

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 9, 2023

Model Code/Part Number:

380D / 7L0140-7020A

Customer:

TRQSS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-648A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 6**PARTS:**

1. Assy parts; AVSSf 0.3 wires B-B L=684±3mm; Black tape

JIG:

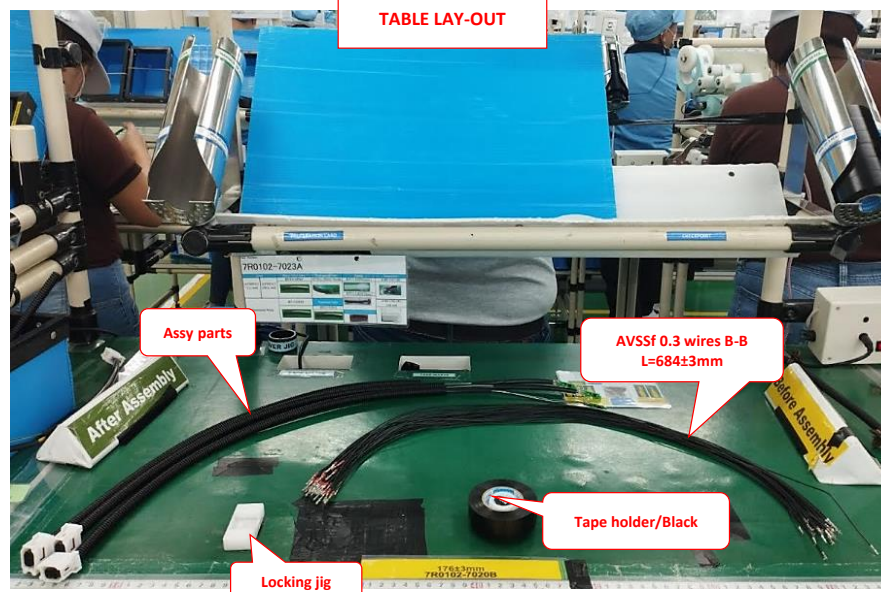
1. Locking jig

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

1

P1

Table Lay-out

**Safety Instruction**

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No wrong use of parts
2. No deformed terminal

Document reference/s:

1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
2. Please refer to WI-ENG-PDE- 669 for Offline Assembly Process

Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/09/23	1	Change Purpose from Pre-launch to Masspro. Inclusion of Quality Checkpoints. Additional table lay-out; Improve Work procedure/Illustration on process 1 to 7.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
03/10/23	0	Initial issue. Change Wire color from Green (G) to Gray (GR).	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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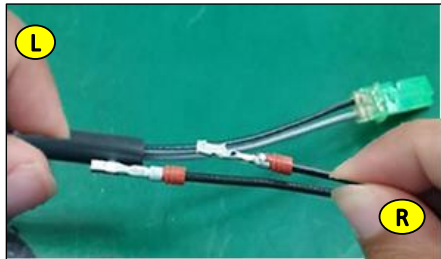


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PARTS:		1. Assy parts 2. AVSSf 0.3 wires B L=684±3mm [2pcs]		JIG	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black VM tube (Sunprene)	<div></div> <div>1. Get the B-B wires using right hand then insert to Black Corrugated tube (No slit) ø5 L= 106±3mm (Assy parts) using both hands.</div>		n/a	1. No wrong use of parts 2. No deformed terminal Document reference/s: 1. Please refer to WI-PRO-CNC- for Wire and Strip length
3	Wire insertion Black Corrugated tube (Assy parts)	<div></div> <div>1. Get the B-B wires using right hand then insert to Black Corrugated tube (No slit) ø7 L= 497±3mm (Assy parts) using both hands.</div> <div></div>			1. No wrong use of parts 2. No deformed terminal

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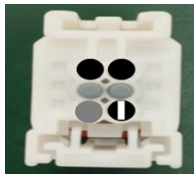

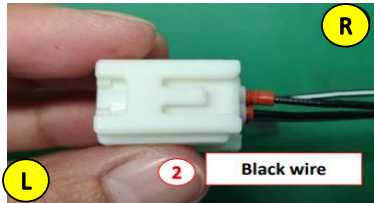
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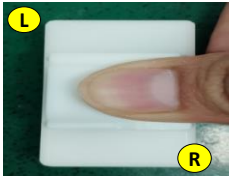
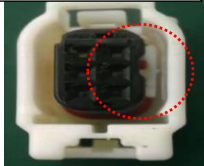
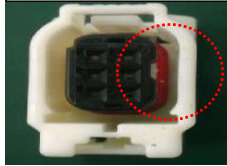



