



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 20, 2021

Product Name/Code: 011B / 7M0364-7020B

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-129A

Revision No.:

3

Page No.:

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PARTS: 3 1. Connector 6189-0451 (W)

3

JIG:

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Connector setting to insertion jig 6189-0451 (W) 3	<p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 6189-0451 (W) into jig using right hand and release the lock.</p> <p>3. Push the guide using left hand. The slot for Gray wire will be opened.</p>	<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>Connector Orientation</p> <p>I-mark is align 1 hole is open GOOD</p> <p>I-mark is not align All holes are open NG</p> <p>1. Use the provided jig per model 2. No wrong orientation of connector</p>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by:	Checked by:	Approved by:	Noted by:
03/20/21	3	Change connector color in accordance with color standardization for plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts). Change from 2x pulling to Pull-Push-Pull-Push insertion quality pointers. Change taping method of Taping of COT to wire near terminal and Taping of COT to wire near connector process. Remove cycle time.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes				
06/17/20	2	Transferred process owner from Production to Engineering. Changed document control number from WI-PRO-ASY-018A to WI-ENG-PDE-130A. Additional cycle time.	M. Catapang	J. Loterte	A. Shimamura	A. Arañes				
08/03/19	1	Distribution of process/include locking jig	J. Silang	W. Carbillon	A. Shimamura	O. Merin				
							Established Date:	October 24, 2018		

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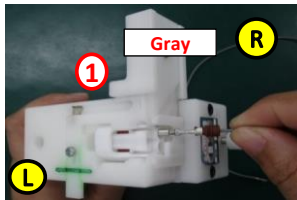
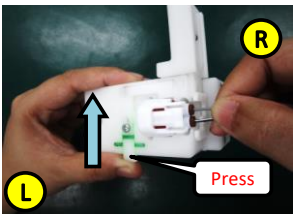
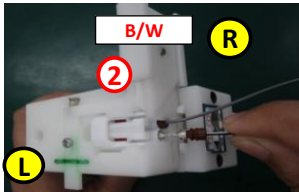
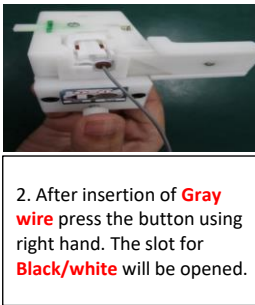

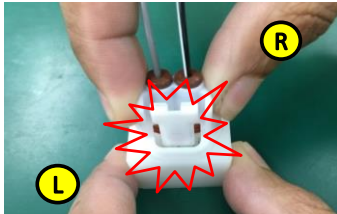



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PARTS:		1. TVSSf 0.3 Wires GR L=610mm ; B/W L=610mm			JIG	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Connector 6189-0451 (W) ³ P1	<div><div><p>1. Get the Gray wire then insert to terminal slot ① using right hand.</p></div><div><p>2. After insertion of Gray wire press the button using right hand. The slot for Black/white will be opened.</p></div><div><p>3. Get the Black/White wire then insert to terminal slot ② using right hand.</p></div><div><p>4. 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><div><p>Wire facing</p></div></div> <div>9N/A</div> <td>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.³ Do not exert extra force.</td>			1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. ³ Do not exert extra force.	
3	Connector Lock ³	<div><p>Put the connector into locking jig using right hand then press 2x to lock. Check the connector lock to confirm if properly pressed.</p></div> <div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><div>Locking jig</div></div> <div>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK.</div> <td>1. Use the provided locking per model 2. No half-locked/unlocked connector</td>			1. Use the provided locking per model 2. No half-locked/unlocked connector	

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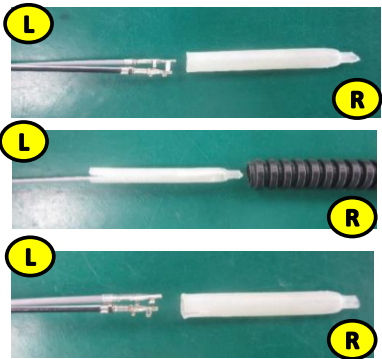


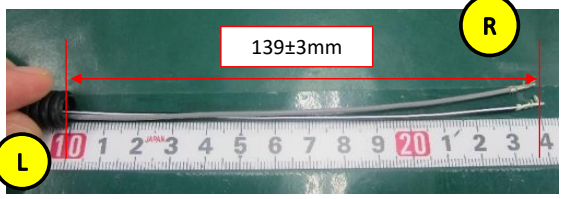
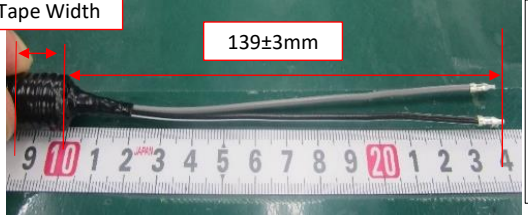

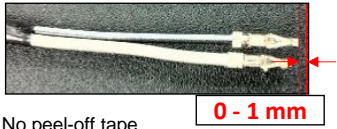
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PARTS:		JIG		1. Terminal cover jig	
1. Black Corrugated tube (No Slit) $\phi 5$, L=435 \pm 4mm 2. Black tape					
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	3 Wire insertion to corrugated tube $\phi 5$ L=435 \pm 4mm	 <p>1. Get the terminal cover jig using right hand then insert to wires.</p> <p>2. Get the corrugated tube $\phi 5$, L= 435\pm4mm using right hand and insert wires using left hand.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>		 <p>Terminal cover jig</p>	<p>1. No wrong use of parts 2. No deformed terminal</p>
5	P1 3 Taping 1 COT to wire near terminal	  <p>2. Measure the end of the corrugated tube up to the tip of terminal 139\pm3mm. Then continue taping using right hand. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p> <p>1. Get Black tape, hold corrugated tube using left hand then start pre-taping.</p> <p>Tape Width</p>  <p>3. After taping, check the dimension, taping condition and wire alignment.</p>		 <p>Measuring tape</p>	<p>Wire alignment tolerance</p>  <p>0 - 1 mm</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. Black tape
2. Assy parts

JIG

N/A

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

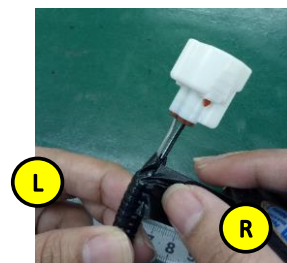
TOOLS/PPE

QUALITY POINTERS

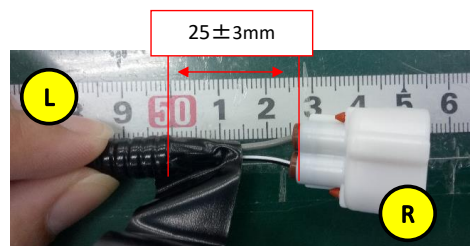
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P1

Taping 2
COT to wire near
connector

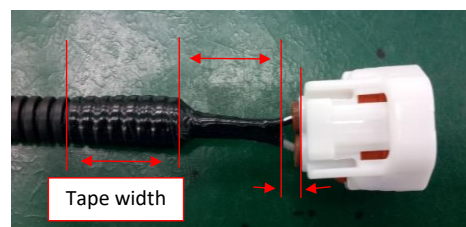


1. Get **Black tape**, hold corrugated tube using left hand then start pre-taping.



2. Measure the end of the corrugated tube up to the edge of connector **25mm**. Then continue taping using right hand.
Refer to WI-PRO-ASY-001 for taping procedure.

Measuring tape



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

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

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape
5. No wrong dimension
6. No missing tape

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