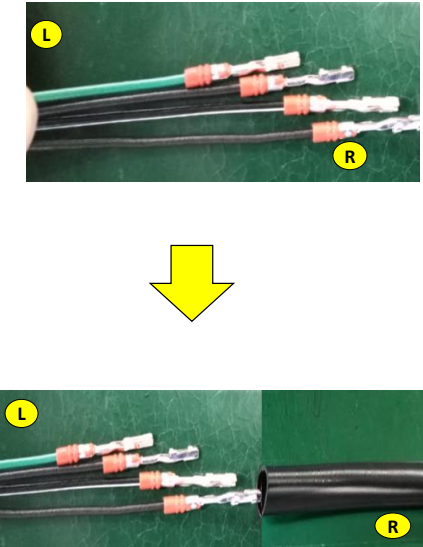
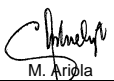



	<b>WORK INSTRUCTION</b>						Effectivity Date:		January 11, 2023	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>						Validity Date:		n/a	
	Model Code/Part Number: <b>380D / 7L0140-7020</b>				Customer: <b>TRQSS</b>		Document No.:		<b>WI-ENG-PDE-611</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO						Revision No.:		0	Page No.:

<b>PARTS:</b>		1. Black VM tube (Sunprene) $\phi 5$ L=106 $\pm$ 3mm 2. MR SW CP G-B/W wires L=692 $\pm$ 3mm 2. AVSSf 0.3 wires B L=684 $\pm$ 3mm [2pcs]				JIG:		n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
1	n/a  Wire Insertion to Black VM tube (Sunprene) $\phi 5$ L=106 $\pm$ 3mm	<div style="display: flex; align-items: center;">  <div style="margin-left: 20px;"> <p>1. Get the <b>G-B/W hotmelted wires (MR SW CP)</b> and <b>B-B wires L=684<math>\pm</math>3mm</b> using both hands then hold using left hand.</p> <p>2. Get the sunprene tube <b><math>\phi 5</math> L= 106<math>\pm</math>3mm</b> using right hand then insert the <b>G-B/W hotmelted wires</b> and <b>B-B wires</b> using left hand.</p> </div> </div>				<div style="border: 1px dashed red; padding: 5px;"> <p><b>Safety Instruction</b></p> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p><b>Housekeeping</b></p> <p>1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>		<p>1. No wrong use of parts            2. No deformed terminal</p> <p><i>Document reference/s:</i></p> <p><b>1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</b></p>	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
01/11/23	0	Initial issue.						M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change						Prepared	Reviewed	Approved	Noted	Est. Date:	January 11, 2023		

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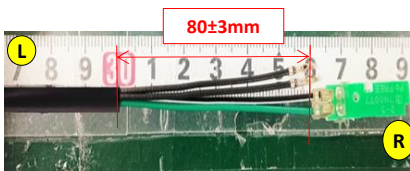
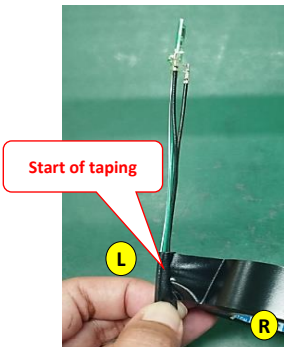
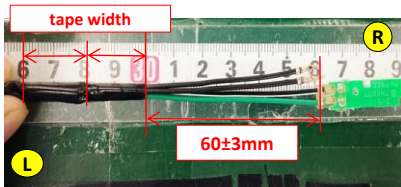

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## PARTS:

1. Assy parts
2. Black tape

## JIG

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a  Taping 1 Black VM tube (Sunprene) to Wire near terminal and PCB	 <p>1. Hold the sunprene tube using left hand. Measure from end of sunprene up to the edge of hotmelted wires <b>80±3mm</b> and up to terminal pointed tip using right hand.</p>  <p>2. Hold the sunprene tube using left hand. Get the <b>Black tape</b> using right hand then start taping process using both hands.</p>  <p>3. After taping, check the measurement, wire alignment and taping condition.</p>	<p><b>MEASURING TAPE</b></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 dimensionr</li></ol> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please use calibrated/verified measuring tape when getting the measurement.</li></ol>

