



WORK INSTRUCTION

Process Name/Title:

Taping Assembly Process

Effectivity Date:

September 30, 2022

Model Code/ Part Number: **TM3 / 7L0113-7020**

Customer:

TRQSS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

WI-ENG-PDE-320B

Revision No.:

2

Page No.:

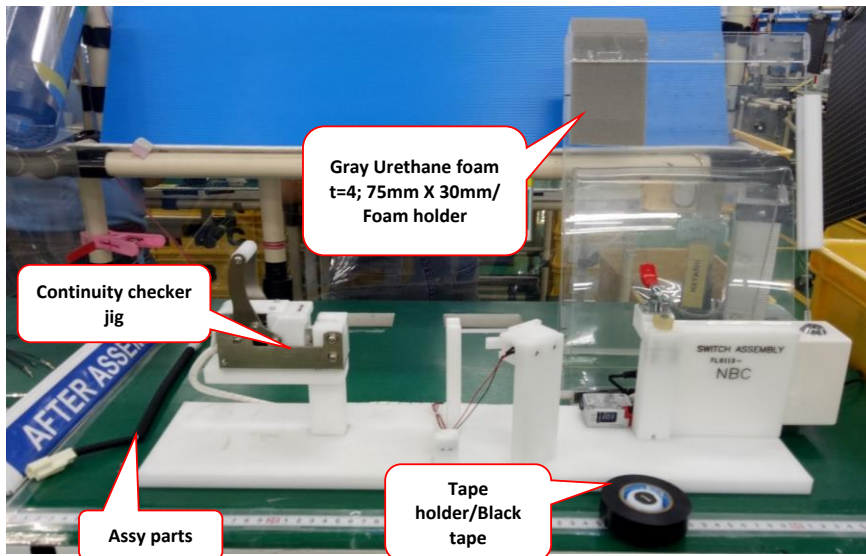
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PARTS:

1. Assy parts; Black tape; Gray Urethane foam t=4; 75mm X 30mm)

JIG:

1. Continuity checker jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table lay-out 	<p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
09/30/22	2	Change of tolerance from 35+/-3mm to 35 (+3/-1mm) as countermeasure of Encountered NG dimension from end of tape up to terminal. Improve work procedure/Illustration on process no. 5 (Visual/by two's inspection) and process no. 6(Measurement); Quality pointers and notes on page no. 2, 3, 5, 6 and 7	M. Ariola	J. Loterte	C. Villanueva	A. Arañes		M. Ariola	J. Loterte	C. Villanueva	A. Arañes
08/26/21	1	Change from Pre-launch to Masspro.	D.Castillo	C.Villanueva	A.Shimamura	A. Arañes		M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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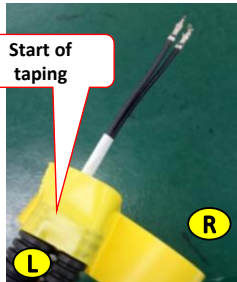
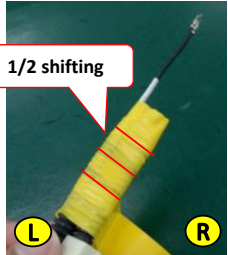
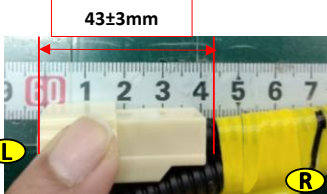
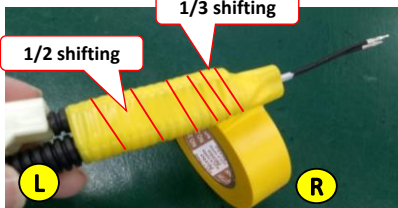
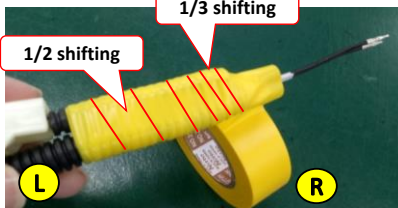


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PARTS:		n/a		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Y-Taping			
		<div><div><div>1. Fix the two (2) COT.</div><div></div><div></div></div><div><div>2. Get the Black tape using right hand then make 2 winds pre-taping before shifting.</div><div></div></div><div><div><div>1/2 shifting</div><div></div></div><div><div>43±3mm</div><div></div></div></div><div><div><div>1/3 shifting</div><div></div></div><div><div>1/2 shifting</div><div></div></div></div><div><div>3. Make 1/2 shifting going left side then measure from connector up to tape 43±3mm then make 2 winds before shifting using both hands.</div><div><div></div><div><div>35+3mm-1mm</div></div></div></div><div><div>4. Make 1/2 shifting going right side and another 1/3 shifting until it reach the 35(+3/-1mm) measurement from end of tape up to terminal pointed tip.</div></div><div><div>5. After taping, check the measurement, taping condition and terminal appearance.</div></div></div>		<div>MEASURING TAPE</div> <div></div>	<div>1. No peel-off tape</div> <div>2. No flip-out tape</div> <div>3. No wide interval between the 2 COT</div> <div>4. No exposed wire</div> <div>5. No wrong dimension</div> <div><div>2</div><div>Important reminder/Note/s:</div><div>1. Used YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</div><div>2. Please use calibrated/verified measuring tape when getting the measurement.</div></div>

