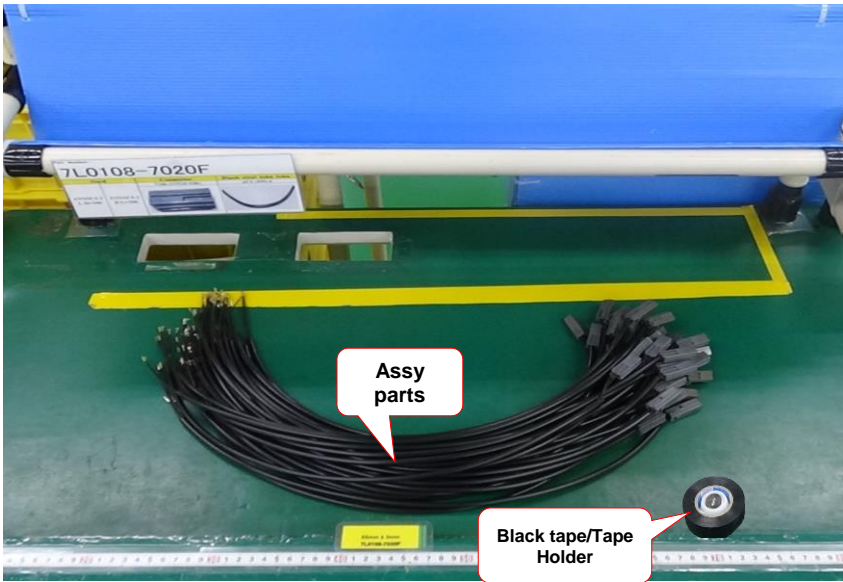




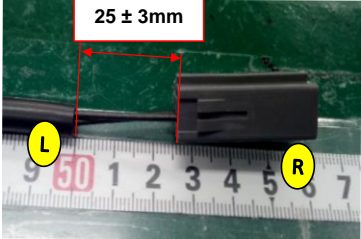
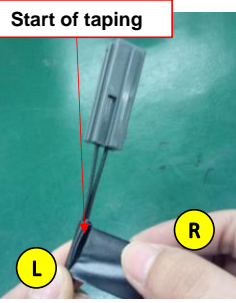
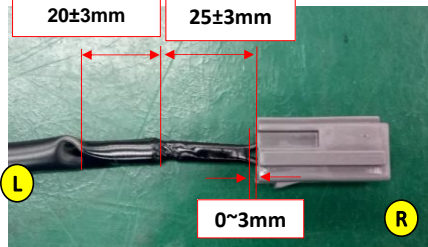
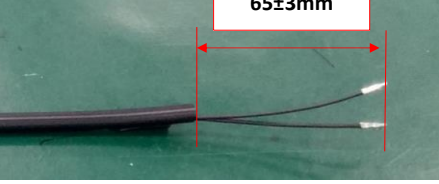

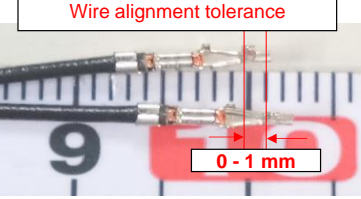
	WORK INSTRUCTION				Effectivity Date:		July 02, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: J34A / 7L0108-7020F		Customer: TRQSS		Car Model: MAZDA-CX		Document No.: WI-ENG-PDE-236	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		4	Page No.: 1 of 4


PARTS:		1. Assy parts 2. Balck tape		JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P1	<div style="text-align: center;"> TABLE LAY-OUT </div> 		<div style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> Housekeeping 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; margin-top: 10px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		Document reference/s: 1. Please refer to WI-ENG-PDE-703 for OFFLINE ASSEMBLY PROCESS	
				1. No missing parts/tools 2. No excess parts/tools			

Revision History						Prepared by	Reviewed by	Approved by	Noted by	
07/02/24	4	Inclusion of Meaurement.	D. Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	
07/18/23	3	Updated template; Inclusion of CAR MODEL "MAZDA-CX"; Updated Table lay-out; Standardize tube description; SV tube (Vinyl); Change MP from 1 MP to 2MP with OFFLINE ASSEMBLY PROCESS ; Transferred process no. 1 and 2 from P1 to OFFLINE ASSEMBLY PROCESS due to new process distribution (Refer to ENGDRR-131); Additional Quality Checkpoints.	M. Ariola	C. Villanueva	A. Arañes	n/a				
06/18/21	2	Change part number from 7L0108-7020B to 7L0108-7020F due to change vinyl tube length from L=520mm to L=499mm. Change taping location from Vinyl tube to wire near terminal to Vinyl tube to wire near connector.	D. Castillo	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	January 29, 2021		


