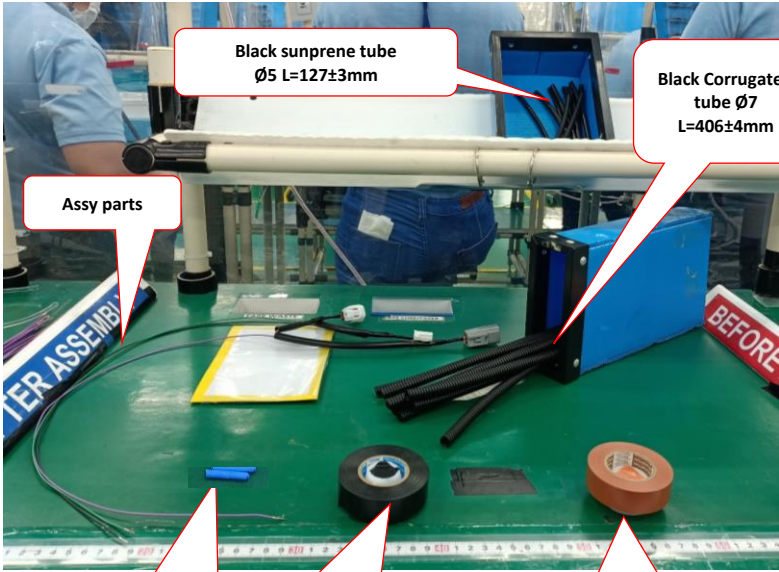
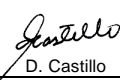



	WORK INSTRUCTION		Effectivity Date:	October 22, 2021	
	Process Name/Title: TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 910B / 7L0126-7022	Customer: TRQSS	Document No.:	WI-ENG-PDE-272B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:

PARTS:	1. All parts (Assy parts: Black corrugated tube Ø7 L=406±4mm (no slit); Black sunprene tube Ø5 L=127±3mm; Brown tape; Black tape)				JIG	1. Terminal cover jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS		
1	P2	<p style="text-align: center;">Table Lay-out</p> 				<p>Safety Instruction Be sure to wear required 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>1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools</p>		
Revision History									
10/22/21	1	Change part number due to design change. Change from pre-launch to masspro. Add table lay-out.				D.Castillo	J.Loterte	C.Villanueva	A. Arañes
09/17/21	0	Initial issue.				D.Castillo	J.Loterte	C.Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Prepared by	Reviewed by	Approved by	Noted by
									
						D. Castillo	J. Loterte	C. Villanueva	A. Arañes
						Est. Date:	September 17, 2021		

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TAPING ASSEMBLY PROCESS

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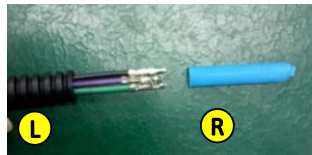

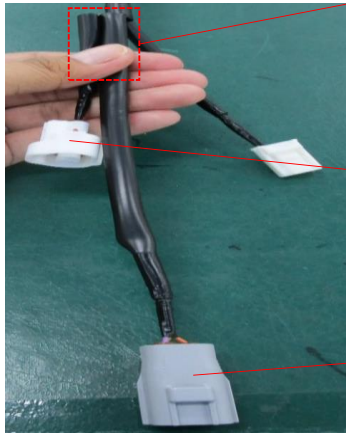
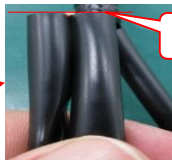


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape [1pc]			3. Black corrugated tube Ø7 L=406±4mm (no slit)		JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS
2		Wire insertion to Black corrugated tube Ø7 L=406±4mm (No slit)	<div><p>1. Combined the assy parts (G, V and B wire with vinyl tube), get the terminal cover jig using right hand and insert wires using left hand.</p></div>	<div><p>2. Get the Black corrugated tube (no slit) Ø7 L=406±4mm using right hand and insert the wires using left hand.</p></div>	<div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>	<div>Terminal Cover jig</div> 		1. No wrong usage of parts 2. No damaged rubber seal
3	P2	Y-Taping	<div><div>Y-taping orientation</div><div>must be aligned</div><div>1. Conduct harness facing using both hands. Combine the vinyl tube Ø7 L=56±3mm and Ø7 L=189±3mm using both hands.</div><div>Start of taping</div><div>2. Get the Black tape using right hand then start pre-taping process using both hands. <i>Note: Do not exert extra force.</i></div></div>			<div>MEASURING TAPE</div>  <div>NOTE: USED YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINE, BUT ACTUAL SHOULD BE BLACK.</div> <div>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 7. No wrong orientation of assy parts</div> <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div>		

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: **910B** / **7L0126-7022**

Customer:

TRQSS

Purpose:

