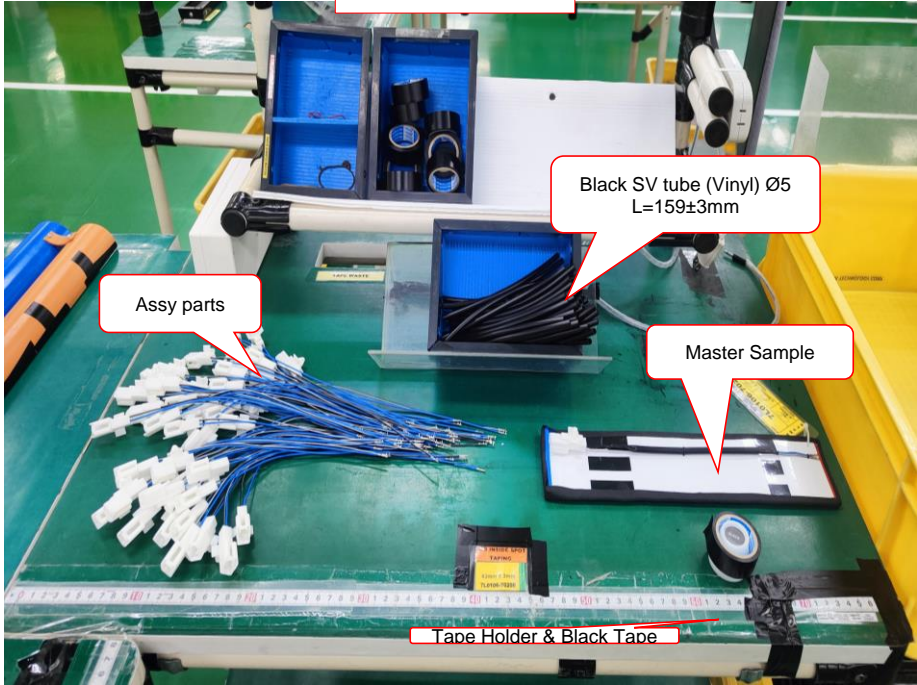
	WORK INSTRUCTION			Effectivity Date:	July 5, 2023		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	-		
	Model code/Part number: J34A / 7L0106-7020E	Customer: TRQSS	Car Model: MAZDA-CX	Document No.:	WI-ENG-PDE-234		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	1 of 6

PARTS:		1. Pre-assy parts: Connector 7182-8049 (W); AVSSf 0.3 L=257±2mm; B/W L=257±2mm)		2. Black SV tube (Vinyl) Ø5 L=159±3mm 3. Black tape		JIG:	n/a
NO.	PROCESS NAME		4 WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<div><div>TABLE LAY-OUT</div></div>			<div><div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>	<div><div>4 Document reference/s: 1. Please refer to WI-ENG-PDE-285 Offline Assembly Process</div><div>1. No missing parts/tools 2. No excess parts/tools</div></div>

Revision History						Prepared by	Reviewed by	Approved by	Noted by
07/05/2023	4	Inclusion of table lay-out and quality check points; improve by two's inspection, document references and important reminders/note/s and work procedure/illustration; standardize term of SV tube (Vinyl); update template, include car model.	J. Loterte	C. Villanueva	A. Arañes	n/a			
06/18/2021	3	Change part number from 7L0106-7020C to 7L0106-7020E due to changes in vinyl tube length from L=173mm to 159mm. Transferred insertion process to Kitting (Refer to WI-ENG-PDE-285). Apply some improvements. Update pictures and additional process.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes			
05/19/2021	2	Extension of validity date due to customer requirements. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes			
01/29/2021	0	Initial issue	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	January 29, 2021	n/a

