



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

January 06, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: 178D / 7N0128-7020

Customer:

TRJ

Document No.:

WI-ENG-PDE-331B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts; Black tape [1pc]

JIG:

1. Insertion jig
2. Locking jig
3. Terminal cover jig

NO.

PROCESS NAME

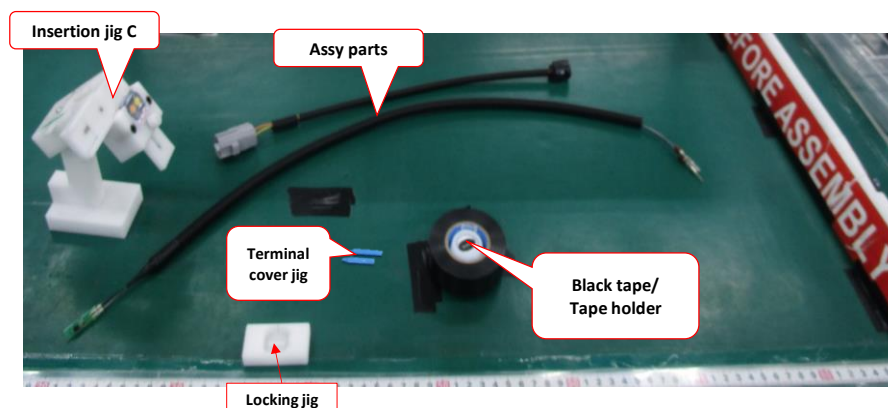
1 WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P2

1 Table Lay-out**Table Lay-out****Safety Instruction**

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

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
01/06/22	1	Change from Pre-launch to Masspro. Improve work procedure/illustration and quality pointers; Additional Table Lay-out.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
09/09/21	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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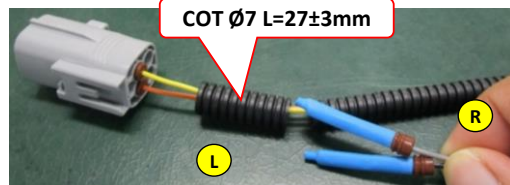
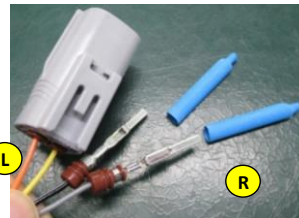

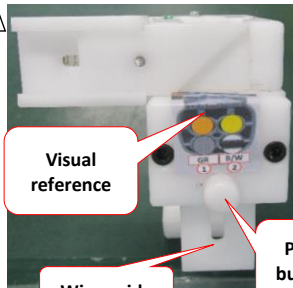
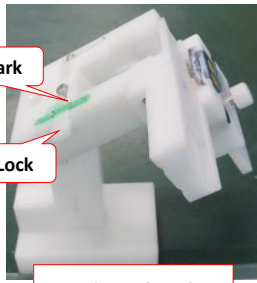