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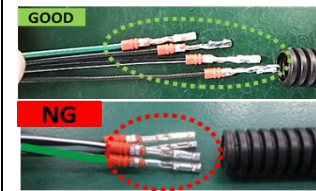
3 of 14

**PARTS:**

1. Assy parts
2. Black Corrugated tube (no slit)  $\varnothing 7$  L=497 $\pm$ 3mm

**JIG**

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a  Wire insertion to Black Corrugated tube (no slit) $\varnothing 7$ L=497 $\pm$ 3mm	 <div>1. Hold the wires using left hand, get the corrugated tube (no slit) <math>\varnothing 7</math> L=497<math>\pm</math>3mm using right hand then insert the <b>G-B/W hotmelted wires and B-B wires</b> using left hand.</div>	n/a	<ol style="list-style-type: none"><li>1. Use the provided jig per connector</li><li>2. No unlock/half-locked connector</li></ol>  <b>Important reminders/Note/s:</b> <i>1. Wire must not be inserted at the same time</i>

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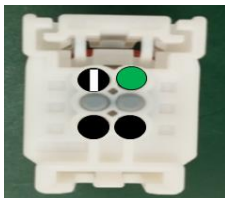

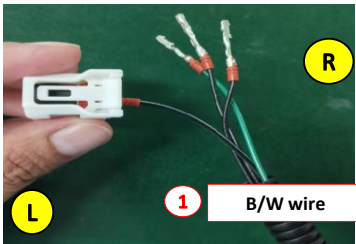
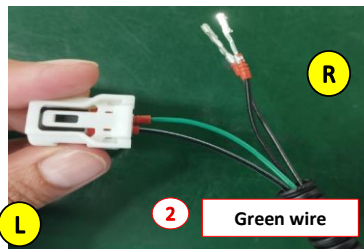
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## PARTS:

1. Assy parts
2. Connector 6189-1142 (W) with inserted Dummy seal 7165-0797 [2pcs]

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a Wire insertion to Connector 6189-1142 (W)	<div><p>CONNECTOR ORIENTATION</p></div> <div><p>VISUAL REFERENCE</p></div> <div><p>Wire facing</p></div> <div><p>1. Hold the connector 6189-1142 (W) then get the B/W wire and insert to terminal slot 1 using right hand. Conduct 2x push-pull after wire insertion.</p></div> <div><p>2. Get the Green wire and insert to terminal slot 2 using right hand. Conduct 2x push-pull after wire insertion.</p></div>	n/a	<ol style="list-style-type: none"><li>1. No wrong orientation of connector</li><li>2. No wrong use of connector</li><li>3. No damaged connector</li><li>4. No wrong insertion of wires</li><li>5. No loose insertion</li><li>6. No wrong insertion</li><li>7. One by one insertion</li><li>8. No deformed terminal</li><li>9. No wrong wire facing</li></ol> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please hold the wire near terminal.</li><li>2. Make sure wires are properly inserted.</li></ol> <p>Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p><b>Document references:</b></p> <ol style="list-style-type: none"><li>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</li></ol>

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## PARTS:

1. Assy parts

JIG

n/a

## NO.

## PROCESS NAME

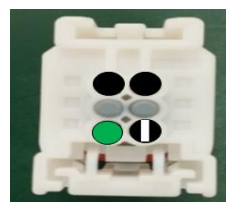
## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

