



WORK INSTRUCTION

Effectivity Date:

June 07, 2021

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Product Name/Code: 101D / 7N0096-7020

Customer:

TRJ

Document No.:

WI-ENG-PDE-238B

Purpose:

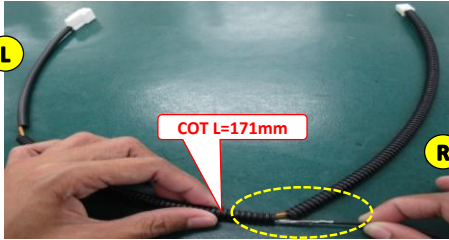
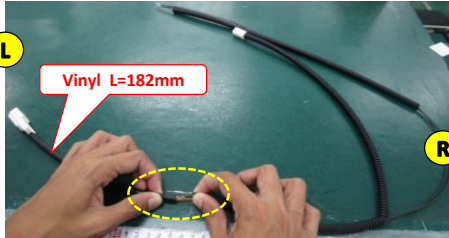

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2	<div>   <p>1. Hold the corrugated tube (no slit) $\phi 5 L=171\pm 3mm$ using left hand then insert the B/B wires using right hand.</p> <p>2. Continue to insert the assy parts, hold the vinyl tube $\phi 5 L=182\pm 3mm$ using left hand then insert the B/B wires using right hand.</p> </div>		<div> <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>  </div>	1. No wrong use of parts 2. No deformed terminal

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/07/21	1	Removal of validity date. Apply additional note in connector insertion process.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
03/06/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
							Est. Date:	March 06, 2021		

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PARTS:

1. Assy parts

JIG

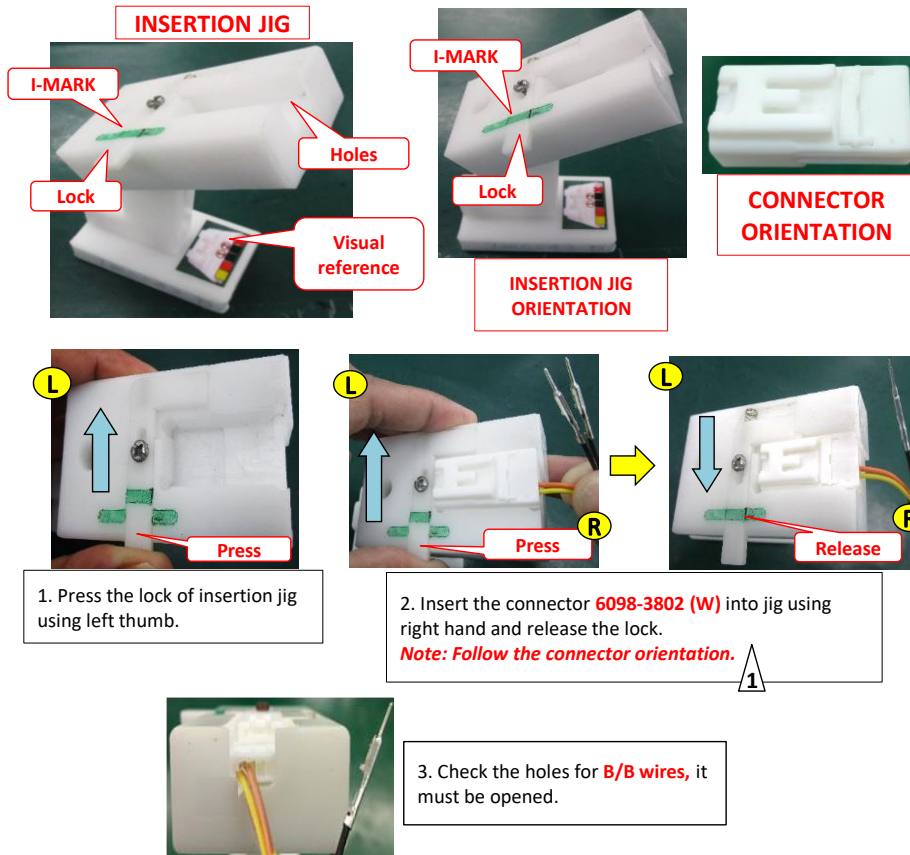
1. Insertion jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

2

P2

Connector setting to
insertion jig
6098-3802 (W)
(Assy parts)



n/a

**Connector Orientation
Illustration**

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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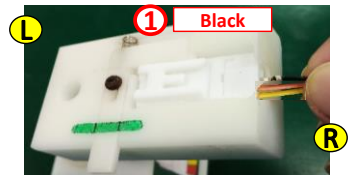
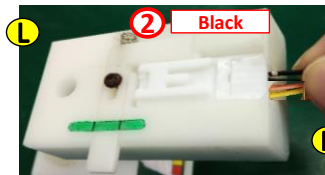
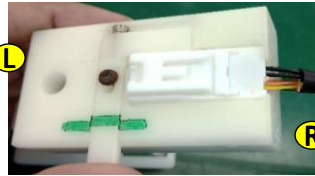
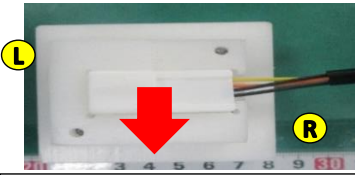