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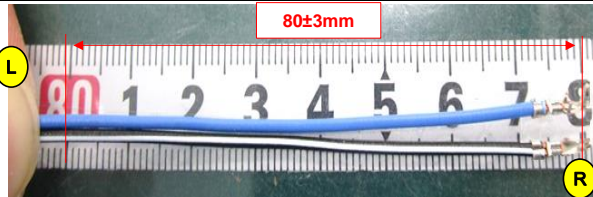
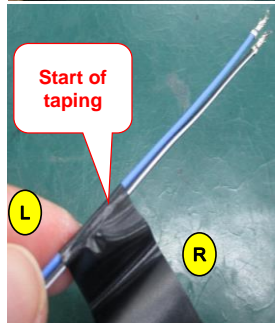
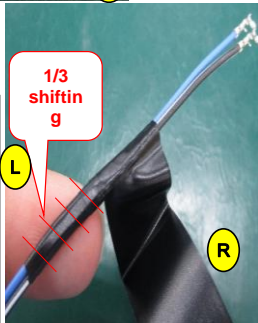
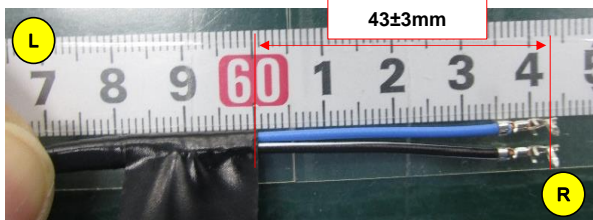
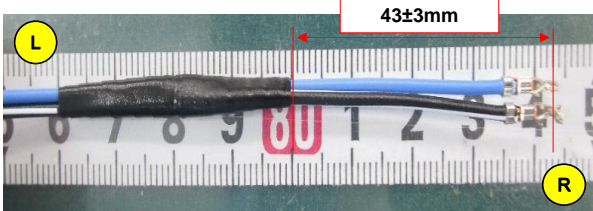
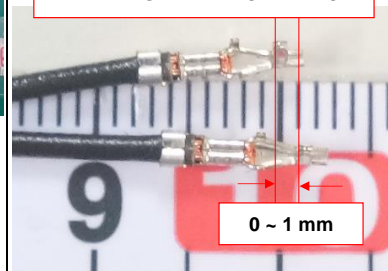
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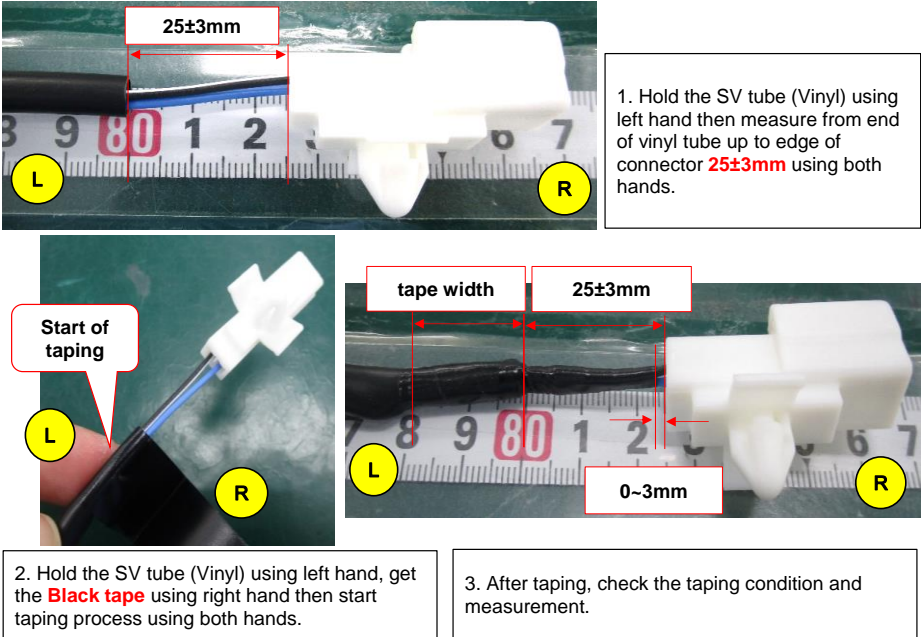

PARTS:		1. Pre-assy parts: Connector 7182-8049 (W); AVSSf 0.3 L L=257±2mm; B/W L=257±2mm) 2.Black tape		JIG:	n/a
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Taping 1 Wire taping	<div></div> <div></div> <div></div> <div></div> <div></div> <div><p>2. Initially attach Black tape using right hand then make 2 windings of tape before shifting.</p><p>3. Make 1/3 shifting of tape then continue the taping process using both hands.</p><p>4. Confirm measurement then make 3 windings of tape before cut.</p><p>5. After taping, check the measurement, taping condition and terminal appearance.</p></div>	MEASURING TAPE	<div></div> <p>Important reminders and Note/s: 4 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape</p>

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	-		
	Model code/Part number: J34A / 7L0106-7020E		Customer: TRQSS	Car Model: MAZDA-CX	Document No.:	WI-ENG-PDE-234	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	3 of 6

PARTS:		1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=159±3mm 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Black SV tube (Vinyl) Ø5 L=159±3mm	 <div> <p>1 Get the SV tube (Vinyl) Ø5 L=159±3mm using right hand then insert the L-B/W wires using left hand.</p> </div>		n/a	1. No wrong usage of parts 2. No deformed terminal
4	P2 Taping 2 Black SV tube (Vinyl) to wire near connector	 <div> <p>1. Hold the SV tube (Vinyl) using left hand then measure from end of vinyl tube up to edge of connector 25±3mm using both hands.</p> <p>2. Hold the SV tube (Vinyl) using left hand, get the Black tape using right hand then start taping process using both hands.</p> <p>3. After taping, check the taping condition and measurement.</p> </div>		MEASURING TAPE 	Important reminders and Note/s: 4 1. Please use calibrated/verified measuring tape when getting the measurement. Document reference/s: 1. Please refer to GL-PRO-ASY-001 for taping procedure.

