

	<b>WORK INSTRUCTION</b>				Effectivity Date:		November 25, 2021	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:		Model Code/Part Number: <b>010B / 4 7L0031-7023</b>		Customer: <b>TRQSS</b>		Document No.: <b>WI-ENG-PDE-197B</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		4	Page No.: 1 of 6

<b>PARTS:</b>	1. Assy parts 2. Black tape [1pc.]			<b>JIG:</b>	1. Insertion jig 2. Terminal cover jig 3. Locking jig		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>4 WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
1	P2  4 Table Lay-out	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;">Table Lay-out</div>		<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <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 style="border: 1px dashed red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>		1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
11/25/21	4	Change part number from 7L0031-7022 to 7L0031-7023 due to additional quantity of clamp (82711-52090 (W)) (Refer to WI-ENG-PDE-197C). Improve work procedure and illustration. Additional table lay-out.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
06/03/21	3	Removal of validity date and apply some improvements.	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes									
11/21/20	2	Transfer process owner from Production (WI-PRO-ASY-043A) to Engineering WI-ENG-PDE-197A; Apply some improvements; update pictures	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes									
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	July 10, 2017						

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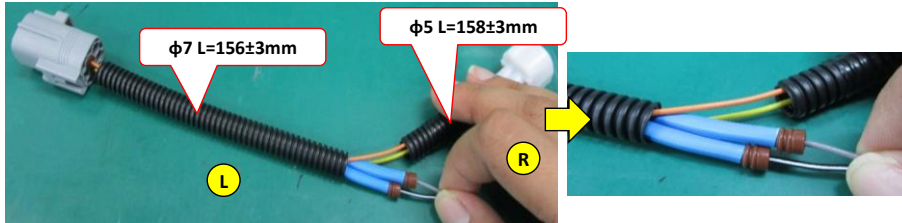
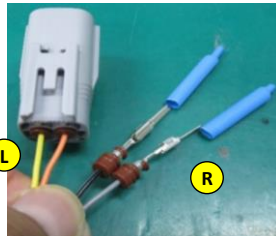

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PARTS:		1. Assy parts			JIG	1. Terminal cover jig
NO.	PROCESS NAME		4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	P2	Wire insertion to COT φ7 L=156±3mm (Assy parts)	<div><p>1. Get the terminal cover jig using right hand then insert to both terminals (GR-B/W wires) using right hand.</p></div> <div><p>2. Hold the COT φ7 L=156±3mm using left hand then insert the GR-B/W wires using right hand.</p></div> <div><p>2. After insertion, remove the cover jig using right hand.</p></div>	<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No damaged rubber seal	

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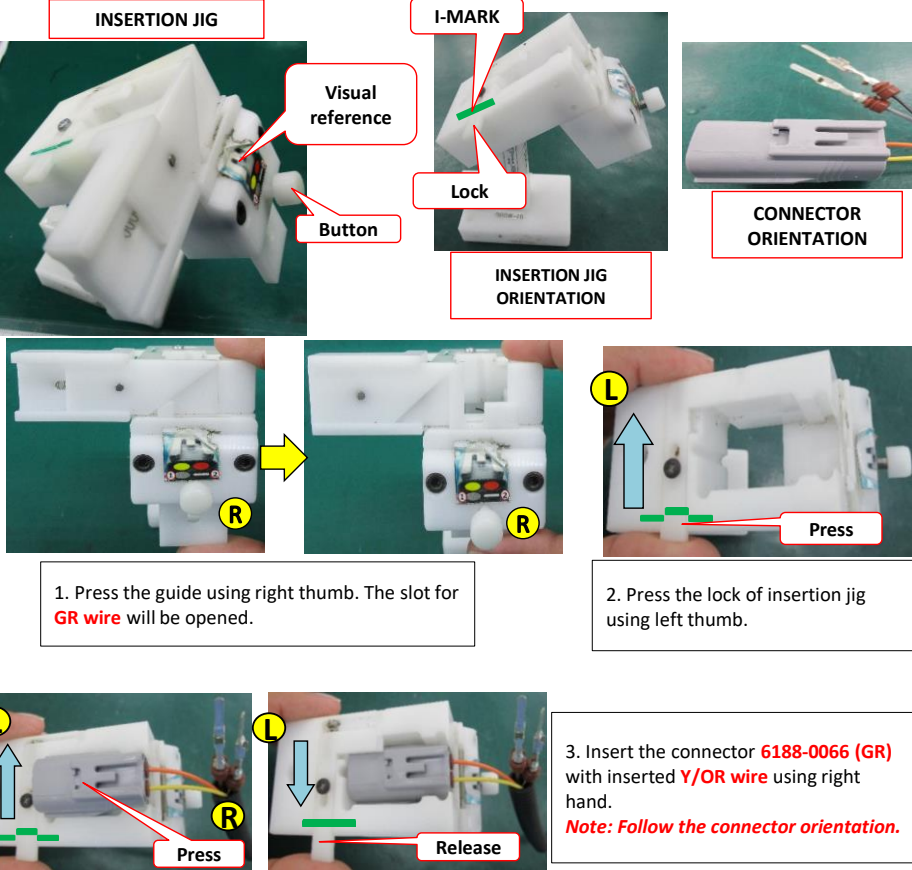
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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	<p>Connector setting to insertion jig 6188-0066 (GR) (Assy parts)</p>  <p>1. Press the guide using right thumb. The slot for <b>GR wire</b> will be opened.</p> <p>2. Press the lock of insertion jig using left thumb.</p> <p>3. Insert the connector <b>6188-0066 (GR)</b> with inserted <b>Y/OR wire</b> using right hand. <i>Note: Follow the connector orientation.</i></p>		n/a	<p><b>Connector Orientation Illustration</b></p> <p>I-mark is align 1 Hole is open</p> <p><b>GOOD</b></p> <p>I-mark is NOT align 2 Holes are opened</p> <p><b>NG</b></p> <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>

