

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

March 10, 2023Model Code/Part Number: **587B / 7M0532-7021**Customer: **TRJ**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-414A

Revision No.:

1

Page No.:

1 of 4

PARTS:

1. Assy parts; Black VM tube (Sunprene) Ø11 L=120±3mm; Black tape

JIG:

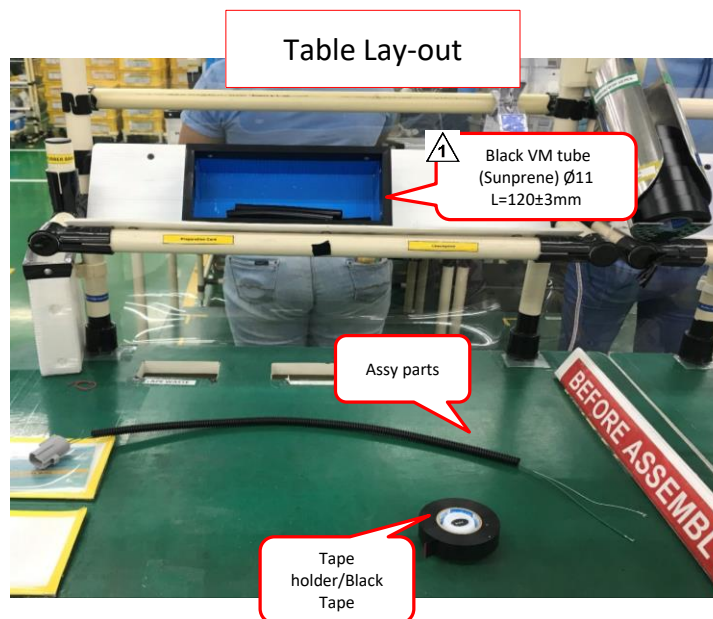
n/a

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

1

P1

Table Lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
03/10/23	1	Improve Quality pointers: Reminders and Notes on page no.1 and 2; Inclusion of Quality Checkpoints; Standardized VM tube description: VM tube (Sunprene)	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
02/22/22	0	Initial issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				

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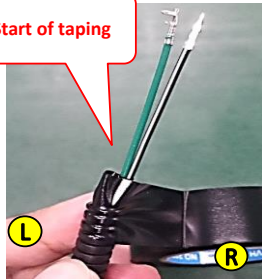
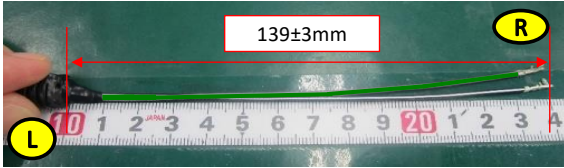
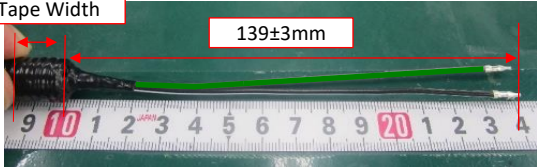

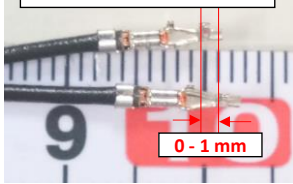
1

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2 of 4**PARTS:**

1. Assy parts
2. Black tape

JIG**n/a**

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Taping 1 Black corrugated tube to wire near terminal	<p>Start of taping</p>  <p>1. Hold the corrugated tube using left hand, get the Black tape then start taping using both hands.</p> <p>MEASURING TAPE</p>  <p>2. Measure from end of corrugated tube up to terminal pointed tip 139±3mm then continue the taping process. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p> <p>Tape Width</p>  <p>3. After taping, check the measurement, wire alignment and taping condition.</p>		<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong use of tape 5. No wrong dimension</p> <p>Wire alignment tolerance</p> 

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PARTS:

1

1. Assy parts
2. Black VM tube (Sunprene) Ø11 L=120±3mm

3. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	<div>1</div> <div>Wire insertion to Black VM tube (Sunprene) Ø11 L=120±3mm</div>	<div>L</div> <div><div>1</div><div>1. Get the VM tube (Sunprene) Ø11 L=120±3mm using right hand and then insert the B/W-G wires using left hand.</div></div> <div>R</div>	n/a	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal
4	<div>P1</div> <div>1</div> <div>Taping 2 Black corrugated tube to Black VM tube (Sunprene)</div>	<div>L</div> <div><div>39±3mm</div><div>1. Measure from end of VM tube (Sunprene) up to terminal pointed tip 39±3mm.</div></div> <div>R</div> <div><div>Start of taping</div><div>2. Hold the VM tube (Sunprene) using left hand, get the Black tape then start the taping process using both hands. Refer to WI-PRO-ASY-001 for taping procedure.</div></div> <div><div>1</div><div>3. After taping, check the measurement and taping condition.</div></div> <div><div>Tape width</div><div>39 ± 3mm</div></div>	<div>MEASURING TAPE</div> <div></div>	<ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension <div>Important reminders/Note/s:</div> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.

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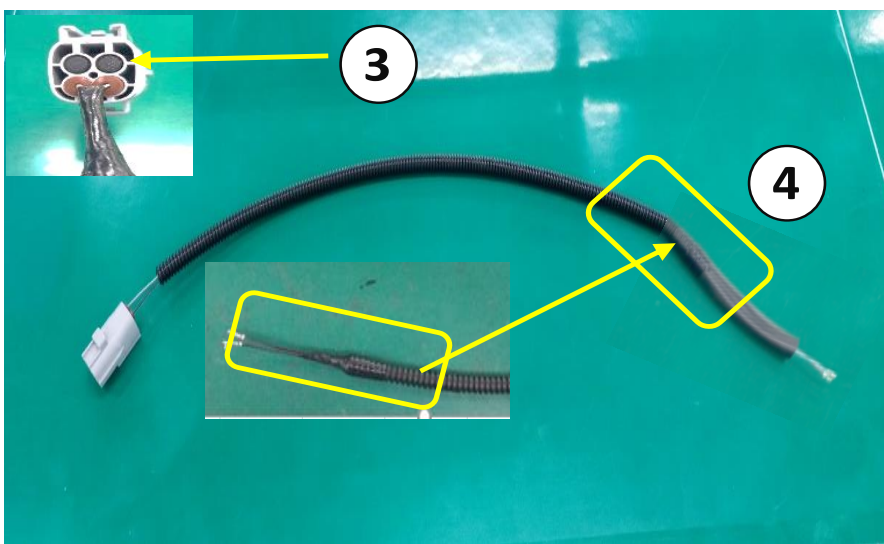
n/a

n/a

JIG

n/a

QUALITY CHECKPOINTS

P1**7M0532-7021****GOOD****GOOD****NO GOOD****NO GOOD****GOOD****GOOD****NO GOOD****NO GOOD****1 No Unlock/Halflock Connector****2 No Wrong Insert****3 No Missing Dummy Seal****4 No Missing Tape**
(taping on COT-wire and
taping on sunprene tube)**5 No Terminal Backing Out**

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