

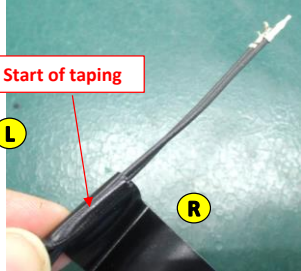
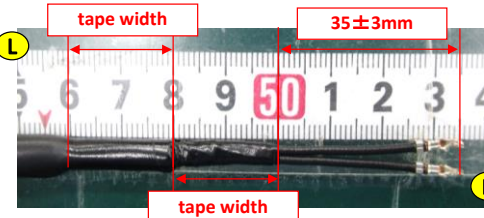
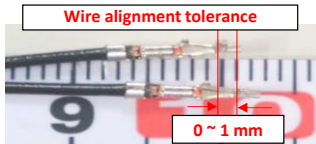
	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>		Effectivity Date:	May 20, 2021	
	Process Name/Title:		Validity Date:	n/a	
	Product Name/Code:	550B / 4 7L0081-7022	Customer:	TRQS	
	Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO	Document No.:	WI-ENG-PDE-018A	
			Revision No.:	4	Page No.: 1 of 2

<b>PARTS:</b> 4 1. Pre-assy parts from Kitting: Connector 6098-3802 (W); AVSSf 0.3 B wires L=652±3mm [2pcs.]; Black Corrugated tube(no slit)ø5 L=460±3mm 2. Black sunprene tube ø5 L=130±3mm		JIG:	1. Insertion jig							
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>						
1	Wire insertion to Black sunprene tube ø5 L=130±3mm	 <p>1. Get the Black sunprene tube ø5 L=130±3mm using right hand then insert the B/B wires using left hand.</p>	<b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)	1. No wrong use of parts 2. No deformed terminal						
2	P1 Taping 1 Black Sunprene tube to wire near terminal	 <p>1. Measure from end of the sunprene tube up to the terminal tip 55mm.</p>  <p>2. Hold the sunprene tube using left hand, get the Black tape then start taping using right hand. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>3. After taping, check the condition of tape, measurement and wire alignment.</p>	<b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.	<b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.						
		 <p>Wire alignment tolerance 0 ~ 1 mm</p>	<b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	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						
<b>MEASURING TAPE</b>										
<b>Revision History</b>										
05/20/21	4	Revise due to: Change part number from 7L0081-7021 to 7L0081-7022. Transfer insertion process from Production to Kitting (Refer to WI-ENG-PDE-254).	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	Prepared by	Reviewed by	Approved by	Noted by
05/01/21	3	Removal of validity date. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
06/10/19	0	Previously established as Engineering Instruction (EI-ENG-PDE-093). Initial issue	J. Loterte	C. Villanueva	A. Shimamura		M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	July 10, 2019		

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code:

550B

/ 4 7L0081-7022

Customer:

TRQSS

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 20, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-018A

Revision No.:

4

Page No.:

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### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

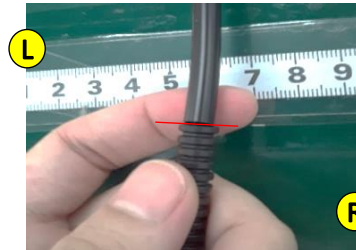
TOOLS/PPE

QUALITY POINTERS

3

P1

Taping 2  
Black Corrugated tube to  
Black Sunprene tube



1. Fix the corrugated tube and sunprene tube using both hands.

Start of taping



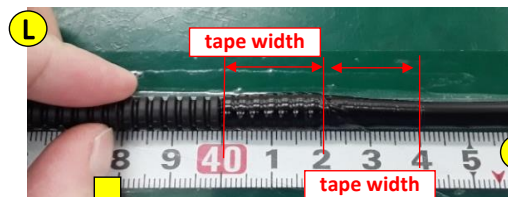
2. Hold the COT and sunprene tube using left hand, get the Black tape then start taping process using both hands.

**Note: Please refer to WI-PRO-ASY-001 for taping procedure.**

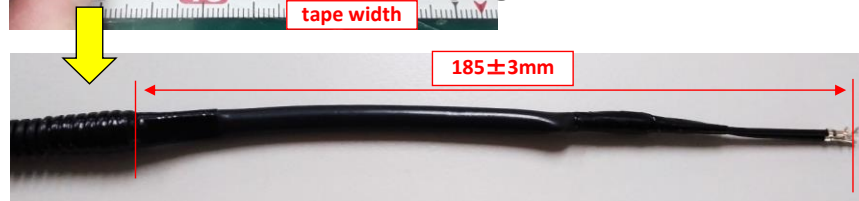
MEASURING TAPE



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



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



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