

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

May 28, 2021

Product Name/Code:

**D01L / 7M0647-7020D**

Customer:

**TRJ**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

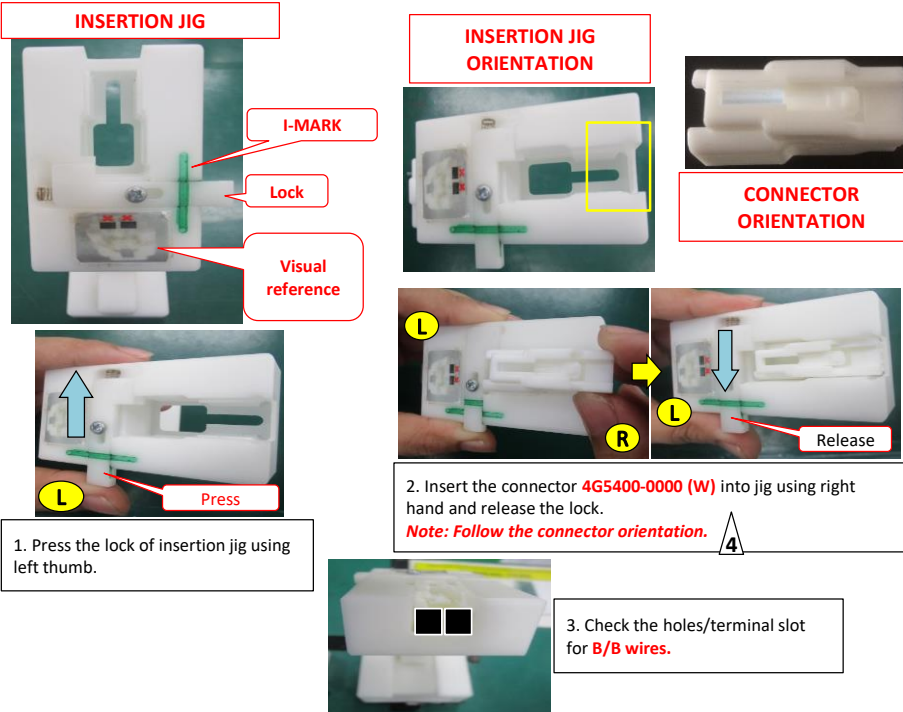
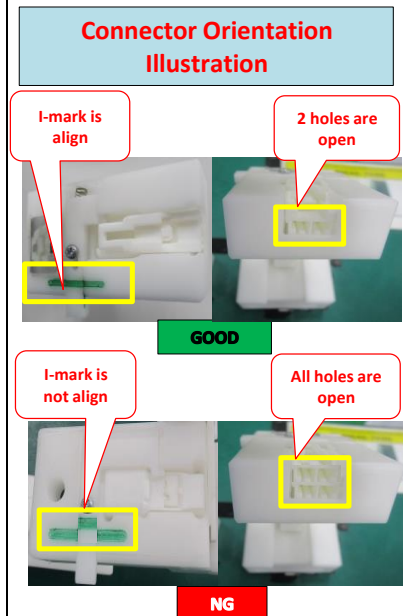
**WI-ENG-PDE-047A**

Revision No.:

4

Page No.:

1 of 5

PARTS:		1. Connector 4G5400-0000 (W)				JIG:	1. Insertion jig		
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS	
1	P1	Connector setting to insertion jig 4G5400-0000 (W)	<div><div><div>INSERTION JIG</div><div></div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 4G5400-0000 (W) into jig using right hand and release the lock. Note: Follow the connector orientation.</div><div>3. Check the holes/terminal slot for B/B wires.</div></div></div>				<div><div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>	<div><div><b>Connector Orientation Illustration</b></div><div></div><div>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div></div>	
Revision History						Prepared by	Reviewed by	Approved by	Noted by
05/28/21	4	Removal of validity date. Apply some improvements.				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
11/28/20	3	Changed effectivity and validity date. Apply some improvements. Remove cycle time.				M. Catapang	R. Peñaaloza	A. Shimamura	A. Arañes
03/01/19	n/a	Previously established as Engineering instruction (EI-ENG-PDE-071). Initial issue				J. Loterte	R. Alcantara	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted
						Est. Date:	March 01, 2019		

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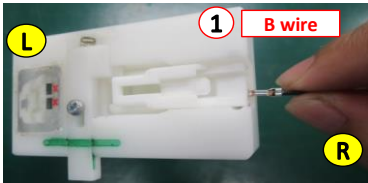
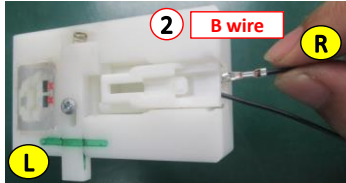

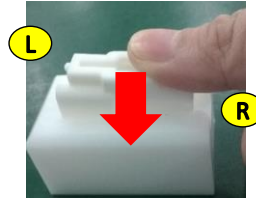
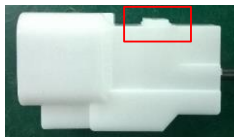


WI-ENG-PDE-047A

Revision No.:

4

Page No.:

2 of 5

PARTS:		1. AVSSf 0.3 B L=1089±3mm [2pcs.]			JIG	1. Insertion jig 2. Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P1	Wire insertion to connector 4G5400-0000 (W)	<div><p>1. Get the <b>B wire</b> and insert to terminal slot <b>1</b> using right hand. <b>Note: Insertion of wire must be from left to right</b></p></div> <div><p>2. Get the <b>B wire</b> and insert to terminal slot <b>2</b> using right hand.</p></div> <div><p>3. 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>	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing  <b>Note: Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</b>	
3		Connector Lock	<div><p>1. Put the connector into locking jig using both hands then press <b>2x</b> using both hands. Touch the connector lock to check if properly locked.</p></div> <div><p>BEFORE PRESSING</p></div> <div><p>AFTER PRESSING</p></div> <div><p>LOCKING JIG</p></div>		<b>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</b>  1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector	

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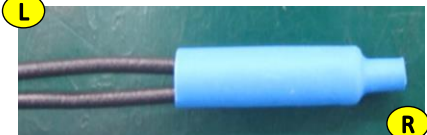



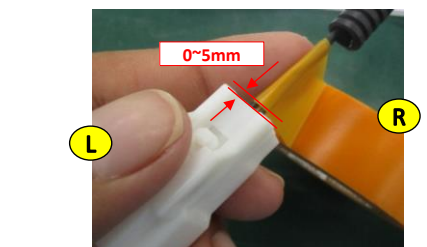
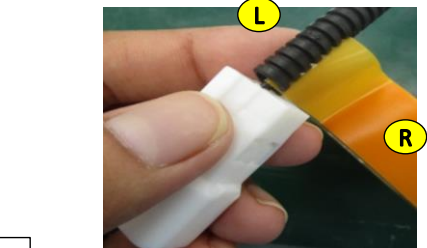
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Revision No.:

4

Page No.:

3 of 5

PARTS:		1. Assy parts 2. Black corrugated tube Ø5 L=632±4mm (with slit in 25mm) 2. Orange tape		JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<div><div></div><div><p>1. Get the terminal cover jig using right hand then insert to wires.</p></div></div> <div><div></div><div><p>2. Get the corrugated tube (w/slit 25mm) <math>\phi 5</math> L=632±4mm using right hand and insert the B/B wires using left hand.</p></div></div> <div><div></div><div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div></div>		<div><p>TERMINAL COVER JIG</p></div>	1. No wrong usage of parts 2. No deformed terminal.
5		<div><div></div><div><p>1. Hold the connector using left hand and attach the orange tape on wires using right hand (see picture for illustration) then make 3 windings, do not cut the tape. Note: Attachment of tape to wire must be from 0~5mm.</p></div></div> <div><div></div><div><p>2. After taping, insert the COT w/slit into orange tape using right hand.</p></div></div>		n/a	<div><p>NOTE: USE ORANGE TAPE ONLY</p></div> <div>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong dimension 5. No wrong use of tape</div>

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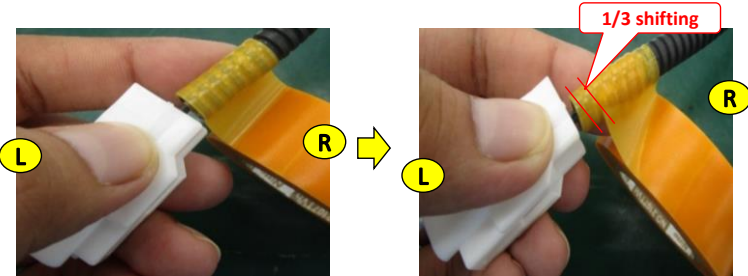
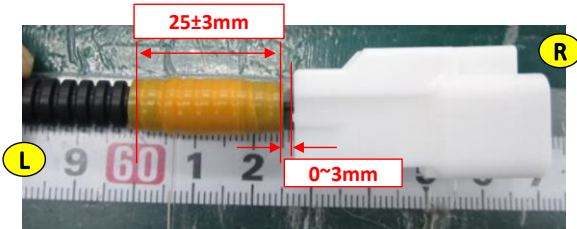

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

Page No.:

4 of 5

PARTS:		1. Assy parts 2. Orange tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	<p>Taping 1 From wire near connector to COT (Continuation)</p>  <p>3. After insertion, conduct <b>2x winding</b> of tape and then make <b>1/3 shifting</b> going to right side until it covers the <b>25mm slit</b>. Make <b>3 winds</b> before cutting of tape.</p>  <p>4. After taping, check the measurement and taping condition.</p>	<p><b>MEASURING TAPE</b></p> 	<p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong dimension 5. No wrong use of tape</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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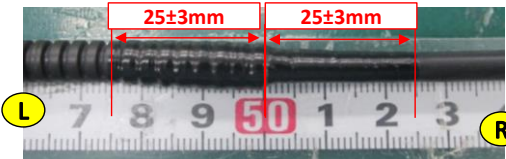

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4

Page No.:

5 of 5

PARTS:		JIG:		
1. Assy parts 2. Black vinyl tube $\phi 5$ L=389 $\pm$ 3mm 3. Black tape		n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Wire insertion to Black vinyl tube $\phi 5$ L=389 $\pm$ 3mm	 <p>1. Get the vinyl tube <math>\phi 5</math> L=389<math>\pm</math>3mm using right hand then insert the B/B wires using left hand.</p>	n/a	1. No wrong use of parts 2. No deformed terminal
7	P1 Taping 2 Black corrugated tube to black vinyl tube	 <p>1. Fix the COT and vinyl tube. Make sure no gap in between.</p>  <p>2. Get the black tape and start taping process using both hands. <i>Note: Please refer to GL-PRO-ASY-001 for taping procedure.</i></p>  <p>3. After taping, check the measurement and taping condition.</p>		<p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong dimension 5. No wrong use of tape</p> <p><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p>

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