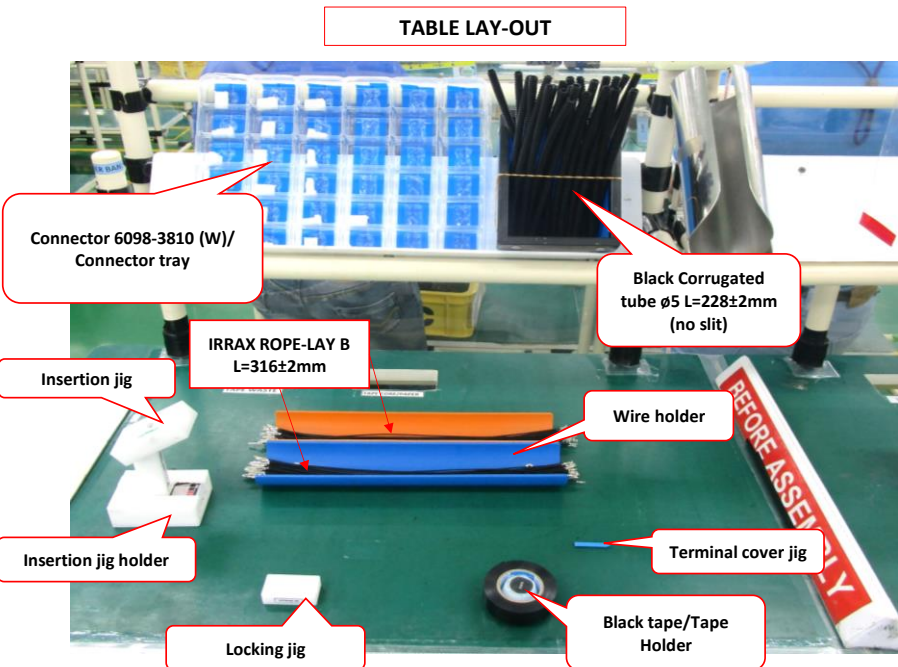

	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:	September 23, 2022		
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	Model Code/Part Number: 817B / 7N0050-7020B		Customer: TRJ		Document No.:	WI-ENG-PDE-257A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	1 of 6

PARTS:		1. All parts (Connector 6098-3810(W); IRRAX ROPE-LAY B L=316±2mm; Black Corrugated tube ø5 L=228±2mm (no slit)) 2. Black tape [1pc.]		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 style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		Document reference/s:  1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No missing parts/tools 2. No excess parts/tools	

Revision History				Prepared by	Reviewed by	Approved by	Noted by
09/23/22	3	Improve quality pointers: Reminders/notes and references in process no.1,2,3,4 and 6 due to document improvement. Work procedure/illustration in process no.4 - connector lock. Change of tolerance from end of tape up to terminal pointed tip 33+2mm/-1mm to 33+3mm/-1mm as countermeasure due to encountered minimum dimension.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	
01/03/22	2	Inclusion of wire tolerance in all wires in parts section. Additional checkpoint "Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance". Improve work procedure and illustration. Change COT length from L=230±3mm to L=228±2mm; Change tolerance in taping process from L=53±3mm to L=55±1mm and from L=33±3mm to L=33+2mm/-1mm due to encountered minimum dimension from end tape to terminal tip	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	
07/08/21	1	Changed from pre-launch to masspro.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: April 8, 2021