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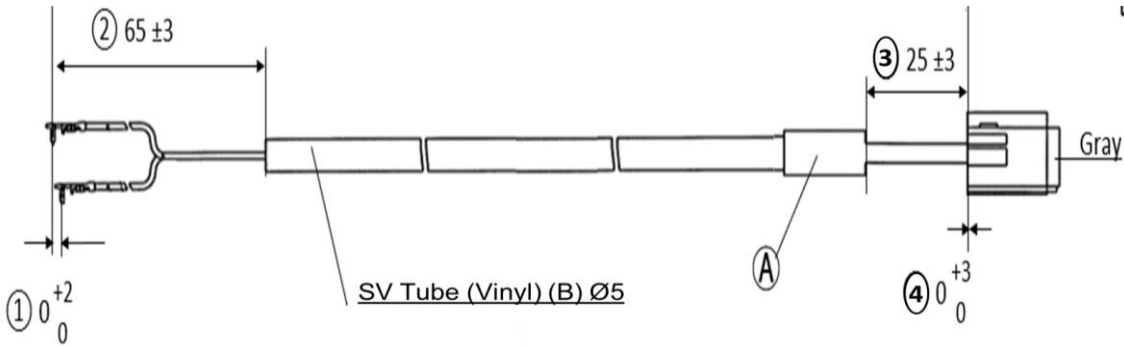
	WORK INSTRUCTION				Effectivity Date:	July 02, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: J34A / 7L0108-7020F		Customer: TRQSS	Car Model: MAZDA-CX	Document No.:	WI-ENG-PDE-236		
	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	4	Page No.:	2 of 4

PARTS: 1. Assy parts 2. Black tape		JIG: n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
2	P1 Taping 1 Black SV tube (Vinyl) to wire near connector	<div>  <p>25 ± 3mm</p> <p>1. Hold the SV tube (Vinyl) using left hand. Measure from SV tube (Vinyl) up to edge of connector 25±3mm using both hands.</p> </div> <div>  <p>Start of taping</p> <p>2. Get Black tape, hold the SV tube (Vinyl) (ø5 L=499±4mm) using left hand then fold the SV tube (Vinyl) and start taping using right hand.</p> </div> <div>  <p>20±3mm</p> <p>25±3mm</p> <p>0~3mm</p> <p>3. After taping, check the measurement and tape condition.</p> </div> <div>  <p>65±3mm</p> </div>	<div> <p>MEASURING TAPE</p>  </div>
		QUALITY POINTERS	
		1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape	
		Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.	
		Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure	
		<div>  <p>Wire alignment tolerance</p> <p>0 - 1 mm</p> </div>	

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	WORK INSTRUCTION				Effectivity Date:		July 02, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: J34A / 7L0108-7020F		Customer: TRQSS		Car Model: MAZDA-CX		Document No.: WI-ENG-PDE-236	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		4	Page No.: 3 of 4

PARTS:		1. Assy parts		JIG:		n/a	
NO.	PROCESS NAME	<div>4</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE		QUALITY POINTERS		
4	P1	Measurement	<div>MEASURING TAPE</div>   <div>NOTE: (A) - Taping (B)</div>		<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono. Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>		

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 02, 2024

Validity Date:

n/a

Model code/Part number:

J34A / 7L0108-7020F

Customer:

TRQSS

Car Model:

MAZDA-CX

Document No.:

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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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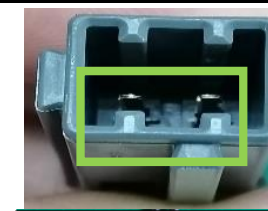
4 of 4

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**P1****7L0108-7020F****GOOD****NO GOOD****GOOD****NO GOOD****1 No Terminal Backing-out****2 No Missing tape (Black tape)****3 No deformed terminal**

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