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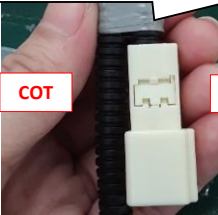


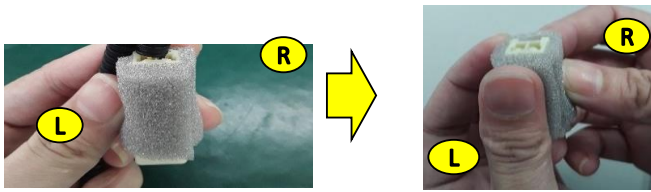
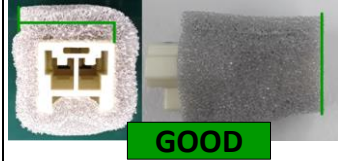
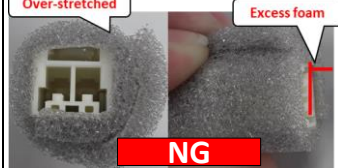
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PARTS:		1. Gray Urethane foam t=4; 75mm X 30mm 2. Assy parts		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Urethane foam manual attachment to connector	<p>Step 1: Identify the right facing to attached the foam</p>  <p>Step 2: Get the Urethane foam and begin the attachment. Note: Foam and connector must be align</p>  <p>Step 3: Attached the foam in all sides of the connector. Note: Follow the attachment sequence based on the illustration</p>  <p>Step 4: Press the Urethane foam side by side after attachment.</p> 		n/a	  Important reminder/Note/s: 1. Tolerance from Urethane foam to connector must be 0~3mm. 2. Do not Stretch the Urethane foam.

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PARTS:

1. Assy parts

JIG

1. Continuity checker jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

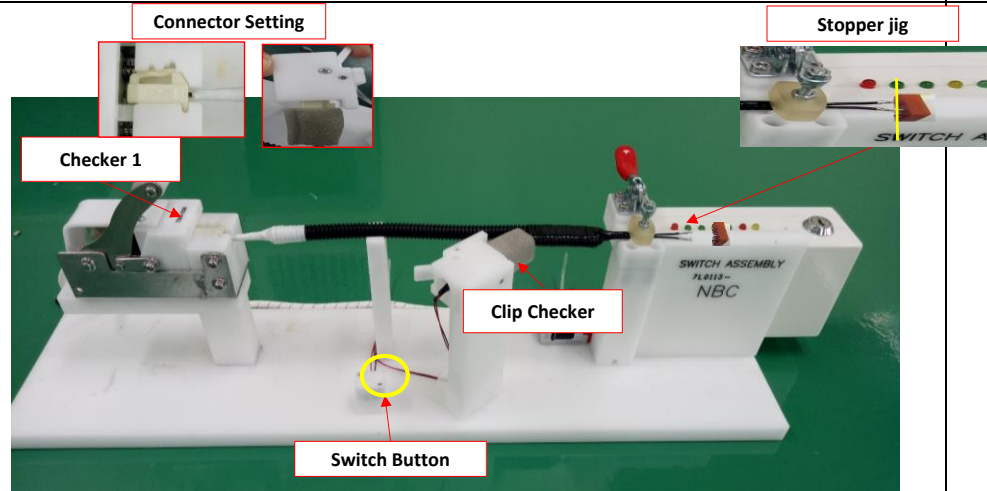
TOOLS/PPE

QUALITY POINTERS

4

P2

Continuity test

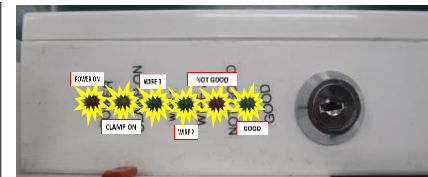


n/a

1. No wrong insert
2. Make sure no gap between terminal and stopper jig

1. Get the assy parts and set to clamp assembly jig using both hands. **(See above picture for correct setting)**. First set the connector **7283-1030 (W)** to **Receiver base** then pull the checker fixture for continuity checking. Second, set the connector **7282-1028 (W)** to **Clip checker** then lock. Last, set the **B-B wires** to together within the stopper jig then press by toggle clamp.

2. Check if all **LED** light for **Power ON, Wire1 & Wire2** was **ON**. If encounter abnormality or hearing **NG** buzzer, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process.