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October 22, 2021

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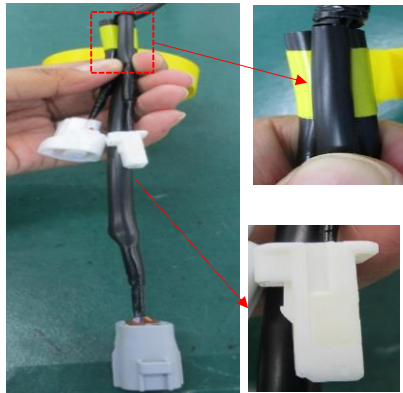
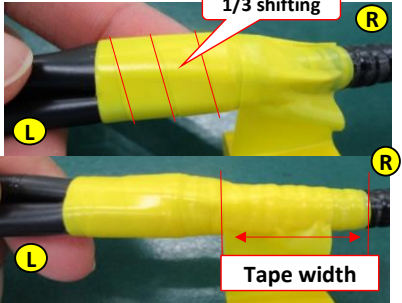
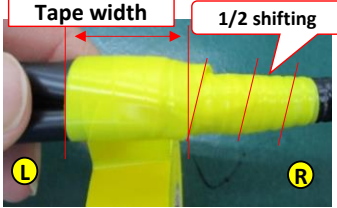
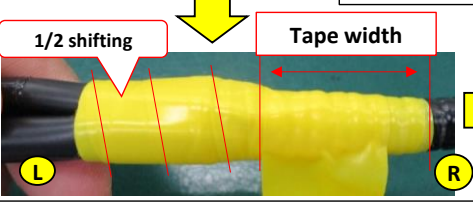
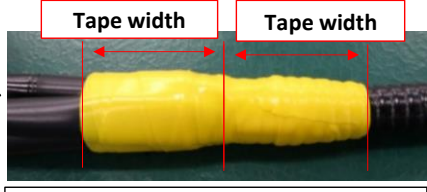

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PARTS:		1. Assy parts 2. Black tape [1pc]	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Y-Taping (Continuation)	<p>3. After pre-taping, combine the vinyl tube $\varnothing 7$ $L=94\pm 3\text{mm}$ to assy parts using both hands.</p>  <p>4. Make 2 windings of tape before shifting then wind 1/3 shifting going to COT using both hands. <i>Note: Do not exert extra force.</i></p>  <p>5. Make 1/2 shifting going to vinyl tube then make 2 windings of tape before final shifting.</p>  <p>6. Make 1/2 shifting going to COT then make 3 windings of tape then cut the tape.</p>  <p>7. After taping, check the measurement and taping condition.</p> 	<p>MEASURING TAPE</p> 	<p>NOTE: USED YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINE, BUT ACTUAL SHOULD BE BLACK.</p> <p>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 7. No wrong orientation of assy parts</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: 910B / 1 7L0126-7022

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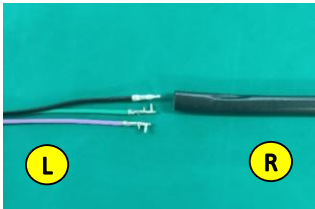
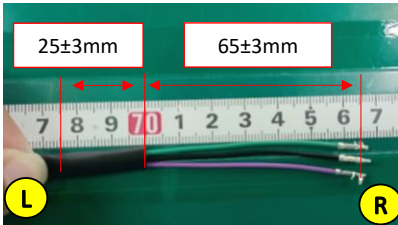
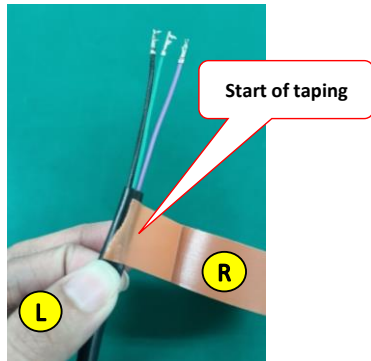

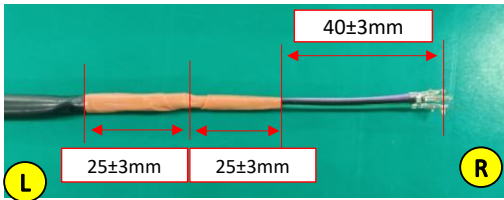
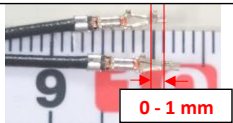
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PARTS:		1. Black sunprene tube $\Phi 5$ L=127 \pm 3mm 2. Brown tape [1pc]			3. Assy parts	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
3		Wire insertion to Black Sunprene tube $\Phi 5$ L=127 \pm 3mm		1. Get the Black Sunprene tube $\Phi 5$ L=127 \pm 3mm using right hand and insert the wires using left hand.	n/a	1. No wrong use of parts 2. No deformed terminal	
4	P1	Taping 4 Black Sunprene tube to wire near terminal	 1. Measure from end of sunprene tube up to terminal pointed tip 65 \pm 3mm using both hands.	 2. Get the Brown tape, using right hand then start taping process using both hands. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i>	 MEASURING TAPE	<i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement. 1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape	
				3. After taping, check the dimension, taping condition and wire alignment.		<i>Wire alignment tolerance</i> 	

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