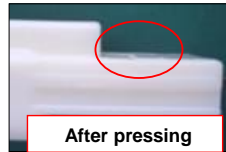
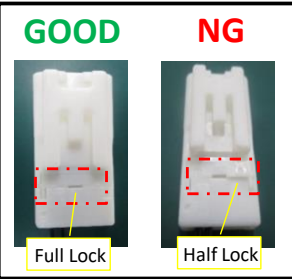
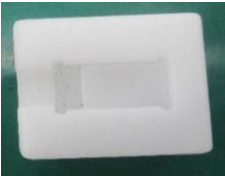
☒ MASSPRO

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PARTS:		1. Assy parts		JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	<div><p>Wire facing</p></div> <div><p>1. Get the assy part and hold the B wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Hold the B wire then insert to terminal slot 2 using right hand.</p></div> <div><p>3. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>		n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Note: Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.
4		<div><p>1. Put the connector into locking jig using right hand then press 2x to lock. Touch the connector lock to confirm if properly locked. Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</p></div> <div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><p>GOOD NG Full Lock Half Lock</p></div>		LOCKING JIG 	NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK. 1. Use the provided locking jig per model 2. No unlock/half-lock connector

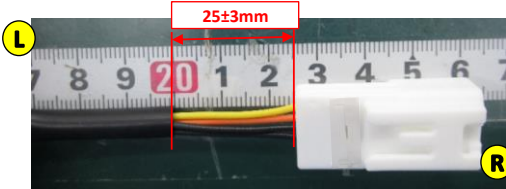
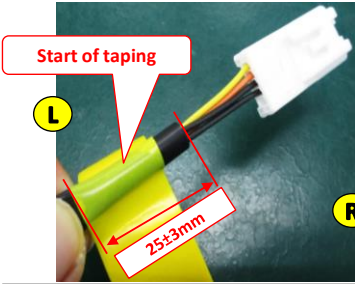
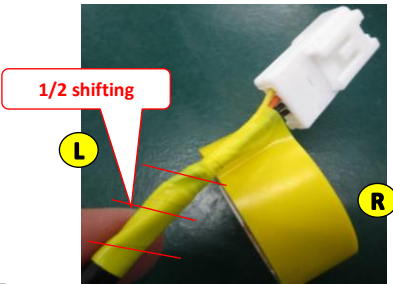
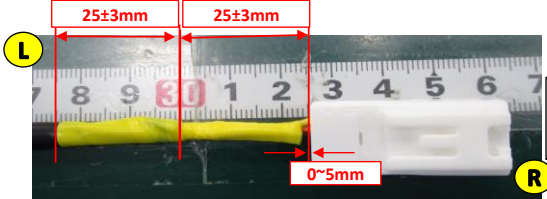

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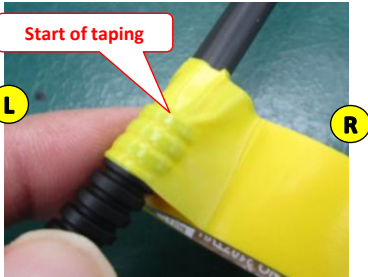

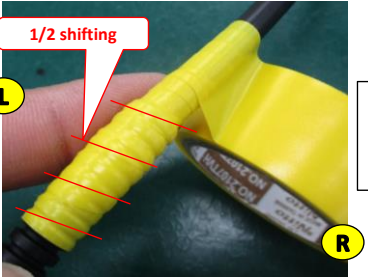
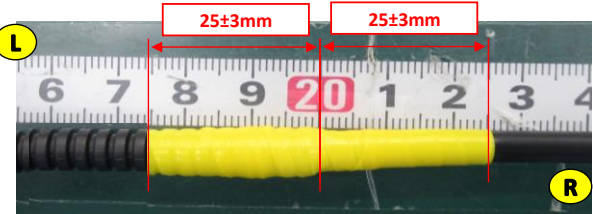

PARTS:	1. Assy parts 2. Black tape			JIG	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2 Taping 1 Black vinyl tube to wire near connector	 <p>1. Measure from end of vinyl tube up to connector 25mm using both hands.</p>  <p>2. Get the Black tape using right hand then attach at 25mm in measure of vinyl tube, make 2 windings of tape at vinyl tube using both hands.</p>  <p>3. Make 1/2 shifting using both hands going to wire side then make 3 windings of tape then cut the tape.</p>  <p>4. After taping, check the taping condition and measurement.</p>		<p>NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</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: Please use calibrated/verified measuring tape when getting the measurement.</p>

