

**WORK INSTRUCTION**

Effectivity Date:

March 29, 2021

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity Date:

n/a

Product Name/Code:

**164B**

/

**7M0610-7020B**

Customer:

**TRJ**

Document No.:

WI-ENG-PDE-159B

Purpose:


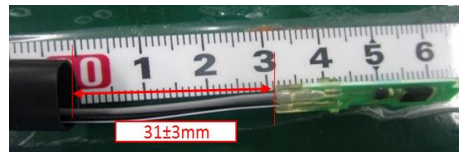
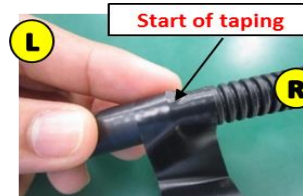


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:		1. Black Sunprene tube $\phi 11$ , L= 120 $\pm$ 3mm 2 Blak tape				<div>6</div> 3. Assy parts		<div>6</div> JIG:		n/a					
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS					
1		<div>6</div> Wire insertion to Sunprene tube $\phi 11$ , L= 120 $\pm$ 3mm		<div><div>L</div><div>R</div></div> <div>1. Get the Sunprene tube <math>\phi 11</math>, L= 120<math>\pm</math>3mm using right hand then insert the Hotmelted wire (GR/BW) using left hand.</div>				<div>Safety Instruction</div> <div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div>		1. No wrong use of parts					
2		P2 <div>6</div> Taping 1 Sunprene tube to COT		<div><div>L</div><div>Start of taping</div><div>31<math>\pm</math>3mm</div></div> <div>1. Measure the end of the sunprene up to the melted wire 31mm.</div> <div><div>L</div><div>R</div></div> <div>2. Hold the corrugated using left hand then start taping using right hand.</div> <div><div>Tape width</div><div>31<math>\pm</math>3m</div></div> <div>3. After taping, check the measurement and tape condition.</div>				<div>Housekeeping</div> <div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level</div> <div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div> <div></div> <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div>		1.No flip out tape. 2.No tape peeling. 3.No loose tape					
Revision History								Prepared by		Reviewed by		Approved by		Noted by	
03/29/21		6		Remove Cycle time; Put assy parts on Pg.1 and 4 parts section; Change connector color in accordance with color standardization for plastic parts refer to GL-COM-003				J. Loterte		C. Villanueva		A. Shimamura		A. Arañes	
09/15/20		5		Transferred process owner from Production (WI-PRO-ASY-88B) to Engineering (WI-ENG-PDE-159B); Apply some improvements; Added Cycle time				J. Loterte		R. Peñaloza		A. Shimamura		A. Arañes	
05/23/19		3		Change sequence of process				J. Silang		A. Morcozo/ W. Carballon		O. Merin		n/a	
Eff. Date		Rev. No		Details of Change				Revised		Checked		Approved		Noted	
												Est. Date:		September 9, 2018	

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☐ PRE-LAUNCH

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### PARTS:

1. Assy parts

### JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

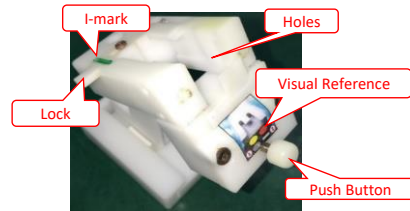
QUALITY POINTERS

3

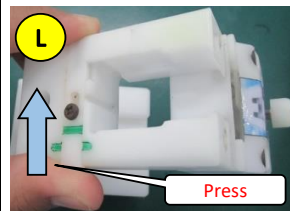
P2

6

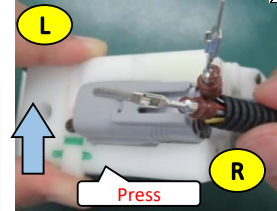
Connector setting to  
insertion jig  
6188-0066 (GR)



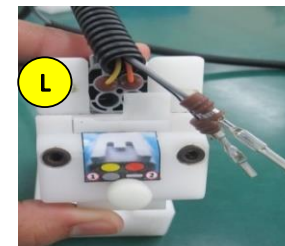
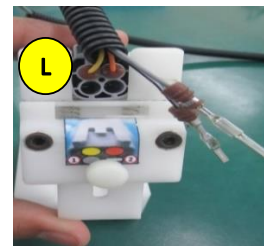
Connector Orientation



1. Press the lock of  
insertion jig using  
left thumb.

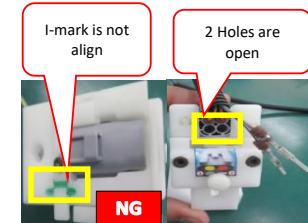
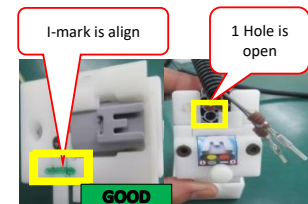


2. Insert the  
connector **6188-  
0066 (GR)** with  
inserted  
Yellow/Orange  
wire using right  
hand.



3. Press the wire guide of insertion jig using left thumb. The slot for **GR wire**  
will be open.

### Connector Orientation Illustration



1. Use the provided jig per model
2. No wrong facing of connector

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

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Product Name/Code:

**164B****/****7M0610-7020B**

Customer:

**TRJ**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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**PARTS:**

