



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	September 30, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-323A		
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Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number: **660B / 7R0111-7020B** Customer: **TRMX**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:

1

1. All parts (Connector 6098-3802 (W); IRRAX A ROPE-LAY 0.3 B/B L=382mm; V/V L=407mm; Black corrugated tube (no slit) $\phi 7$ L=210 \pm 3mm; Black corrugated tube (no slit) $\phi 5$ L=116 \pm 3mm; Black corrugated tube (no slit) $\phi 5$ L=106 \pm 3mm; Yellow tape [1pc.]; Black tape [1pc.]

JIG:

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<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>	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
09/30/21	1	Revise due to transfer of insertion process to Kitting (Refer to WI-ENG-PDE-348); Provide insertion jig and locking jig; Improve all process description and illustration; Change from pre-launch to masspro.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
08/10/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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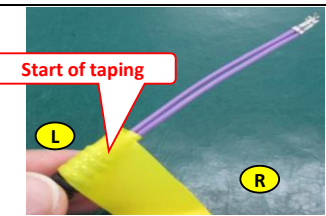
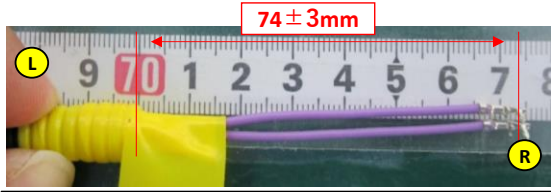
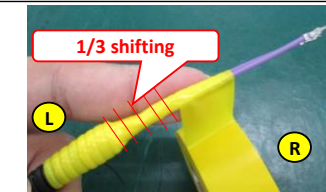
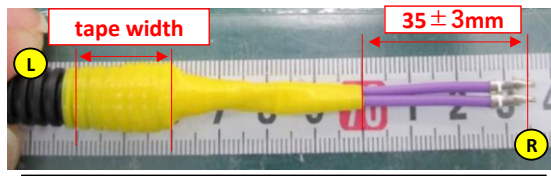

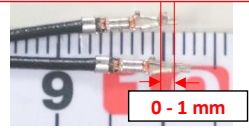
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black Corrugated tube (no slit) Ø5 L=116±3mm 3. Yellow tape	JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black Corrugated tube (no slit) Ø5 L=116±3mm	 1. Get the assy part and combine the V/V wires L=407mm using both hands and get the terminal cover jig using right hand  2. Get the corrugated tube (no slit) Ø5 L=116±3mm using right hand and insert the wires using left hand.  3. After insertion, remove the terminal cover jig using right hand.	 TERMINAL COVER JIG	1. No wrong usage of parts 2. No deformed terminal tip
3	P1 Taping 1 Black corrugated tube to wire near terminal	 1. Hold the COT using left hand, get the Yellow tape using right hand then start pre-taping using both hands.  2. Measure from end of COT up to terminal pointed tip 74±3mm then continue the taping process using both hands.  3. Make 1/3 shifting on wires until it measures from end tape up to terminal pointed tip 35±3mm .  4. After taping, check the measurement, terminal appearance and taping condition.	 MEASURING TAPE	NOTE: USE YELLOW TAPE ONLY.  Wire alignment tolerance 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension Note: Please use calibrated/verified measuring tape when getting the measurement.

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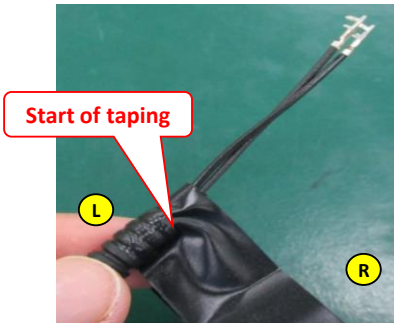
☒ MASSPRO

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PARTS:		1. Assy parts 2. Black Corrugated tube (no slit) $\phi 5$ L=106 \pm 3mm 3. Black tape	JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Wire insertion to Black corrugated tube $\phi 5$ L=106 \pm 3mm (no slit)	<div><p>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B/B wires using left hand.</p></div> <div><p>2. Get the corrugated tube (no slit) $\phi 5$ L=106\pm3mm using right hand then insert the B/B wires using left hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>	<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No deformed terminal tip
5	Taping 2 Black corrugated tube to wire near terminal	<div><p>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div>	n/a	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape

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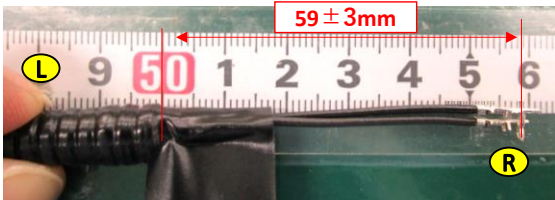
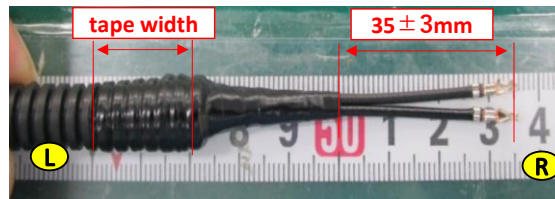

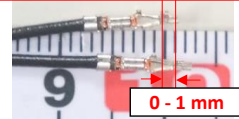
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PARTS:		1. Assy parts 2. Black tape			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	Taping 2 Black corrugated tube to wire near terminal (Continuation) P1	 <p>2. Measure from end of COT up to terminal pointed tip 59±3mm then continue the taping process using both hands.</p>  <p>3. After taping, check the measurement, terminal appearance and taping condition.</p>				 <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p> <p>Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p>

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