

	WORK INSTRUCTION						Effectivity Date:		December 16, 2022	
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:				Model Code/Part Number: 010B / 7L0031-7024		Customer: TRQSS		Document No.: WI-ENG-PDE-428B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		1	Page No.: 1 of 7

PARTS:	1. Assy parts 2. Black tape [1pc.]						JIG:	1. Insertion jig 2. Terminal cover jig 3. Locking jig					
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE		QUALITY POINTERS		
1	P2 Table Lay-out		<div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;">Table Lay-out</div>						<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction 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;"> 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;"> 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								Prepared by		Reviewed by		Approved by		Noted by	
12/16/22	1	Improve quality pointers: Reminders/notes and references. Inclusion of Quality checkpoints	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
03/05/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:		March 5, 2022			

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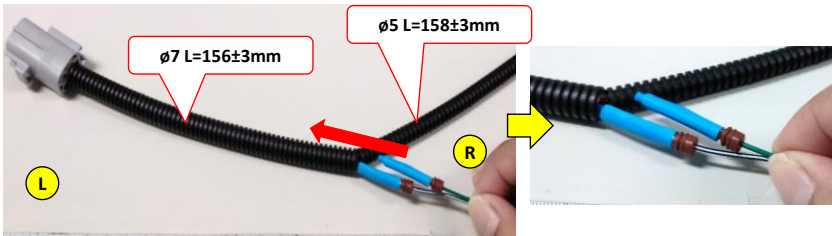
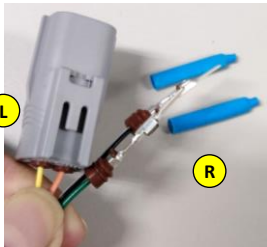

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P2	<div><p>1. Get the terminal cover jig using right hand then insert to both terminals (G-B/W wires) using right hand.</p></div> <div><p>2. Hold the COT $\phi 7 L=156\pm 3\text{mm}$ using left hand then insert the G-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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☐ PROTOTYPE

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

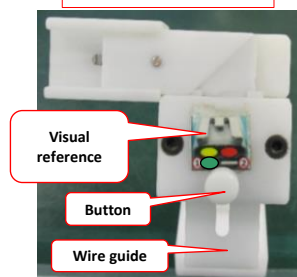
QUALITY POINTERS

3

P2

Connector setting to
insertion jig
6188-0066 (GR)
(Assy parts)

INSERTION JIG



Visual
reference

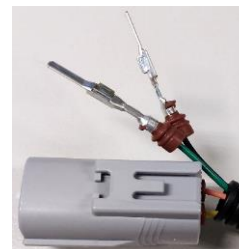
Button

Wire guide

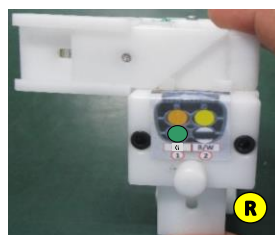
I-mark

Lock

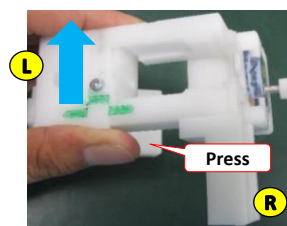
INSERTION JIG
ORIENTATION



CONNECTOR
ORIENTATION



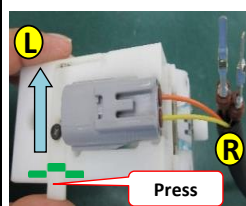
Hole



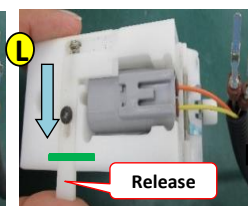
Press

1. Push the lower wire guide upward using right thumb. Slot for **Green wire** will be opened.

2. Press the lock using left thumb.



Press



Release

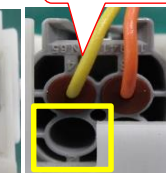
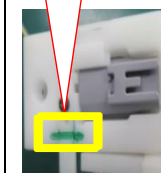
3. Flip the assy parts upward to make way for insertion using left hand. Push the wire guide upward using right hand. Slot for **Green wire** will be opened.

