

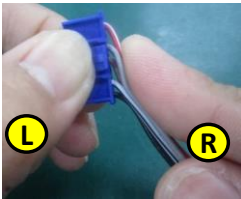
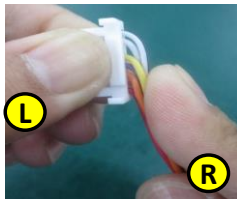







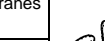



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	April 4, 2023		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-041B		
Revision No.:	6	Page No.:	1 of 7

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model code/Part number:	435B / 75N731-0101	Customer:	TRJ
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	1. Assy parts	JIG:	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Wire folding     BEFORE FOLDING AFTER FOLDING	Safety Instruction Be sure to wear prescribed 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.	 Terminal tip must be visible Document References: 1. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.   ALL WIRES MUST BE BEND

Revision History								Prepared by:	Reviewed by:	Approved by:	Noted by:
04/04/23	6	Standardized tube description: VM tube (Sunprene); Inclusion of Quality Checkpoints on page no. 7 as document process improvement.	M. Ariola	J.Loterte	C. Villanueva	A. Arañes	 M. Ariola	 J. Loterte	 C. Villanueva	 A. Arañes	
09/23/22	5	Remove Marking process due to improvement. Include WI-ENG-PDE-431 for Steering Electrical Test after assembly.	D.Castillo	J.Loterte	C. Villanueva	A. Arañes					
02/11/21	4	Change connetor colors in accordance with standardization for plastic parts; Removal of cycle time; Put assy parts on pg.1-6; Conduct semi-annual review of documents; Put measuring tape instruction and illustration on pg. 7; Add wire facing arrangement.	J. Loterte	C.Villanueva	A. Shimamura	A. Arañes					
Eff. Date	Rev. No	Details of Change			Revised	Checked	Approved	Noted	Est. Date:	October 28, 2019	

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

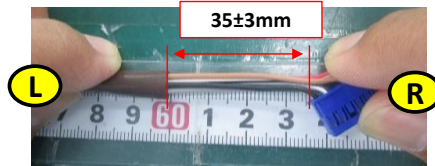
TOOLS/PPE

QUALITY POINTERS

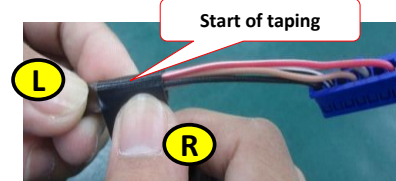
2

P2

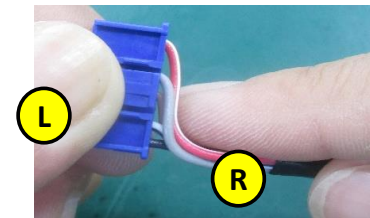
Taping 1
Brown VM tube
(Sunprene) to wire near
connector
XAP-07V-1-E (L)



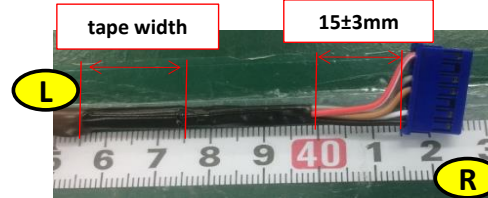
1. Hold the VM tube (Sunprene) using left hand and measure from end of sunprene tube up to edge of connector **35±3mm**.



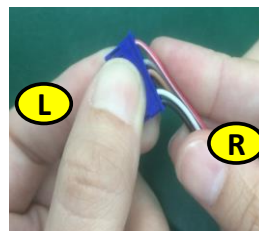
2. Hold the VM tube (Sunprene) using left hand and start taping process using right hand.



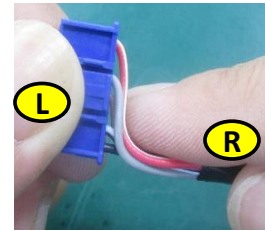
3. Hold the connector and slowly fold the wires using right hand.