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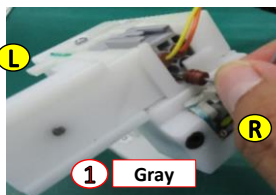

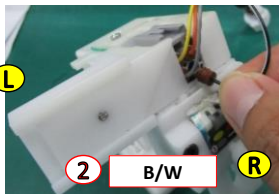



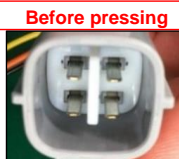










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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS								
4	P2	Wire insertion to connector 6188-0066 (GR) (Assy parts)	<div><p>1 Hold the <b>GR wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for <b>B/W wire</b> will be opened.</p></div> <div><p>3. Hold the <b>B/W wire</b> then insert to terminal slot <b>2</b> using right hand.</p></div> <div><p>4. 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	<div><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p><p>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p><p>4 <b>Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></p></div>								
5	Connector Lock	<div><p>1. Put the connector into locking jig using both hands and then conduct <b>2x</b> pressing. Check the connector if properly locked.</p></div> <div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><p>Coupler Cross Sectional View</p><table><tr><td>NG</td><td>NG</td><td>GOOD</td></tr><tr><td></td><td></td><td></td></tr><tr><td>Unlock</td><td>Half Lock Condition</td><td>Full Lock Condition</td></tr></table></div>	NG	NG	GOOD				Unlock	Half Lock Condition	Full Lock Condition	<b>Locking jig</b> 	<div><p><b>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK</b></p><p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p></div>
NG	NG	GOOD											
													
Unlock	Half Lock Condition	Full Lock Condition											

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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	P2  Taping 1 Black COT to Black sunprene tube near PCB	<div><div><div><div><div>L</div><div>176±3mm</div><div>R</div></div></div><div><div>1. Measure from end of corrugated tube up to the edge of hotmelted wires 176±3mm using both hands.</div></div></div><div><div><div><div>L</div><div>Start of taping</div><div>R</div></div></div><div><div>2. Hold corrugated tube using left hand, conduct pre-taping using both hands. Note: Refer to WI-PRO-ASY-001 for taping procedure</div></div></div><div><div><div><div>L</div><div>tape width</div><div>R</div></div></div><div><div>176±3mm</div><div>3. After taping, check the measurement and taping condition.</div></div></div></div> <div><div>Measuring jig</div><div></div></div>		<div>Note: Please use calibrated/verified measuring tape when getting the measurement.3</div> <div><div>1. No flip-out tape</div><div>2. No peel-off tape</div><div>3. No loose tape</div><div>4. No missing tape</div><div>5. No wrong dimension</div><div>6. No wrong use of tape</div></div>	

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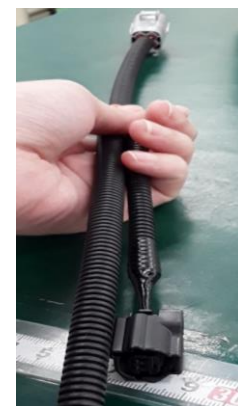
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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P2	Y-taping	n/a	<p>Note: USE <b>YELLOW TAPE</b> FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE <b>BLACK TAPE</b></p> <ol style="list-style-type: none"><li>No flip-out tape</li><li>No peel-off tape</li><li>No loose tape</li><li>No missing tape</li><li>No wrong dimension</li><li>No wrong use of tape</li></ol> 

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