n/a

Connector Orientation Illustration

I-mark is align

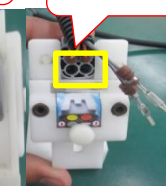
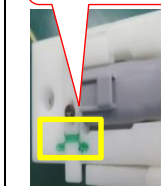
1 Hole is open



GOOD

I-mark is NOT
align

2 Holes are
opened



NG

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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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

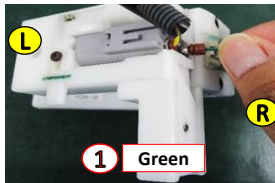


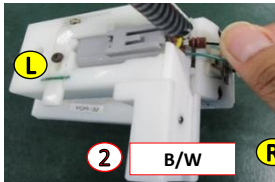
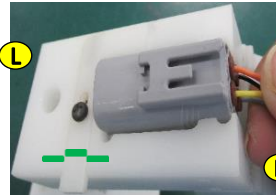
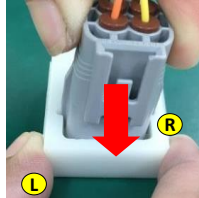


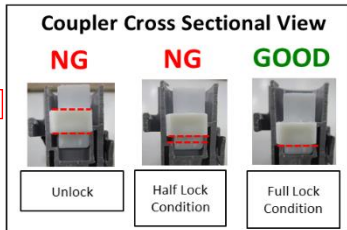

☒ MASSPRO

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PARTS:	1. Assy parts			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1. QUALITY POINTERS
4	P2 Wire insertion to connector 6188-0066 (GR)	<div><div><p>1 Hold the Green wire then insert to terminal slot 1 using right hand.</p></div><div><p>WIRE FACING</p><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><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>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p><p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p></div>
5	Connector Lock	<div><div><p>1. Put the connector into locking jig using right hand then press 2x. Touch the connector lock to confirm if properly locked.</p></div><div><div><p>Before pressing</p><p>After pressing</p></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><p>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p><p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p></div>

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☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

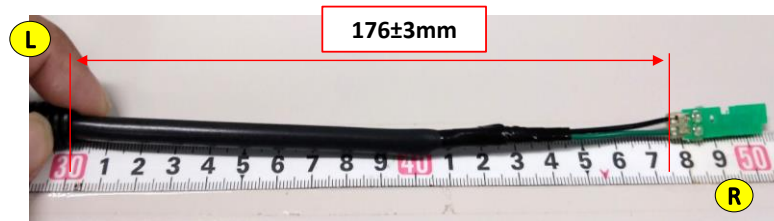
TOOLS/PPE

1 QUALITY POINTERS

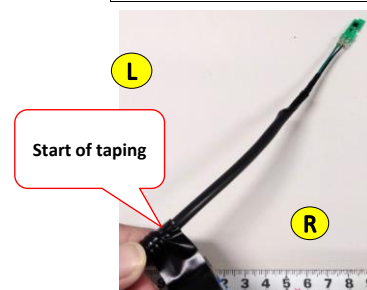
6

P2

Taping 1
Black COT to
Black sunprene tube near
PCB



1. Measure from end of corrugated tube up to the edge of hotmelted wires **176±3mm** using both hands.



2. Hold corrugated tube using left hand, conduct pre-taping using both hands then continue the taping process using both hands.