4. After folding, check the measurement and taping condition.



BEFORE FOLDING



AFTER FOLDING

MEASURING TAPE



B WIRE MUST BE STRAIGHT

1. No peel-off tape
2. No flip-out tape
3. No loose tape
4. No wrong dimension
5. No wrong use of tape
6. Wires must be folded carefully
7. No damaged/scratch wires
8. No terminal backing out if pulled-out full force.
9. No tangled wires

Important Reminder/Note/s:

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

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WORK INSTRUCTION

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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

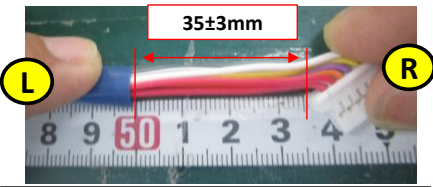
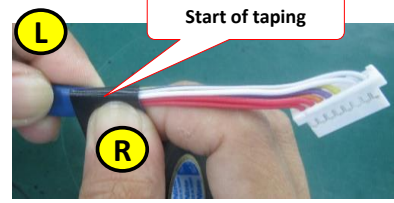
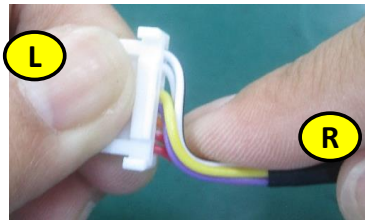
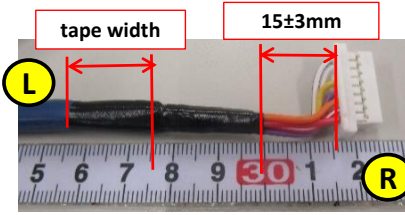
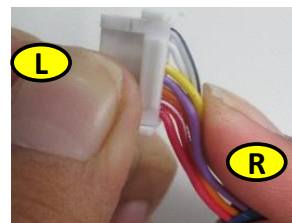
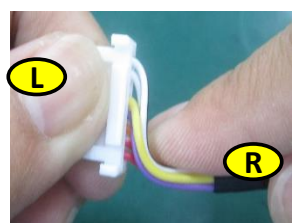


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PARTS:		1. Black tape 2. Assy parts	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 2 Blue VM tube (Sunprene) to wire near connector PBVP-08V-S (W)	<div><p>1. Hold the VM tube (Sunprene) using left hand and measure from end of sunprene tube up to edge of connector 35±3mm.</p></div> <div><p>2. Hold the VM tube (Sunprene) using left hand and start taping process using right hand.</p></div> <div><p>3. Hold the connector and slowly fold the wires using right hand.</p></div> <div><p>4. After folding, check the measurement and taping condition.</p></div> <div><p>BEFORE FOLDING</p></div> <div><p>AFTER FOLDING</p></div>	<div><p>MEASURING TAPE</p></div>	<div><p>RED WIRES MUST BE STRAIGHT</p></div> <div><p>1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. Wires must be folded carefully 7. No damaged/scratch wires 8. No terminal backing out if pulled-out full force. 9. No tangled wires</p><p>Important Reminder/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p></div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **435B / 75N731-0101**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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n/a

