



## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 13, 2022

Model Code/Product Number:

816W / 7H0402W7020A

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-494A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

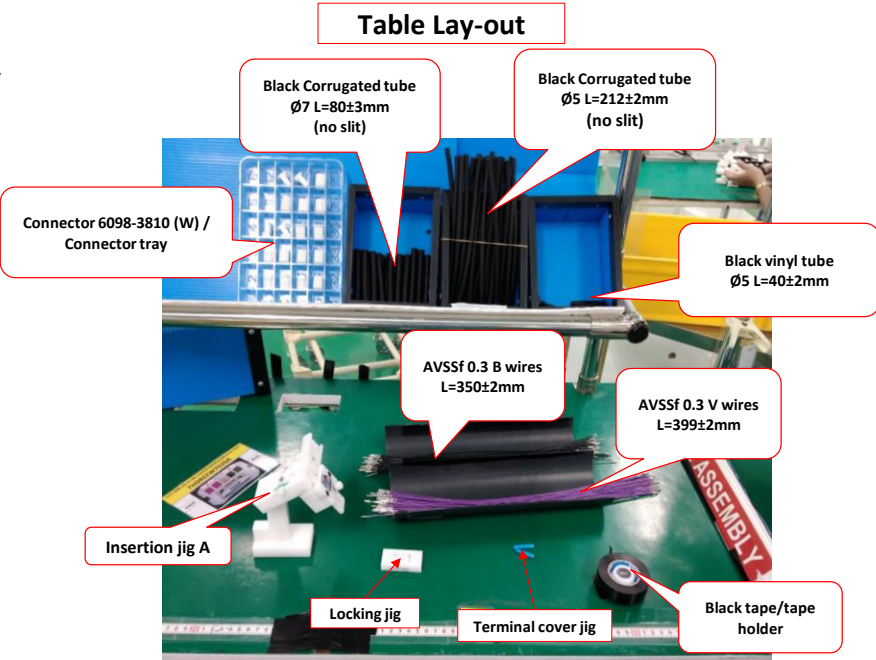
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## PARTS:

1. Connector 6098-3810 (W); AVSSf 0.3 B wires L=350±2mm; AVSSf 0.3 V wires L=399±2mm; Black Corrugated tube Ø7 L=80±3mm (no slit); Black Corrugated tube Ø5 L=212±2mm (no slit); Black vinyl tube Ø5 L=40±2mm; 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 	<b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)  <b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.  <b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	<i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i>  1. No missing parts/tools 2. No excess parts/tools

## Revision History

Eff.Date	Rev.No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/13/22	1	Change document purpose from pre-launch to masspro. Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A.Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
04/29/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A.Arañes				

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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)

**Insertion Jig Orientation**

**Insertion Jig**

**Lock**

**I-mark**

**Visual reference**

**Button**

**Lower wire guide**

**Double lock**

**CONNECTOR ORIENTATION**

**Press**

**Release**

**Holes**

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

### Connector Orientation

I-mark was align

2 holes were only open

GOOD

I-mark is NOT align

All holes were open

NG

1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

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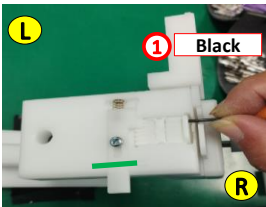
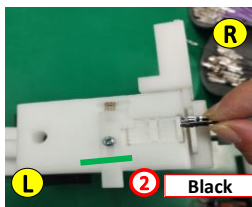
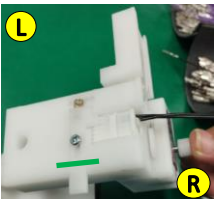
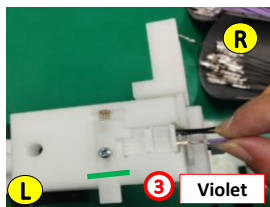
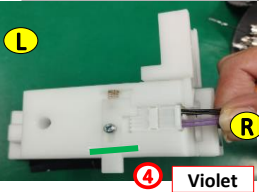
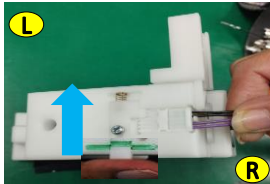
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<b>PARTS:</b>	1. AVSSf 0.3 B wires L=350±2mm [2pcs.] 2. AVSSf 0.3 V wires L=399±2mm [2pcs.]			<b>JIG</b>	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1  Wire insertion to Connector 6098-3810 (W)	<div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div>1. Get the <b>1st Black 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>2. Get the <b>2nd Black wire</b> then insert to terminal slot <b>2</b> using right hand.</div> <div>3. Press the button using right thumb. The slot for <b>V-V wires</b> will be opened.</div> <div>4. Get the <b>1st Violet wire</b> then insert to terminal slot <b>3</b> using right hand. <i>Note: Insertion of wires must be from left to right.</i></div> <div>5. Get the <b>2nd Violet wire</b> then insert to terminal slot <b>4</b> using right hand.</div> <div>6. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div>		n/a	<i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i>  <i>Note: Please hold the wire near terminal during insertion.</i>  1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed 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.  <i>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i>

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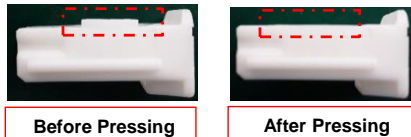
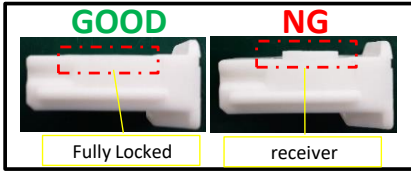