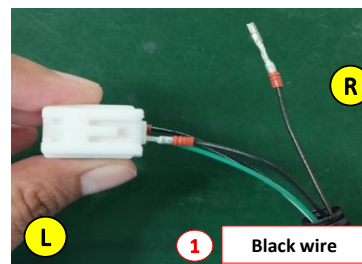
## QUALITY POINTERS

4

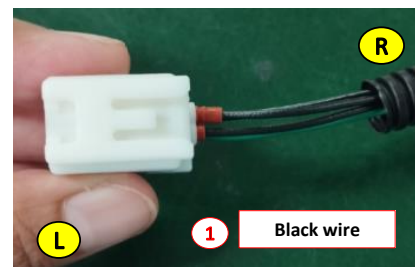
n/a

Wire insertion to Connector  
6189-1142 (W)  
(Continuation)CONNECTOR  
ORIENTATIONVISUAL  
REFERENCE

Wire facing



1. Hold the connector **6189-1142 (W)** then get the **1st Black wire** and insert to terminal **slot 1** using right hand. Conduct **2x** push-pull after wire insertion.



2. Get the **2nd Black wire** and insert to terminal **slot 2** using right hand. Conduct **2x** push-pull after wire insertion.

n/a

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

**Important reminders/Note/s:**

1. Make sure wires are properly inserted.  
Conduct **Pull-Push-Pull-Push** after insertion.  
Do not exert extra force.
2. During insertion, hold the wire not rubber seal to prevent sagging.

**Document references/:**

1. Please refer to **WI-PRO-CNC-017** for Wire and Strip Length tolerance
2. Please refer to **GL-PRO-ASY-029** for Pull-Push procedure.

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**PARTS:**

1. Assy parts

**JIG**

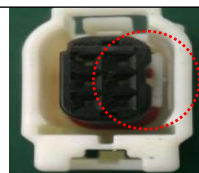
1. Locking jig

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

5

n/a

Connector Lock

**BEFORE PRESSING****AFTER PRESSING****LOCKING JIG**

1. Use the provided jig tool per model
2. No unlock/half-locked connector
3. No damaged lock

**Important reminders/Note/s:**

1. Manual locking may cause damaged connector lock.

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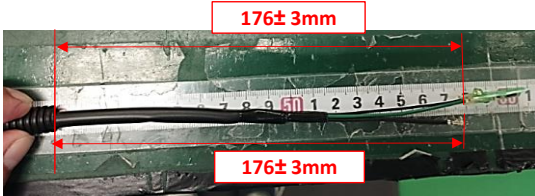
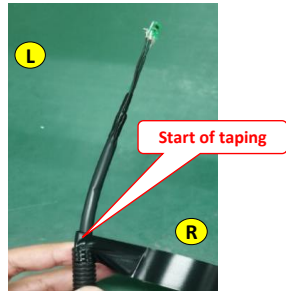
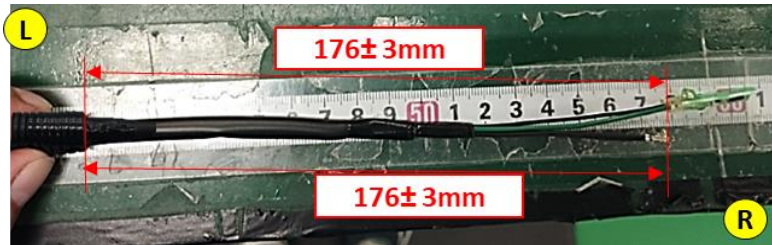
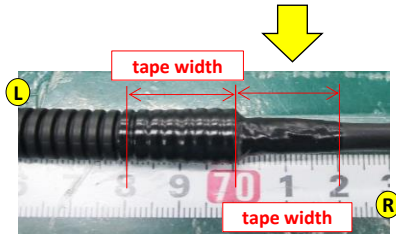

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**PARTS:**

1. Assy parts
2. Black tape

**JIG**

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	n/a 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 <b>176mm</b> 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>	<b>MEASURING TAPE</b> 	<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><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please use calibrated/verified measuring tape when getting the measurement.</li></ol>