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

MEASURING TAPE



Important reminders/Note/s:
1. 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

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE


1 QUALITY POINTERS

7

P2

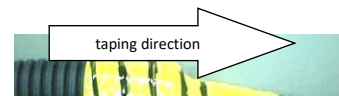
Y-taping

No gap between tubes

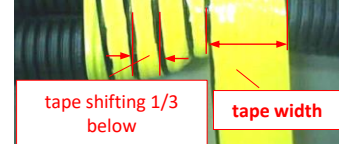


1. Fix the corrugated tube .

taping direction



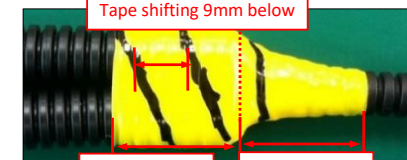
tape shifting 1/3 below



tape width

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

Tape shifting 9mm below



Tape width


Tape width

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

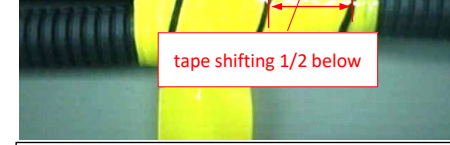
tape width

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 1/2 below



4. Wind the tape backward 1/2 shifting

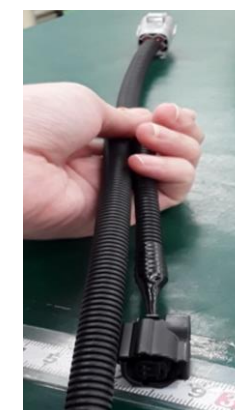
5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.

n/a

Important reminders/Note/s:

1. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE**.
2. 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
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Y-Taping Orientation

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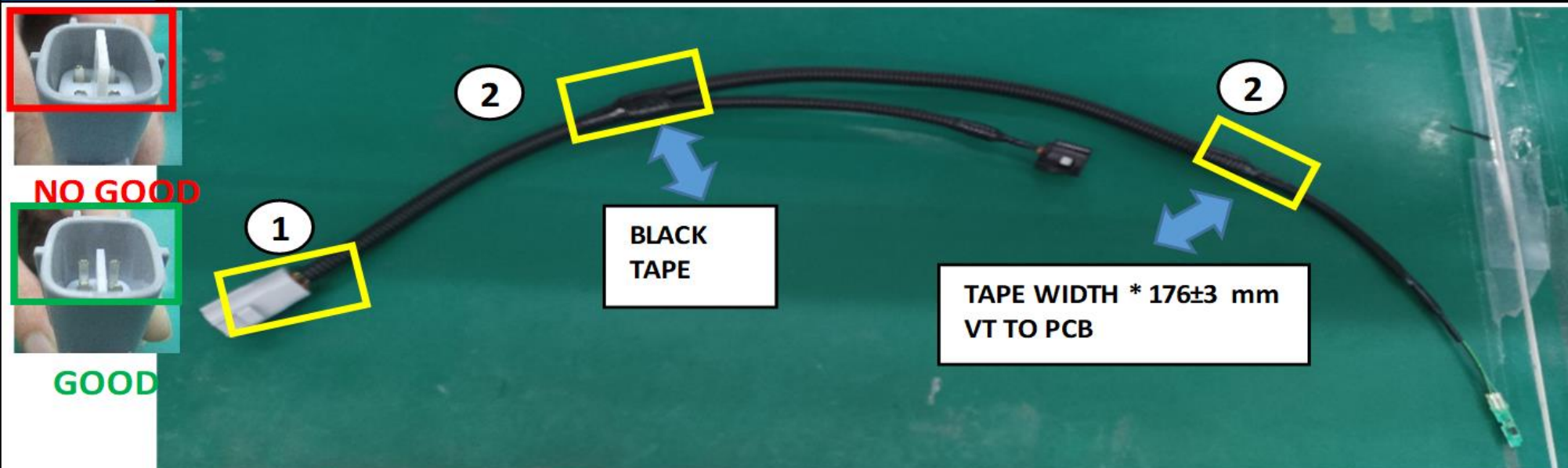
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PARTS:

1. Assy parts

JIG

n/a

1 QUALITY CHECKPOINTS**P2****7L0031-7024**

1 No **WRONG INSERT**
No **UNLOCKED/HALFLOCKED**
NO **TBO**

2 No **Missing tape**

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