

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

Effectivity Date:

May 05, 2022Model Code/ Part Number: **715W RR LH / 7H0351W7020D**Customer: **NBS**

Validity Date:

n/a

Document No.:

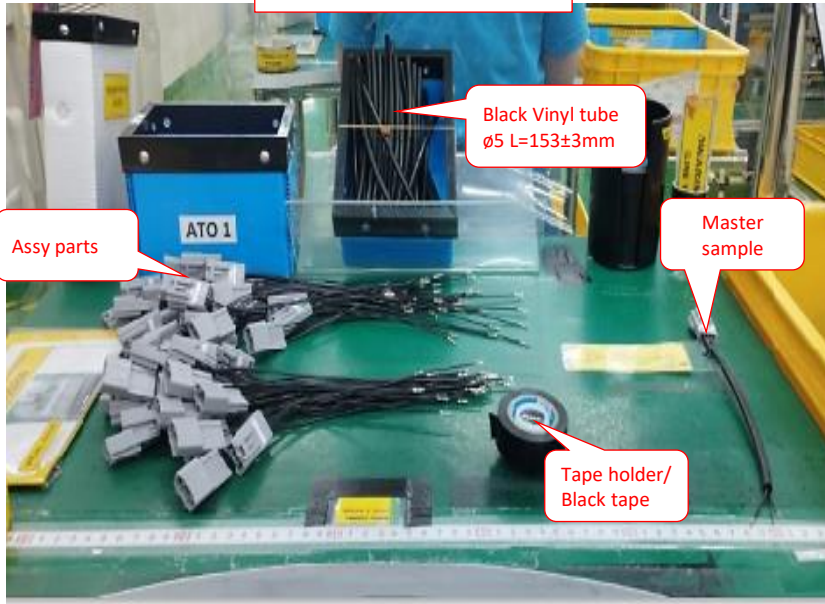
WI-ENG-PDE-473Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:	1. All parts; Pre-assy parts from Offline (Connector 6098-5673 [GR]; AVSSf wires B L= 224±2mm [2pcs]); Black Vinyl tube ø5 L=153±3mm; Black tape			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out	 <p>TABLE LAY-OUT</p> <p>Assy parts</p> <p>Black Vinyl tube ø5 L=153±3mm</p> <p>Master sample</p> <p>Tape holder/ Black tape</p>		<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No wrong usage of parts 2. No deformed terminal
Revision History				Prepared by:	Checked by:
05/05/22	1	Change from Pre-Launch to Masspro. Additional Table Lay-out.		M. Ariola	J. Loterte
04/019/22	0	Initial Issue.		M. Ariola	J. Loterte
Eff. Date	Rev. No	Details of Change		Revised	Reviewed
				Approved	Noted
				Est. Date: April 19, 2022	

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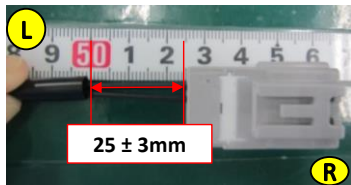



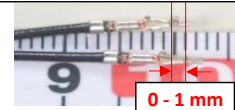
PARTS:

1. Pre-assy parts from kitting (Connector 6098-5673 [GR];
AVSSf wires B L= 224±2mm [2pcs])

2. Black Vinyl tube $\phi 5$ L=153±3mm
3. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Vinyl tube $\phi 5$ L=153±3mm	 <p>Get the Vinyl tube $\phi 5$ L= 153±3mm using right hand then insert the 2 Black wires.</p>	n/a	1. No wrong usage of parts 2. No deformed terminal
3	P1 Taping Black Vinyl tube to Wire near connector	 <p>25 ± 3mm</p> <p>1. Measure the end of the vinyl tube up to edge of connector 25±3mm.</p>  <p>Start of taping</p> <p>2. Get Black tape, hold the vinyl tube ($\phi 5$ L=153±3mm) using left hand then fold the vinyl tube and start taping using right hand. Refer to WI-PRO-ASY-001 for taping procedure</p>  <p>25 ± 3mm 0-5mm Tape Width 40 ± 3mm</p> <p>3. After taping, check the wire alignment, measurement and tape condition.</p>	<p>MEASURING TAPE</p>   <p>0 - 1 mm</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>	1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong tape measurement 6. No missing tape

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PARTS:

n/a

JIG

n/a

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

4

Visual/ By two's inspection

1. Check the connector

2. Check the Taping condition.

3. Check the terminal appearance.
Make sure no deformed terminal.

4. Compare to Master Sample

*Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy***MASTER SAMPLE**

P1

Measurement

**MEASURING TAPE****254 ± 3mm****0-3 mm****40 ± 3mm****NOTE: FOR HATSUMONO AND OWARIMONO**

1. No wrong dimension

*Note:
Please use calibrated/verified measuring tape when getting the measurement.*

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