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**PARTS:**

1. Clamp 82711-16820(BR)

**JIG**

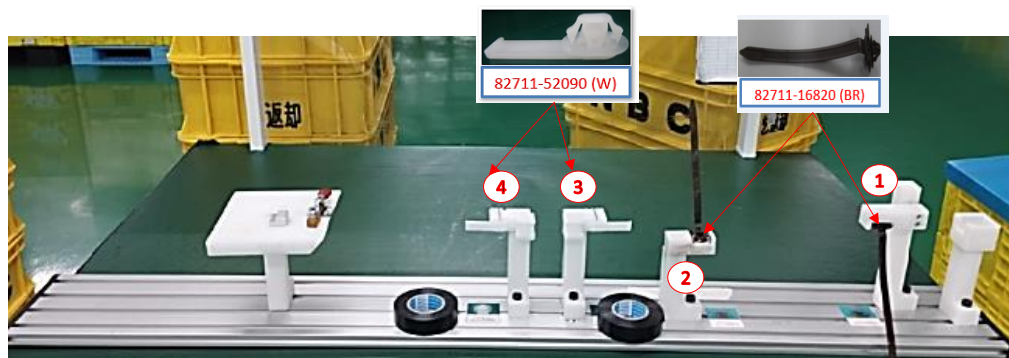
1. Temporary clamp assembly jig

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

7

n/a

Clamp setting



1. Get 2pcs. of clamp **82711-16820 (BR)** using right hand and set to clamp location **2 and 1** using both hands.

2. Get 2pcs. of clamp **82711-52090 (W)** using right hand and set to clamp location **3 and 4** using both hands.

3. Initially attach the black tape **to Location 3 and 4.**

1. No wrong use of clamp
2. No damaged clamp
2. No wrong use of tape

**STANDARD TAPING FOR CLAMP**

One side tape under clamp

**Important reminders/Note/s:**

*1. Please check the clamp and band clamp before start of assembly to avoid wrong use of clamp.*

**CLAMP ILLUSTRATION****BAND CLAMP ILLUSTRATION**

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## PARTS:

