



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

July 21, 2021

Process Name/Title:

Validity Date:

n/a

Product Name/Code:

480A / A7040E

Customer:

TRQSS

Document No.:

WI-ENG-PDE-305

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

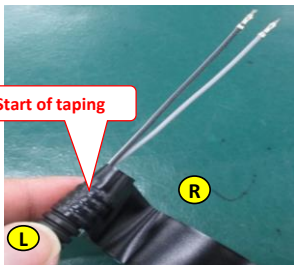


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PARTS:

1. Pre-assy parts from Kitting: Connector 6188-0407 (W); AVSSf wires GR-B/W L=216±2mm; Clip type clamp 82711-1E360 (W); Black Corrugated tube (no slit) Ø7 L=125±3mm
2. Black tape

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Taping 1 Black corrugated tube to wire near terminal	 <p>1. Get the Black tape using right hand then start taping process using both hands.</p>  <p>2. Measure from end of COT up to end of terminal pointed tip 78±3mm then continue the taping process using both hands.</p>  <p>3. After taping, check the measurement and taping condition.</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 workplace 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> <p>MEASURING TAPE</p>	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p> <p>Wire alignment tolerance 0 ~ 1 mm</p>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/21/21	3	Transfer process owner from Production WI (WI-PRO-ASY-008) to Engineering WI (WI-ENG-PDE-305). Improve process illustration and quality pointers. Change connector color in accordance with color standardization for plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts). Removal of marking.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
09/18/19	2	Remove clip insertion.	A. Roxas	W. Carbillon	O. Merin	n/a				
07/10/17	0	Initial issue	J. Montecillo/ L. Briones	W. Carbillon	O. Merin	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	July 10, 2017		

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NO.

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WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

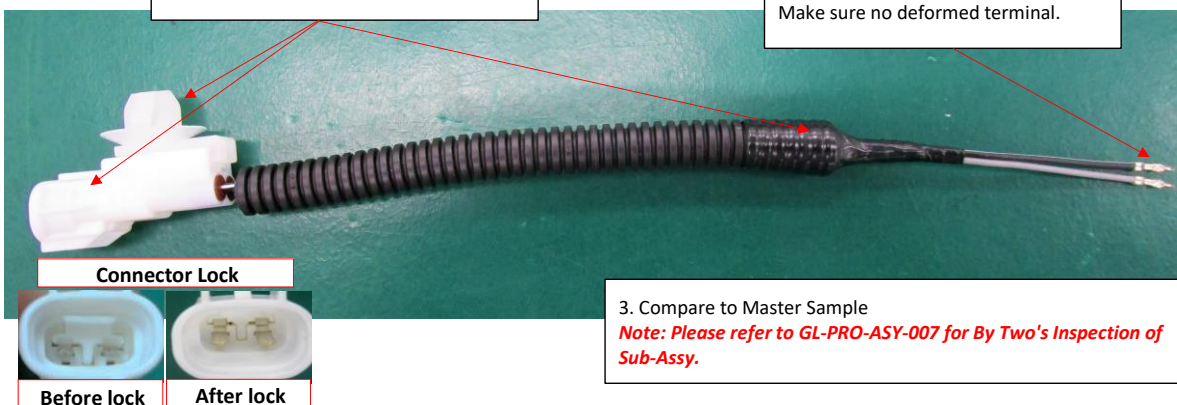
1

Visual/By Two's inspection

P1

1. Check the connector lock, presence of clamp and taping condition.

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



MASTER SAMPLE



3

1

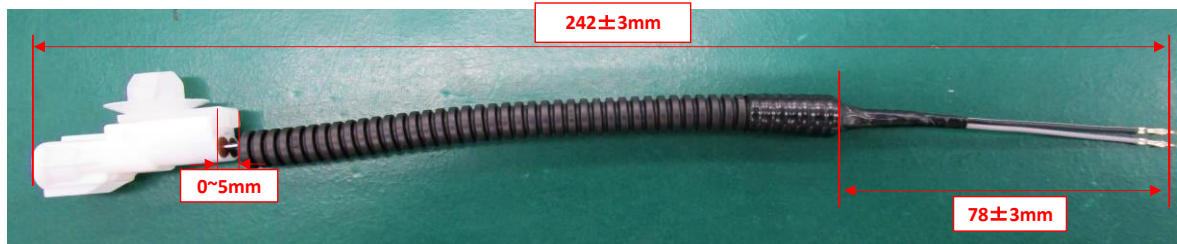
Measurement

MEASURING TAPE



Note:

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



NOTE: FOR HATSUMONO AND OWARIMONO

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