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

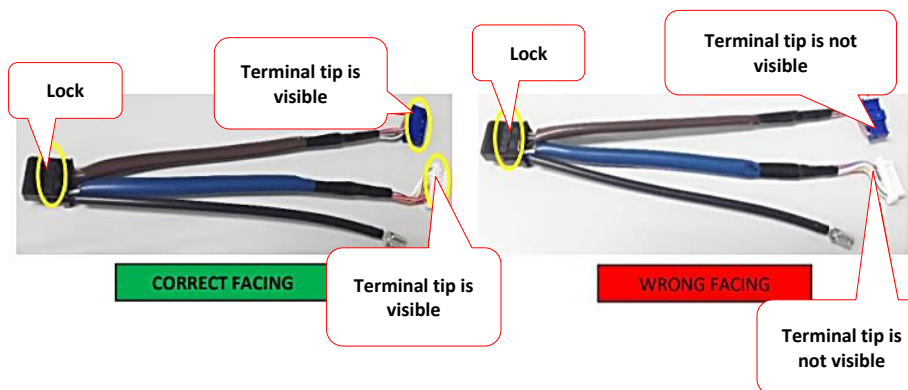
TOOLS/PPE

QUALITY POINTERS

4

P2

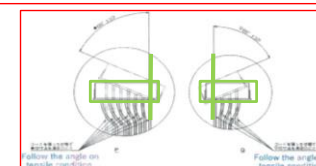
Wire Facing Arrangement



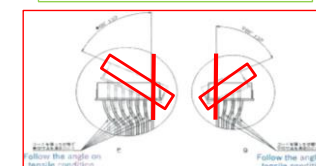
n/a

1. No wrong facing
2. No tangled wires

NOTE: CONNECTOR AND WIRE MUST BE IN LINE AS SHOWN IN THE DRAWING



GOOD Connector Orientation



NG Connector Orientation

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

P2

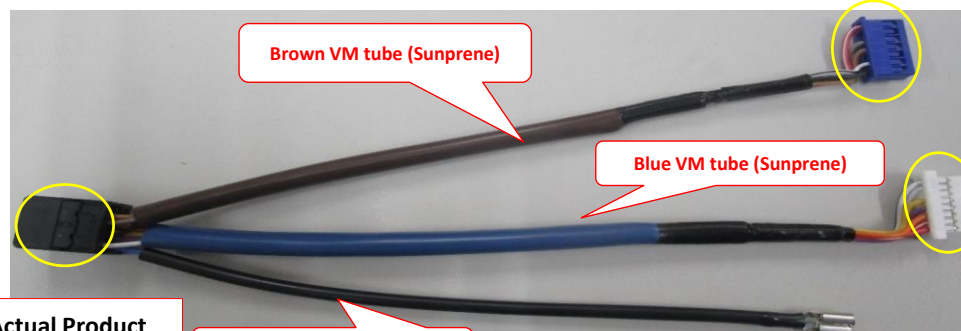
Visual/By two's inspection

1. Check the connector lock, locking of connector is included in Steering electrical test.

2. Check the wire alignment. Make sure no tangled wires.

3. Check the terminal if with backing out (not fully inserted) or deformed terminal.

4. Check the orientation of harness.



Actual Product

Master Sample

5. Compare to Master Sample by tapping.



Assembly product

Document References:

1. Refer to WI-ENG-PDE-431 for Steering Electrical Test after assembly.

MASTER SAMPLE



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PARTS:

N/A

JIG:

N/A

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

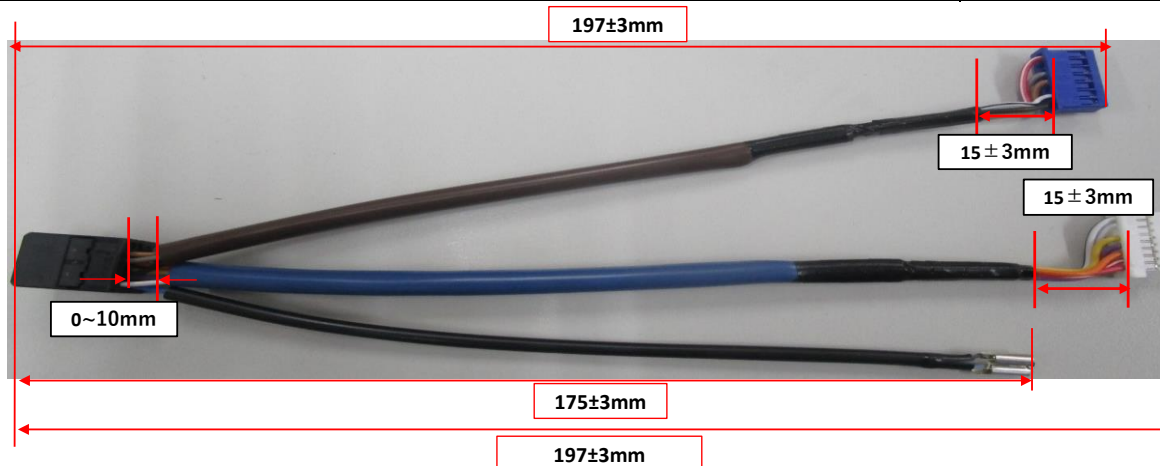
TOOLS/PPE

QUALITY POINTERS

6

P2

Measurement



MEASURING TAPE



1. No wrong dimension

Important Reminder/Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono and Owarimono

0-5mm



GOOD



NG

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PARTS:

N/A

JIG:

N/A



QUALITY CHECKPOINTS

75N731-0101

1. Check the connector lock, should be unlock.

2. Check the wire alignment. Make sure no tangled wires.

Brown VM Tube (Sunprene)

Blue VM Tube (Sunprene)

Black VM Tube (Sunprene)

3. Check the orientation of harness.

4. Check if no missing parts.

5. Check the terminal if with backing out (no fully inserted) or deformed terminal

6. Compare to master sample.

FOLDED WIRES MUST BE IN BACK POSITION

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