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PARTS:		1. Assy parts 2. Black Corrugated tube Ø7 L=80±2mm (no slit)			JIG	1. Locking jig 2. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
4	P1	Connector lock	 <p>1. Put the connector into locking jig using right hand then press to lock <b>2x</b> 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>  			<b>LOCKING JIG</b> 	<b>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</b> 1. Use the provided locking jig per model 2. No unlocked/half-locked connector 2. No damaged lock
5		Wire Insertion to Black Corrugated tube Ø7 L=80±3mm (no slit)	 <p>1. Get the terminal cover jig using right hand then insert the <b>B-B, V-V wires</b> using left hand.</p>  <p>2. Get the corrugated tube (no slit) Ø7 L=80±2mm using right hand and insert the wires using left hand.</p>  <p>3. After insertion, remove the terminal cover jig on <b>B-B wires</b> using right hand.</p>			<b>TERMINAL COVER JIG</b> 	1. No wrong use of parts 2. No deformed terminal

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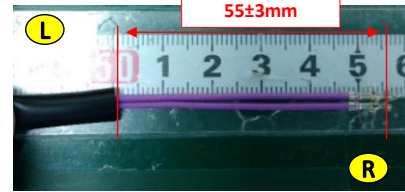
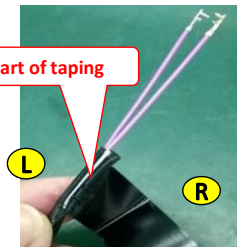

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black Corrugated tube Ø5 L=212±2mm (no slit)		3. Black vinyl tube Ø5 L=40±2mm 4. Black tape		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=212±2mm	 1. Get the corrugated tube (no slit) Ø5 L=212±2mm using right hand and insert the wires using left hand.	 2. After insertion, remove the terminal cover jig using right hand.		1. No wrong use of parts 2. No deformed terminal	
7		Wire Insertion to Black vinyl tube Ø5 L=40±2mm	 1. Get the Black vinyl tube Ø5 L=40±2mm using right hand then insert the V-V wires using left hand.	n/a		1. No wrong use of parts	
8		Taping 1 Black vinyl tube to wire near terminal (V-V wires)	 1. Hold the vinyl tube using left hand and measure from end of vinyl tube up to the terminal pointed tip 55±3mm using both hands.	 2. Hold the assy parts using left hand, get the Black tape and conduct pre-taping between vinyl and wire using right hand. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure</i>		1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension	

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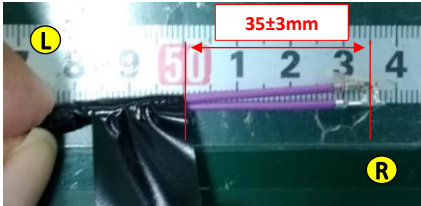
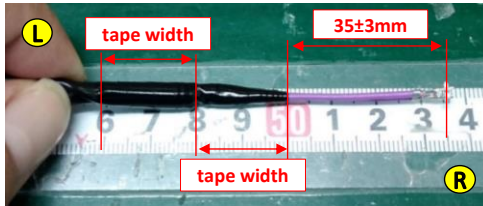

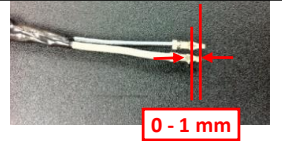


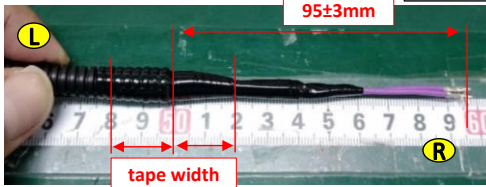

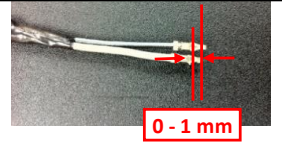
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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	Taping 1 Black vinyl tube to wire near terminal (V-V wires) (Continuation)	 <p>3. Confirm measurement of <b>35±3mm</b> from end of tape up to terminal pointed tip using both hands.</p>  <p>4. After taping, check the measurement, wire alignment and taping condition.</p>		<p><b>Wire alignment tolerance</b></p>  <p>0 - 1 mm</p> <ol style="list-style-type: none"><li>1. No peel-off tape</li><li>2. No flip out tape</li><li>3. No loose tape</li><li>4. No wrong use of tape</li><li>5. No wrong dimension</li></ol>
10	Taping 2 Black COT to Black vinyl tube near terminal (V-V wires)	 <p>1. Fix the COT and vinyl tube using both hands, get the <b>Black tape</b> using right then start pre-taping using both hands.</p>  <p>2. Measure from end of COT up to terminal pointed tip <b>95±3mm</b> using both hands then continue the taping process using both hands. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure</i></p>  <p>3. After taping, check the measurement, terminal appearance and taping condition.</p>		<p><b>Wire alignment tolerance</b></p>  <p>0 - 1 mm</p> <ol style="list-style-type: none"><li>1. No peel-off tape</li><li>2. No flip out tape</li><li>3. No loose tape</li><li>4. No wrong use of tape</li><li>5. No wrong dimension</li></ol> <p><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p>

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