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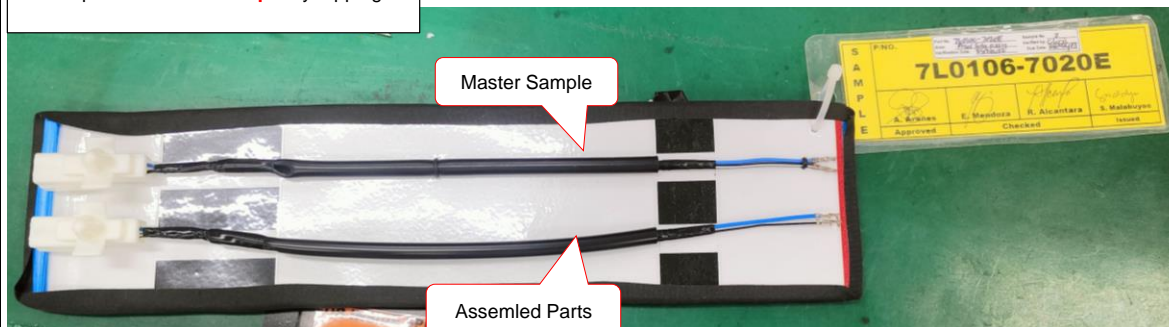

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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	P1 Visual/By Two's Inspection	<div>1. Check the wire insertion in connector.</div> <div>2. Check the taping condition.</div> <div>3. Check the terminal appearance. Make sure no deformed terminal.</div> <div>ACTUAL PRODUCT</div> <div>4. Compare to Master Sample by tapping.</div> <div>Master Sample Assembled Parts</div>		MASTER SAMPLE 	

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PARTS:

1. Assy parts

JIG:

n/a

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

6

P1

Measurement



Important reminders and 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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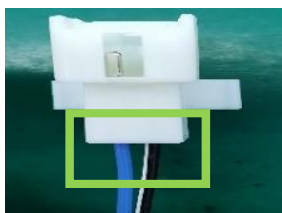
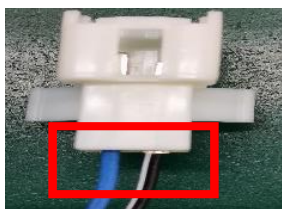
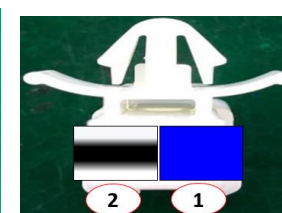
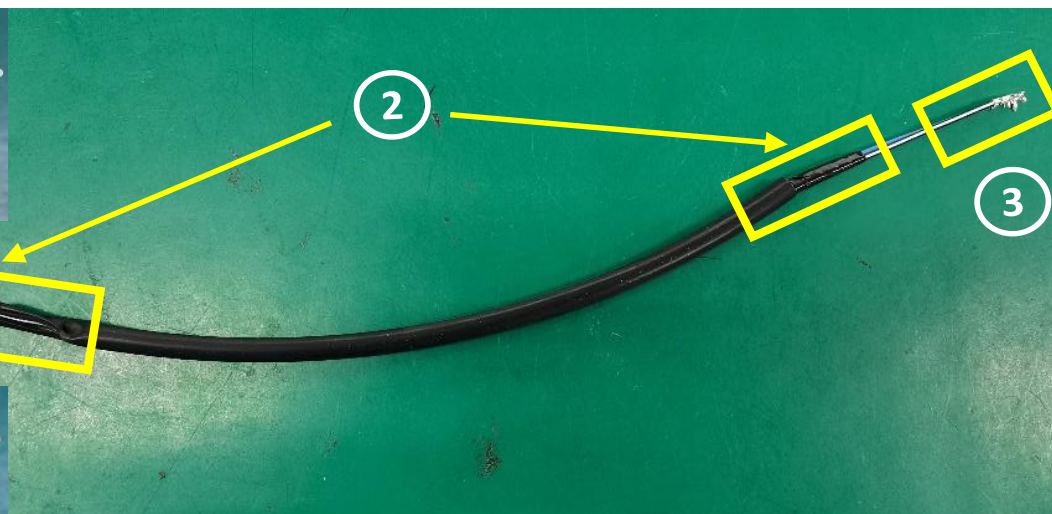
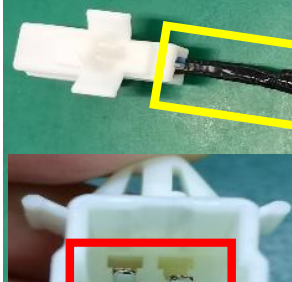
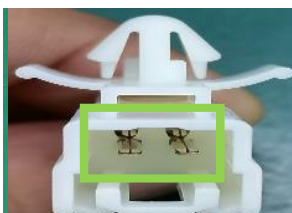
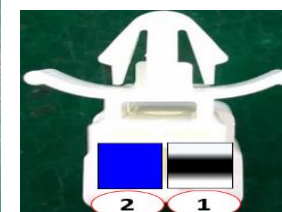
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PARTS:

n/a

JIG:

n/a

4 QUALITY CHECKPOINTS**P1****7L0106-7020E****GOOD****NO GOOD****GOOD****NO GOOD****① No Terminal Backing Out****② No Missing Tape and No Missing Spot Tape (black tape)****③ No Deformed Terminal****④ No Wrong Insert**

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