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

Model Code/Part Number: **817B / 7N0050-7020B** Customer: **TRJ**

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
2	P1 Connector setting to insertion jig 6098-3810 (W)	<div><div><div>INSERTION JIG</div><div></div></div><div><div>Connector lock</div><div></div></div><div><div>Connector Orientation</div><div></div></div><div><div>Visual reference</div><div></div></div><div><div>INSERTION JIG ORIENTATION</div><div></div></div></div> <div><div><div><div>L</div><div></div><div>Press</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div></div></div><div><div><div><div>L</div><div>R</div><div></div><div>Press</div></div><div><div>2. Get the connector 6098-3810 (W) using right hand then insert to jig using right hand and release the lock using left thumb.</div><div>Note: Follow the connector orientation.</div></div></div><div><div><div><div>L</div><div></div><div>Release</div></div><div><div>3. Check the holes/terminal slot for B/B wires.</div></div></div></div></div><div>n/a</div></div>		<div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>2 Holes are widely open</div><div></div><div>GOOD</div></div><div><div>I-mark is not align</div><div>No holes are open</div><div></div><div>NG</div></div></div><div><div>3</div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div></div><div>6098-3810 (W)</div></div><div><div>NG</div><div></div><div>6098-5677 (W)</div></div></div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div></div></div>	

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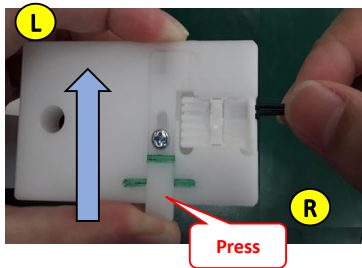
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Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number: **817B / 7N0050-7020B** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. IRRAX ROPE-LAY B wires L=316±2mm [2pcs.]		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 6098-3810 (W)	<div><p>Wire facing</p></div> <div><p>1. Get 1st black wire then insert to terminal slot ① using right hand.</p></div> <div><p>2. Get 2nd Black wire then insert to terminal slot ② using right hand.</p></div> <div><p>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.</p></div>		n/a	<div><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p></div> <div><p>3 Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 3. Insertion of wires must be from left to right</p></div> <div><p>3 Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p></div>

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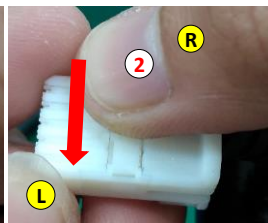
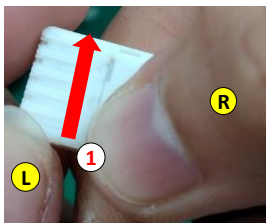



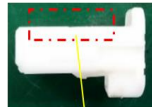
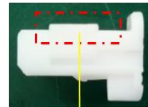




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Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number: **817B / 7N0050-7020B** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts 2. Black Corrugated tube (no slit) Ø5 L=228±2mm		JIG	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 <div>3</div> Connector Lock	<div><div><p>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</p></div><div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div><div><p>Before Pressing</p></div><div><p>After Pressing</p></div></div>		<div>LOCKING JIG</div>  <div>3</div> <div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div> <div>1. Use the provided locking jig per model 2. No unlock/half-locked connector</div> <div>CONNECTOR LOCK CONDITION</div> <div><div><p>Fully Locked</p></div><div><p>UnLocked</p></div></div>	
5	Wire insertion to Black Corrugated tube (no slit) Ø5 L=228±2mm	<div><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 corrugated tube (no slit) Ø5 L=228±3mm using right hand then insert the B-B wires using left hand.</p></div><div><p>3. Remove the terminal cover jig after insertion using right hand.</p></div></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts 2. No deformed terminal

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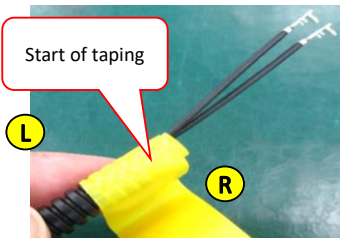
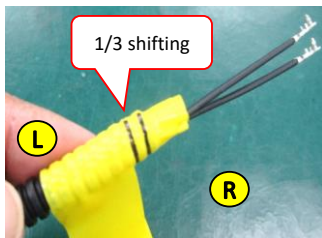
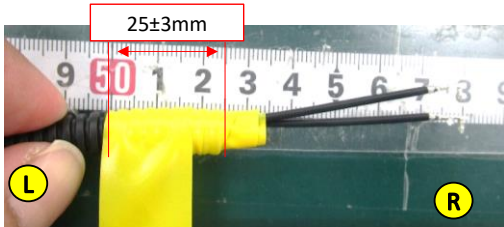
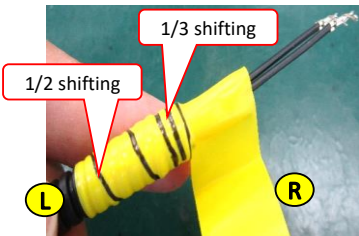