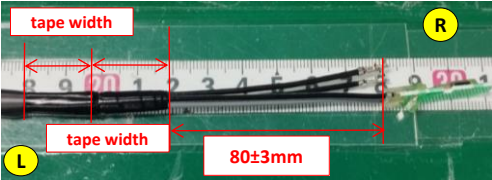

PARTS:		1. Assy parts		JIG	n/a
NO.	PROCESS NAME		<div>1</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Wire insertion to Connector 6189-1142 (W)	<div><div><div>CONNECTOR ORIENTATION</div></div><div><div>VISUAL REFERENCE</div></div><div><div>1. Hold the connector 6189-1142 (W) then get the B-wire and insert to terminal slot 1 using right hand. Conduct 2x push-pull after wire insertion.</div></div><div><div>2. Get the Gray wire and insert to terminal slot 2 using right hand. Conduct 2x push-pull after wire insertion.</div></div></div>	n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 3. Insertion must be from left to right.</div> <div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure</div>

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PARTS:		1. Assy parts 2. Black tape		JIG	1. Locking jig
NO.	PROCESS NAME	1	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Connector Lock		 <p>1. Put the connector into locking jig using right hand and then press 2x using both hands. Check the connector lock if properly locked.</p> <div style="display: flex; justify-content: space-around;"> <div> <p>BEFORE PRESSING</p>  </div> <div> <p>AFTER PRESSING</p>  </div> </div>	<p>LOCKING JIG</p> 	<p>1. Use the provided jig tool per model 2. No unlock/half-locked connector 3. No damaged lock</p> <p>Important reminders/Note/s: 1. Manual locking may cause damaged connector lock.</p>
6	Taping 1 Black VM tube (Sunprene) to wire near terminal and PCB	P1	 <p>1. Hold the VM tube (Sunprene) using left hand. Measure from end of sunprene up to the edge of hotmelted wires 80±3mm and up to terminal pointed tip using right hand.</p>  <p>2. Hold the VM tube (Sunprene) using left hand. Get the Black tape using right hand then start taping process using both</p>  <p>3. After taping, check the measurement, wire alignment and taping condition.</p>	<p>MEASURING TAPE</p> 	<p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</p> <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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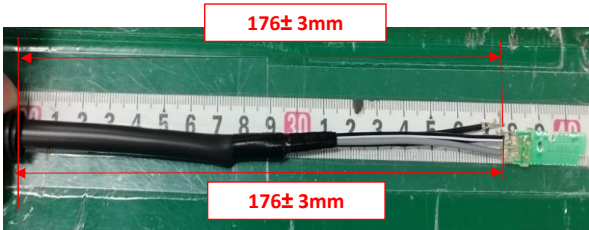
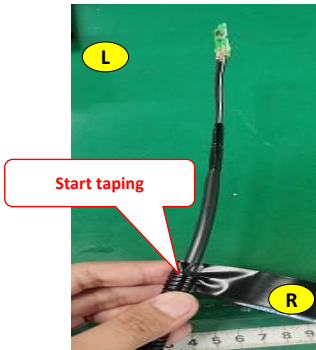
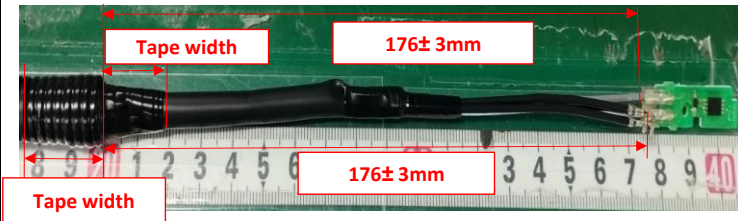

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 Taping 2 Black Corrugated tube to Black VM tube (Sunprene)	 <p>1. Measure the end of the corrugated tube up to the edge of hotmelt 176mm and terminal pointed tip using right hand.</p>  <p>2. Hold the corrugated tube using left hand. Get the Black tape using right hand and start taping process using both hands.</p>  <p>3. After taping, check the measurement and taping condition.</p>		<ol 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> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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PARTS:

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JIG

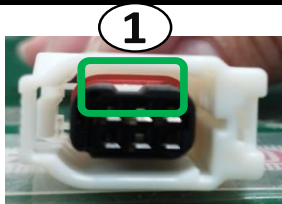
n/a



QUALITY CHECKPOINTS

P1

7L0140-7020A



GOOD



NO GOOD



① No Unlock/Half-locked Connector

③ No Missing tape

④ No Deformed Terminal/PCB

Proper alignment of B-B wires and hotmelt

② No Terminal Backing-out

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