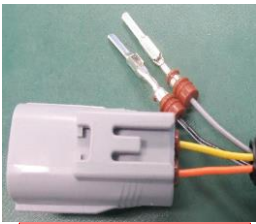
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts		JIG	1. Terminal cover jig 2. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to assy parts P2	<div><div></div><div><p>1. Get the MRSW CP GR-B/W wires L=654±3mm using both hands then insert the terminal cover jig using right hand.</p></div></div> <div><div></div><div><p>2. Get the assy parts then hold the COT (no slit) Ø7 L=27±3mm using left hand then insert the MRSW CP GR-B/W wires L=654±3mm using right hand.</p></div></div> <div><div></div><div><p>3. After insertion, remove the cover jig using right hand.</p></div></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No damaged rubber seal 3. No exposed rubber seal during insertion
3	Connector setting to insertion jig 6188-0066 (GR) (Assy parts)	<div><div></div><div><p>Wire guide</p></div></div> <div><div></div><div><p>I-mark</p></div><div><p>Lock</p></div></div> <div><div></div><div><p>Push button</p></div></div> <div><div></div><div><p>INSERTION JG ORIENTATION</p></div></div> <div><div></div><div><p>CONNECTOR ORIENTATION</p></div></div>		n/a	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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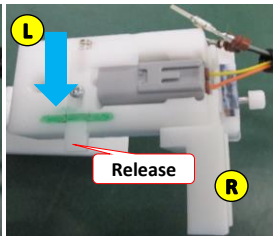
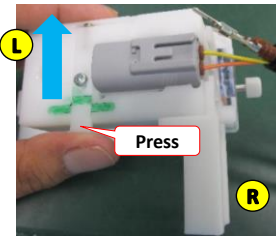
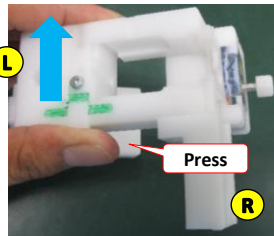
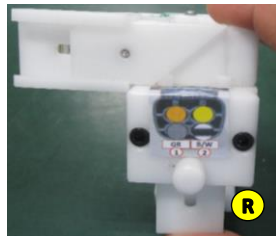
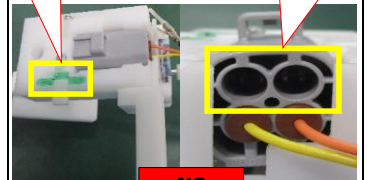
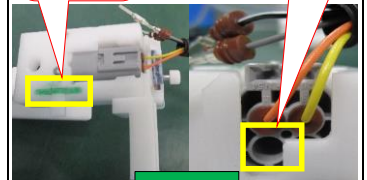
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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Connector setting to insertion jig 6188-0066 (GR) (Assy parts) (Continuation)	<div><div></div><div><p>Hole</p><p>1. Push the lower wire guide upward using right thumb. Slot for Gray wire will be opened.</p><p>Press</p><p>2. Press the lock using left thumb.</p><p>Press</p><p>Release</p><p>3. Get the connector 6188-0066 (GR) using right hand and insert to insertion jig. Release the lock after insertion. <i>Note: Follow the connector orientation.</i></p></div></div>		3	<div><div></div><div><p>1. Insertion jig</p><p>CONNECTOR ORIENTATION ILLUSTRATION</p><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p><p>I-mark is not align</p><p>2 holes are open</p><p>NG</p></div><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></div>

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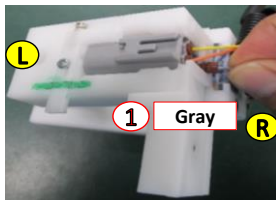

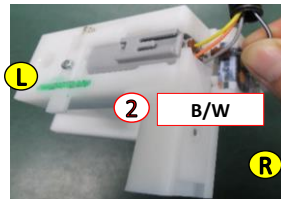
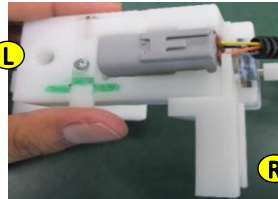
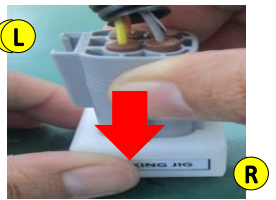


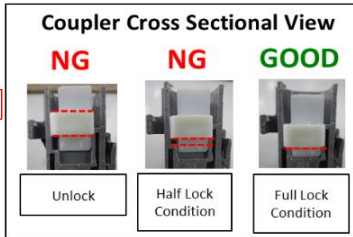

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PARTS:	1. Assy parts		JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2 Wire insertion to connector 6188-0066 (GR) (Assy parts)	<div><div><p>1 Hold the GR wire then insert to terminal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

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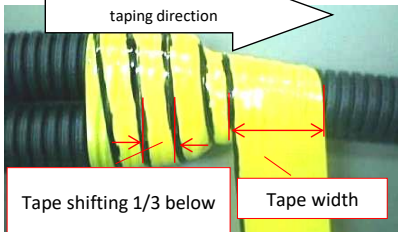
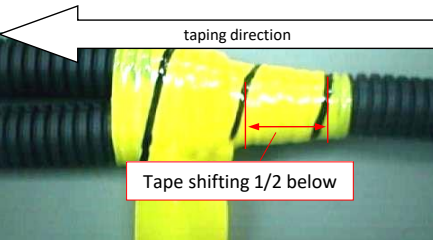