3. Press the switch button using right hand. **GO** buzzer will be heard

4. Conduct **POINT CHECKING** before removing the harness from jig.

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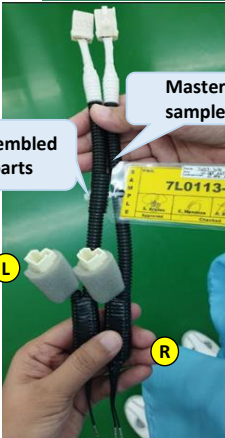
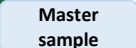
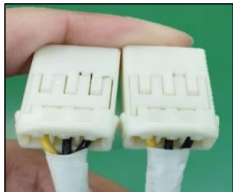



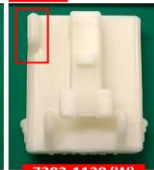

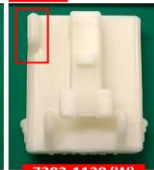
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PARTS:		1. Assembled parts 2. Master sample		JIG	n/a
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Visual/By Two's Inspection	<div><p>ACTUAL PRODUCTS</p></div>		<div>MASTER SAMPLE</div> 
			<div><div><p>Assembled parts</p></div><div><p>Master sample</p></div><div></div><div></div><div></div><div>1. Conduct alignment of harness (Master sample vs. Assembled parts) using both hands.</div><div>2. Check the connector lock, terminal and Insertion.</div><div>3. Check the taping condition.</div></div> <td></td> <td><div>1. No skip checking during inspection</div><div>2 CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div>7283-1030 (W)</div></div><div><div>NG</div><div>7283-1138 (W)</div></div></div></td>		<div>1. No skip checking during inspection</div> <div>2 CONNECTOR ILLUSTRATION</div> <div><div><div>GOOD</div><div>7283-1030 (W)</div></div><div><div>NG</div><div>7283-1138 (W)</div></div></div>

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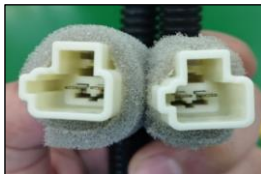

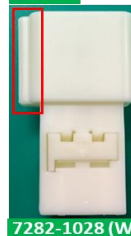
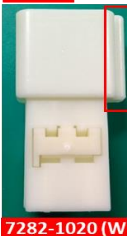
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PARTS:		1. Assembled parts 2. Master sample			JIG	n/a
NO.	PROCESS NAME		2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Visual/By Two's Inspection (Continuation)	<div><div>ACTUAL PRODUCTS</div></div>			<div>MASTER SAMPLE</div> <div></div>
			<div><div></div><div>3. Check the terminal, insertion and presence of Urethane foam attachment.</div></div> <div><div></div><div>4. Check the Y-Taping condition and terminal appearance. Must be no deformed terminal.</div></div>		<div>2</div> <div>1. No skip checking during inspection</div> <div>2</div> <div>CONNECTOR ILLUSTRATION</div> <div><div><div>GOOD</div><div></div><div>7282-1028 (W)</div></div><div><div>NG</div><div></div><div>7282-1020 (W)</div></div></div>	

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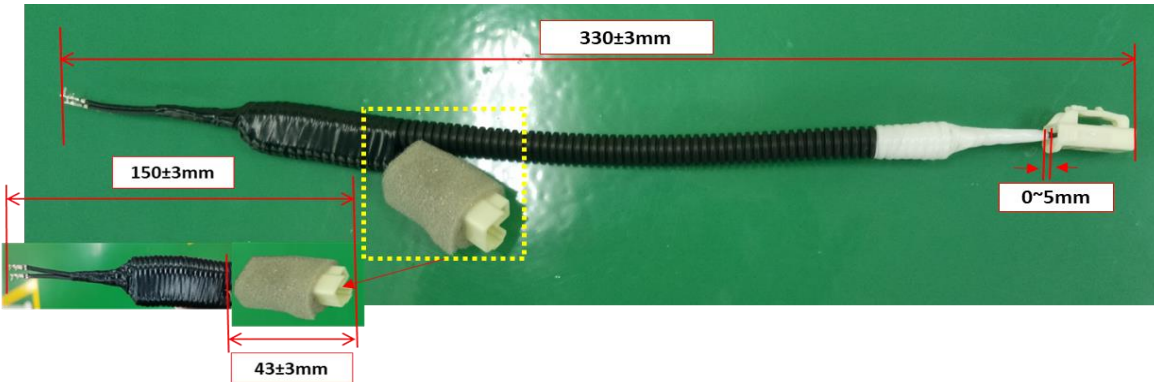
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PARTS:		n/a	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2	Measurement	<div>MEASURING TAPE</div>  	1.No wrong dimension Important reminders/Note/s: 1. Please use calibrated/ verified measuring tape when getting the measurement. 2. For Hatsumono and Owarimono.

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