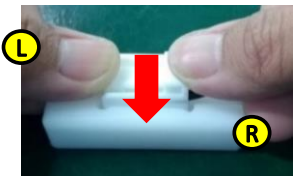

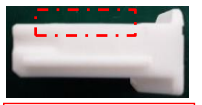


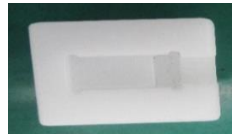



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PARTS:		1. Assy parts 2. Black Corrugated tube Ø7 L=138±3mm (No slit)		JIG	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Connector lock	<div><p>1. Put the connector into locking jig using right hand then press to lock 2x using both hands. Touch the connector if it is properly locked. <i>Refer to GL-PRO-ASY-017 for verification of connector lock.</i></p><div><p>Before Pressing</p><p>After Pressing</p><div><p>GOOD Fully Locked</p><p>NG reciever</p></div></div></div>	<div><p>LOCKING JIG</p></div>	<p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p> <p>1. Use the provided locking jig per model 2. No unlock/half-lock connector</p>
5		Wire Insertion to Black Corrugated tube Ø7 L=138±3mm (No Slit)	<div><p>1. Get the terminal cover jig using right hand then insert the B-B wires using left hand.</p><p>2. Get the Black COT Ø7 L=138±3mm (No Slit) using right hand and insert B-B wires using left hand.</p><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>	<div><p>Terminal cover jig</p></div>	<p>1. No wrong use of parts 2. No deformed terminal</p>

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PARTS:		1. Assy parts 2. Black Corrugated tube Ø5 L=174±3mm (No slit)		JIG	1.Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1	Wire Insertion to Black Corrugated tube Ø5 L=174±3mm (No slit)	<div><p>1. Get the terminal cover jig using right hand then insert the B-B wires using left hand.</p></div> <div><p>2. Get the Black COT Ø5 L=174±3mm (No slit) using right hand and insert B-B wires using left hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>	<div>Terminal cover jig</div> 	1. No wrong use of parts 2. No deformed terminal

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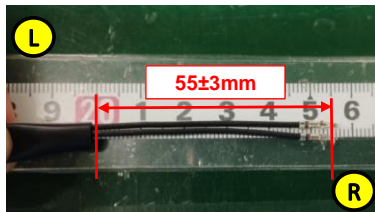

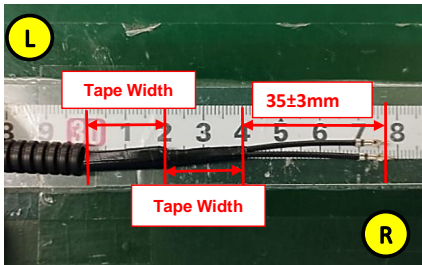


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PARTS:		1. Assy parts 2. Black Vinyl tube $\varnothing 5$ L=22 \pm 3mm 3. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7		<div><p>1. Get the Black Vinyl tube $\varnothing 5$ L=22\pm3mm using right hand and insert B-B wires using left hand.</p></div>	n/a	1. No wrong use of parts 2. No deformed terminal
8	P1 Taping 1 Black vinyl Tube to Wire near Terminal	<div><p>1. Measure the end of the Vinyl tube up to the end of the terminal pointed tip 55mm using both hands.</p></div> <div><p>2. Get Black tape, hold the vinyl tube ($\varnothing 5$ L=22\pm3mm) using left hand then fold the vinyl tube and start taping using right hand. <i>Refer to WI-PRO-ASY-001 for taping procedure</i></p></div> <div><p>3. After taping, check the measurement, alignment and tape condition.</p></div>	<div>MEASURING TAPE</div> 	<div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div> <div>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</div> <div><p>Wire alignment tolerance 0 ~ 1 mm</p></div>

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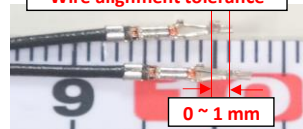
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PARTS:		1. Assy parts.		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	<div><div><div><div><div>L</div><div><div><div>77±3mm</div></div></div></div><div><div>R</div></div></div><div><div>1. Measure the end of the COT up to the end of the terminal pointed tip 77mm using both hands.</div></div></div><div><div><div><div>L</div><div><div><div>Start of Pre-taping</div></div></div><div><div>R</div></div></div><div><div><div>Tape Width</div></div></div></div><div><div>2. Get the Black tape and start taping process using both hands. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></div></div></div><div><div><div><div><div>Tape Width</div></div><div><div>35±3mm</div></div><div><div>Tape Width</div></div></div></div><div><div>3. After taping, check the measurement and taping condition.</div></div></div></div>		<div><div>MEASURING TAPE</div><div></div></div>	<div><div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div><div><div>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</div></div><div><div><div>Wire alignment tolerance</div><div><div>0 ~ 1 mm</div></div></div><div></div></div></div>

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