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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2 Y-taping	<div><div><p>1</p><p>NO WIDE INTERVAL</p><p>1. Fix the corrugated tube .</p></div><div><p>taping direction</p><p>Tape shifting 1/3 below</p><p>Tape width</p><p>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)</p></div><div><p>2</p><p>taping direction</p><p>Tape shifting 1/2 below</p><p>4. Wind the tape backward 1/2 shifting</p></div><div><p>Note: Do not exert excessive force during pulling & winding of tape</p><p>Tape width</p><p>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side, width must be same with tape (19mm)</p></div></div>	<p>MEASURING TAPE</p> 	<p>Note: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape <p>Y-TAPING ORIENTATION</p> 

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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

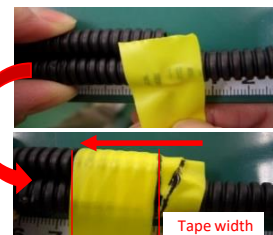
Y-taping
(continuation)

1

NO WIDE INTERVAL



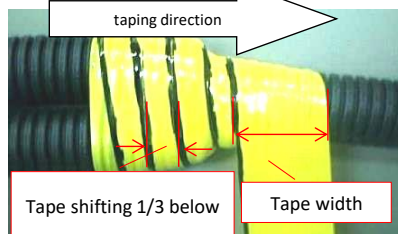
1. Fix the corrugated tube .



Note: Do not exert excessive force during pulling & winding of tape

Tape width

2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side, width must be same with tape (19mm)

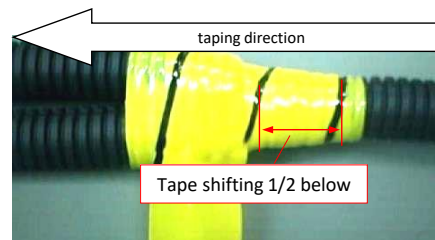


taping direction

Tape shifting 1/3 below

Tape width

3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)



taping direction

Tape shifting 1/2 below

4. Wind the tape backward 1/2 shifting

MEASURING TAPE



Note:
USE **YELLOW TAPE** FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE **BLACK TAPE**.

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

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

Y-TAPING ORIENTATION



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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

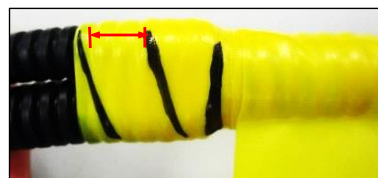
QUALITY POINTERS

6

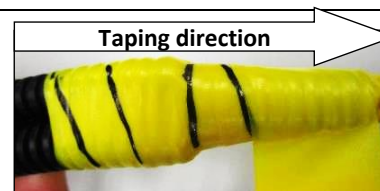
P2

Y-taping
(continuation)

1

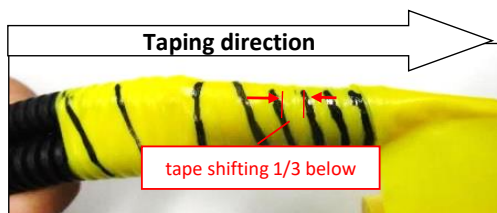


5. Wind the tape 1/2 shifting going to other side of corrugated tube.



Taping direction

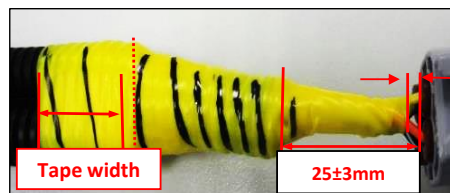
6. Make the half of tape outside the COT then wind it 2-3 times as Pre-Taping.



Taping direction

tape shifting 1/3 below

7. Wind the tape 1/3 shifting until it reach the wire , make 3 winds to wires then cut.



Tape width

25±3mm

Note: 0 - 5mm
→End tape up to coupler (includes rubber seal)

8. After taping, check the measurement and taping condition.

MEASURING JIG



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

Note:

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

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