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PARTS:	1. Assy parts 2. Black tape				JIG	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2 Taping 2 Black Corrugated tube to Black vinyl tube near connector	<div>  <p>Start of taping</p> </div> <div>  <p>1/3 shifting</p> </div> <div>  <p>1/2 shifting</p> </div> <div>  <p>25±3mm 25±3mm</p> </div> <div> <p>1. Get the Black tape using right hand then make 2 windings of tape at the middle of COT and vinyl using both hands.</p> <p>2. Make 1/3 shifting using both hands going to the side of COT until it reach 25mm then make 2 windings of tape before shifting to other side.</p> <p>3. Make 1/2 shifting using both hands going to other side of vinyl tube then make 3 windings of tape and cut the tape.</p> <p>4. After taping, check the taping condition and measurement.</p> </div>	<div>  <p>MEASURING TAPE</p> </div>	<div> <p>NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</p> </div> <div> <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> </div> <div> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> </div>

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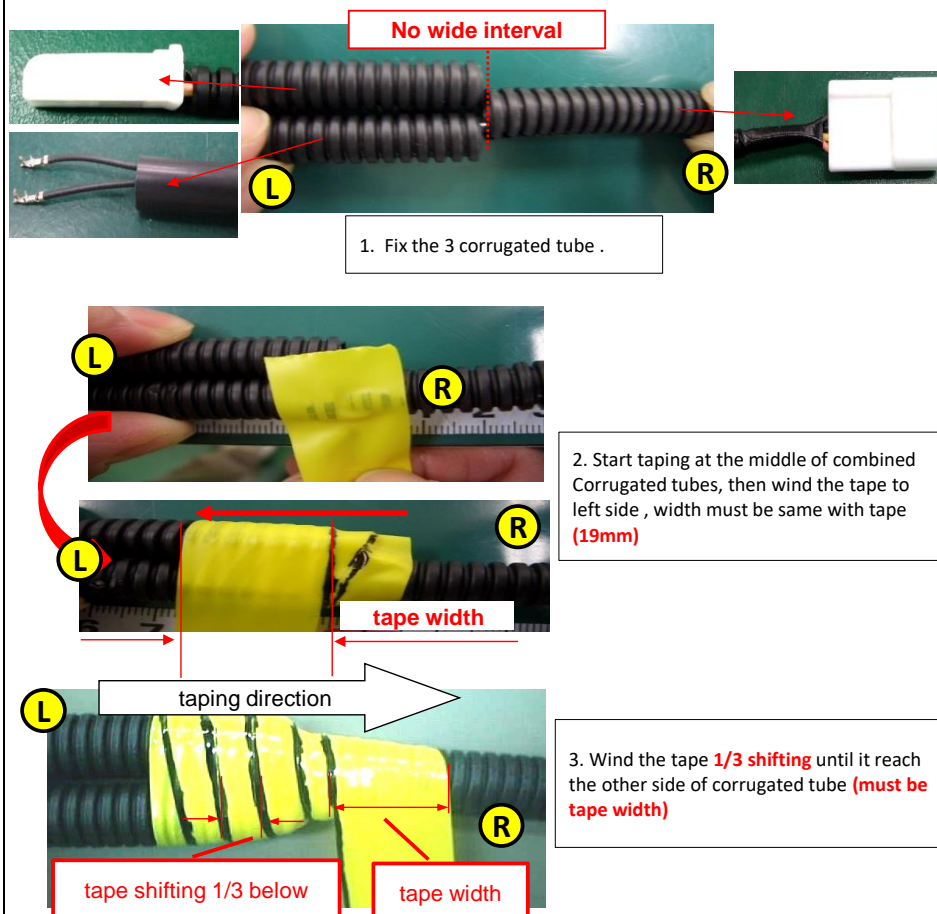
PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P2	Y-Taping	n/a	<div>NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</div> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension



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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

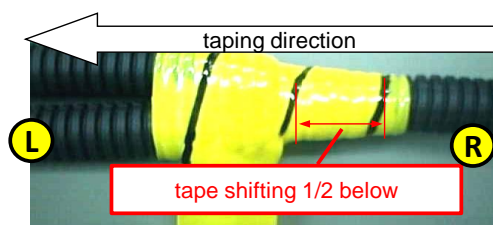
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QUALITY POINTERS

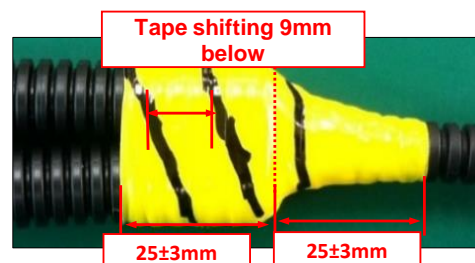
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P2

Y-Taping
(Continuation)

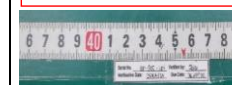


4. Wind the tape backward **1/2 shifting**



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.

MEASURING TAPE



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

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:
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