1. Assy parts

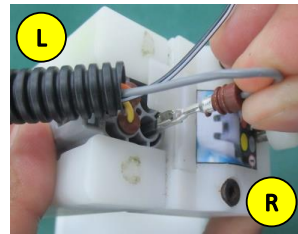
**JIG**

1. Insertion jig

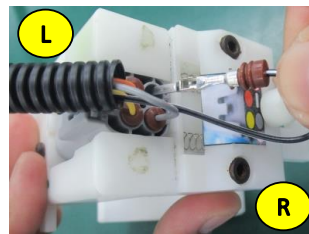
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

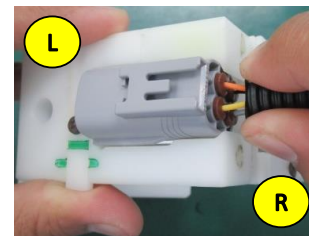
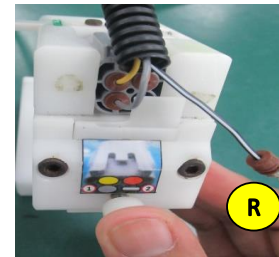
P2

Wire Insertion to  
connector  
6188-0066  
(GR)

1. Hold the **GR wire** then insert to terminal slot ① using right hand.



3. Hold the **B/W wire** then insert to terminal slot ② using right hand.



4. After insertion, push the lock button using left thumb and then hold the wires and gently pull out the connector from jig using right hand.

n/a

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.  
Do not exert extra force.

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PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

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PARTS:



1. Black tape
2. Assy parts

JIG

1. Locking jig

NO.

PROCESS NAME

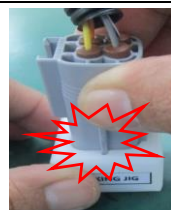
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

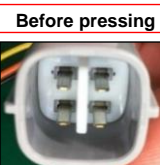
QUALITY POINTERS

5

Connector lock



1. Put the connector into locking jig using both hands and then press 2x. Check the connector if properly locked.



Before pressing

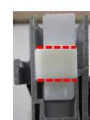
After pressing

### Coupler Cross Sectional View

NG

NG

GOOD



Unlock

Half Lock Condition



Full Lock Condition

LOCKING JIG



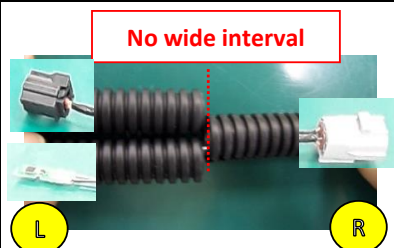
**NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK**

1. No unlock/half-locked connector

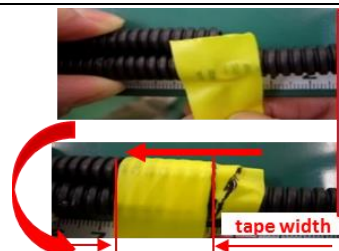
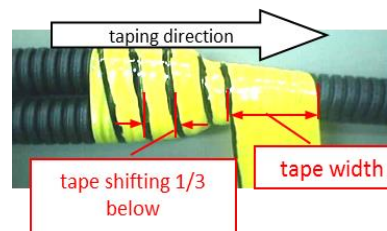
6

P2

Y-taping



1. Fix the corrugated tube .



2. Start taping at the middle of combined Corrugated tubes, then wind the tape going to 2 corrugated tubes , width must be same with tape (19mm)

3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)

n/a

**NOTE:**  
**USED YELLOW TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL SHOULD BE BLACK.**

- 1.No flip out tape.
- 2.No tape peeling.
- 3.No loose tape
4. No lacking of tape windings

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

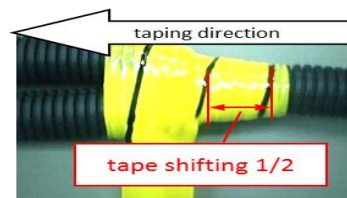
TOOLS/PPE

QUALITY POINTERS

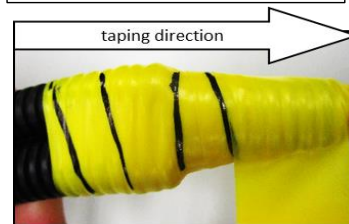
6

P2

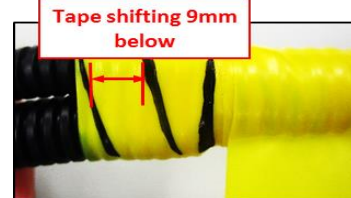
Y-taping  
(continuation)



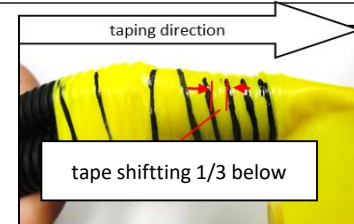
4. Wind the tape backward 1/2 shifting.



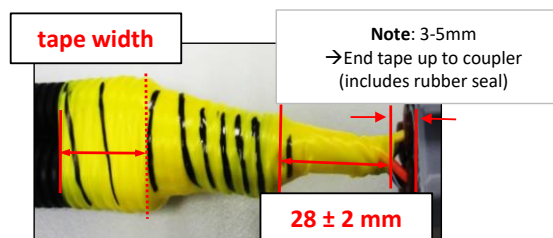
6. Make the half of tape outside the COT then wind it 2-3 times as Pre-Taping.



5. Wind the tape 1/2 shifting going to other side of corrugated tube.



7. Make 1/3 shifting until it reached the wire, make 3 windings to wire then cut.



n/a

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