1. Assy parts

## JIG

1. Temporary clamp assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

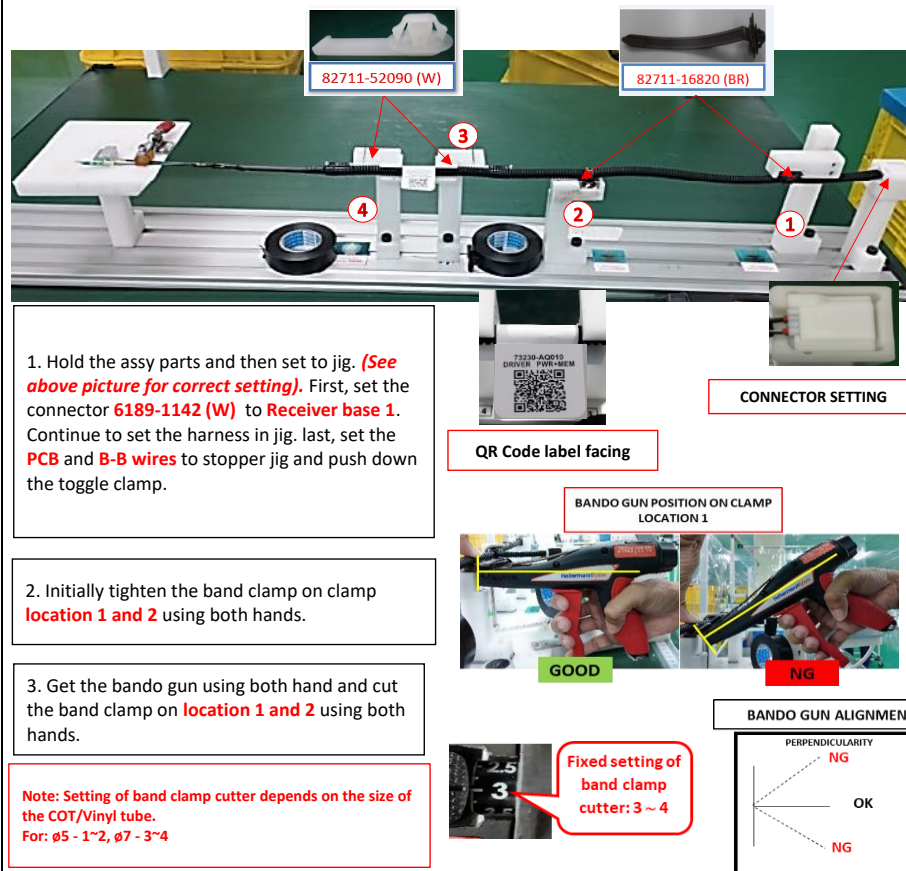
## TOOLS/PPE

## QUALITY POINTERS

8

n/a

Clamp Assembly



1. Hold the assy parts and then set to jig. (See above picture for correct setting). First, set the connector 6189-1142 (W) to Receiver base 1. Continue to set the harness in jig. last, set the PCB and B-B wires to stopper jig and push down the toggle clamp.

2. Initially tighten the band clamp on clamp location 1 and 2 using both hands.

3. Get the bando gun using both hand and cut the band clamp on location 1 and 2 using both hands.

Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.  
For: ø5 - 1~2, ø7 - 3~4

CONNECTOR SETTING

QR Code label facing

BANDO GUN POSITION ON CLAMP  
LOCATION 1

GOOD

NG

BANDO GUN ALIGNMENT

PERPENDICULARITY

NG

OK

NG

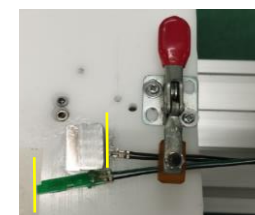
BANDO GUN

FLAT NOSEPIECE

1. No wrong use of clamp
2. No damaged clamp
2. No wrong use of tape

## Important reminders/Note/s:

1. Make sure no gap between stopper and terminals



BANDO GUN ILLUSTRATION

GOOD

NG



FLAT NOSEPIECE

EXTENDED NOSEPIECE

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PARTS:

1. Assy parts

JIG

1. Temporary clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

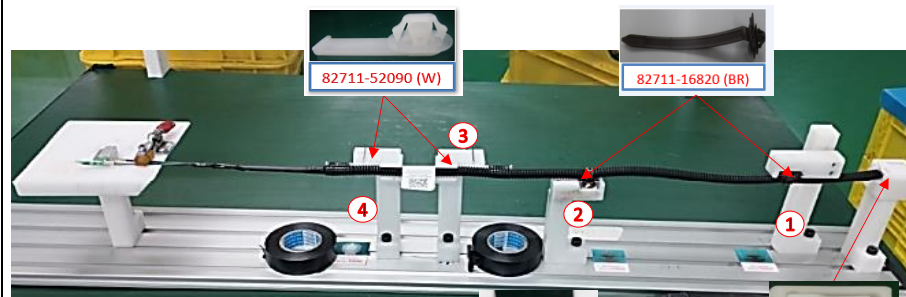
TOOLS/PPE

QUALITY POINTERS

8

n/a

Clamp Assembly  
(Continuation)

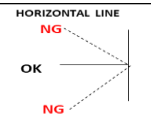


4. Cut the band clamp on location 2 using both hands. Continue on clamp location 3.

BANDO GUN POSITION ON CLAMP LOCATION 2



Fixed setting of  
band clamp  
cutter: 3 ~ 4



QR Code label facing

CONNECTOR SETTING

5. Hold the tape on clamp location 3. Make 3 windings of tape then cut the tape using both hands. Continue the process on clamp location 4.

6. Hold the tape on clamp location 4. Make 3 windings of tape then cut the tape using both hands. Continue the process on label attachment

7. For label attachment, get the QR code label then attach using both hands. (Refer to the next page for label attachment).