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PARTS:		1. Assy parts 2. Black tape		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 Black corrugated tube to wire near teminal	<div><div><p>Start of taping</p></div><div><p>1/3 shifting</p></div><div><p>1. Hold the COT using left hand, get the Black tape using right then start pre-taping at the middle of COT and wires using both hands.</p></div><div><p>25±3mm</p></div><div><p>1/2 shifting 1/3 shifting</p></div><div><p>2. Make 1/3 shifting going to the side of COT until it reach 25mm.</p></div><div><p>3. Confirm 25mm measurement from end of tape up to end of COT then make 2 windings of tape using both hands before shifting to other side.</p></div><div><p>4. Make 1/2 shifting using both hands going to other side of COT and 1/3 shifting going to wires</p></div></div> <td><div><p>MEASURING TAPE</p></div></td> <td><div><p>3 Important reminders/Note/s:</p><p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p><p>2. Please use calibrated/verified measuring tape when getting the measurement.</p></div><div><p>1. No peel-off tape</p><p>2. No flip-out tape</p><p>3. No loose tape</p><p>4. No wrong use of tape</p><p>5. No wrong dimension</p><p>6. No missing tape</p></div></td>		<div><p>MEASURING TAPE</p></div>	<div><p>3 Important reminders/Note/s:</p><p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p><p>2. Please use calibrated/verified measuring tape when getting the measurement.</p></div> <div><p>1. No peel-off tape</p><p>2. No flip-out tape</p><p>3. No loose tape</p><p>4. No wrong use of tape</p><p>5. No wrong dimension</p><p>6. No missing tape</p></div>

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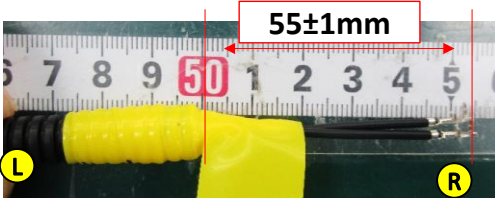
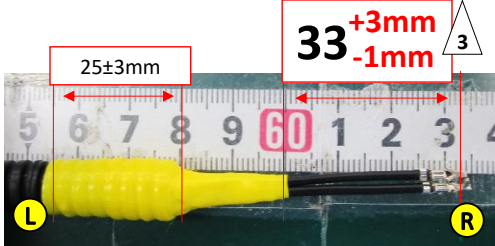
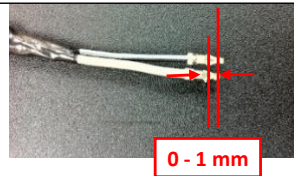
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PARTS:		1. Assy parts 2. Black tape			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 Black corrugated tube to wire near teminal (Continuation)	 <p>5. Measure from end of COT up to terminal pointed tip 55±1mm then continue the taping process using both hands.</p>  <p>6. After taping, check the measurement and taping condition.</p>				 <p>Wire alignment tolerance 0 - 1 mm</p> <ul style="list-style-type: none">1. No peel-off tape2. No flip-out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape <p>Important reminders/Note/s:</p> <ul style="list-style-type: none">1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.2. Please use calibrated/verified measuring tape when getting the measurement. <p>Document reference/s:</p> <ul style="list-style-type: none">1. Refer to WI-ENG-PDE-588 for TAPE AND TUBE END STANDARD TOLERANCE

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