8. Conduct POINT CHECKING before removing the harness from jig.

BANDO GUN

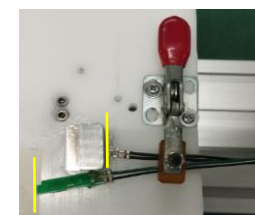


FLAT NOSEPIECE

1. No wrong use of clamp
2. No damaged clamp
2. No wrong use of tape

Important reminders/Note/s:

1. Make sure no gap between stopper and terminals



BANDO GUN ILLUSTRATION



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**PARTS:**

1. Assy parts
2. Label 7V8110-0020

**JIG**

n/a

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

9

n/a

Label Attachment

Model Code	Item No.	Item Name
7L0139-7020	73230-AQ040	Driver Manual
7L0140-7020	73230-AQ010	Driver PWR+MEM
7L0141-7020	73230-AQ020	Driver Power



Model code

1. Get the label.

**Note: Check the model code, item no. & name**

Item no. &amp; name

2. Align the end part of label in the jig.

3. Fold the center part of the label

4. Align both end part of label .

5. After alignment , Press the label with both fingers .

6. Press the label upside down using finger.

Acceptable overlap  
0~1mm**GOOD****NG**

1. No bubbles
2. No damage
3. No peel off
4. No wrong use of label
5. No missing parts
6. No loose attachment
7. No wrong usage of label



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DCC Stamp



# WORK INSTRUCTION

Effectivity Date:

January 11, 2023

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

380D / 7L0140-7020

Customer:

TRQSS

Document No.:

WI-ENG-PDE-611

Purpose:

☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Revision No.:

0

Page No.:

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### PARTS:

1. Assembled parts
2. Engineering sample

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

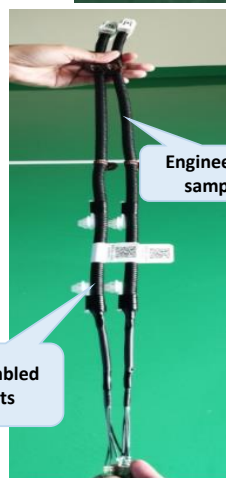
10

n/a

Visual/By two's inspection



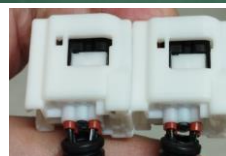
ACTUAL PRODUCT



Engineering sample

Assembled parts

1. Conduct **alignment of harness (Engineering sample vs. assembled parts)** using both hands.



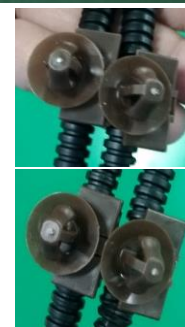
2. Check the **connector lock condition, insertion and terminal.**



4. Check the **taping condition.**



5. Check the **QR Code label and correct facing.**



3. Check the **Y-Taping condition, presence of all clamp attachment, taping condition and band clamp cut condition.**



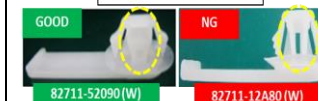
6. Check the **Terminal and PCB appearance, Must be no deformed terminal.**

1. No skip checking during inspection

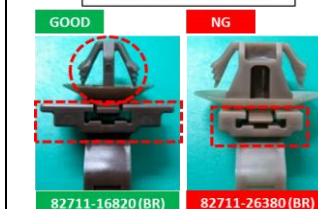
### ENGINEERING SAMPLE



### CLAMP ILLUSTRATION



### BAND CLAMP ILLUSTRATION



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☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

Page No.:

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**PARTS:**

n/a

**JIG**

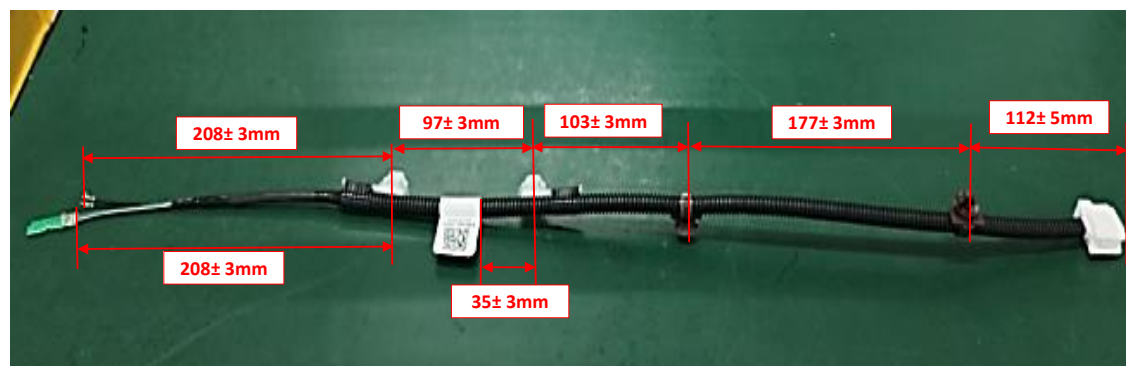
n/a

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

11

n/a

Measurement

**MEASURING TAPE****Important reminders/Note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono and Owarimono.

1. No wrong dimension

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☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Revision No.:

0

Page No.:

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PARTS:

n/a

JIG

n/a

## QUALITY CHECKPOINTS

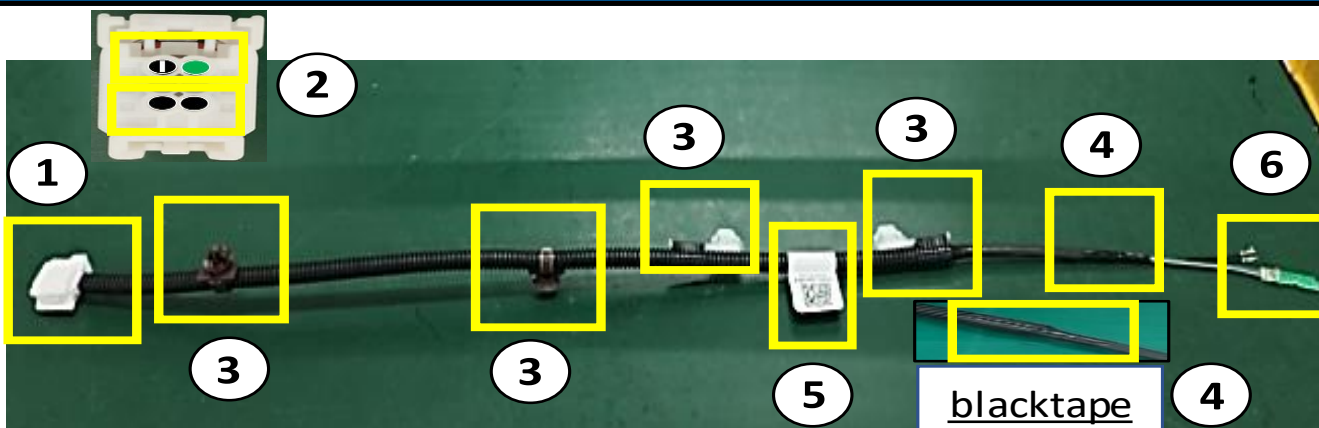
# P1



GOOD



NO GOOD



Proper alignment of  
B/B wires and hotmelt

① NO UNLOCKED/HALF  
LOCKED CONNECTOR

② No WRONG INSERT  
No Terminal Backing Out

③ No MISSING CLAMP [4pcs]

③ Checking of Clamp  
attachment

④ No Missing tape

⑤ NO MISSING QR CODE  
No wrong facing of QR  
CODE

⑥ NO Deformed  
terminal

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