



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

March 22, 2021

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Product Name/Code:

291B / 7L0034-7020

Customer:

TRQSS

Document No.:

WI-ENG-PDE-192B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

1 of 4

PARTS:

1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

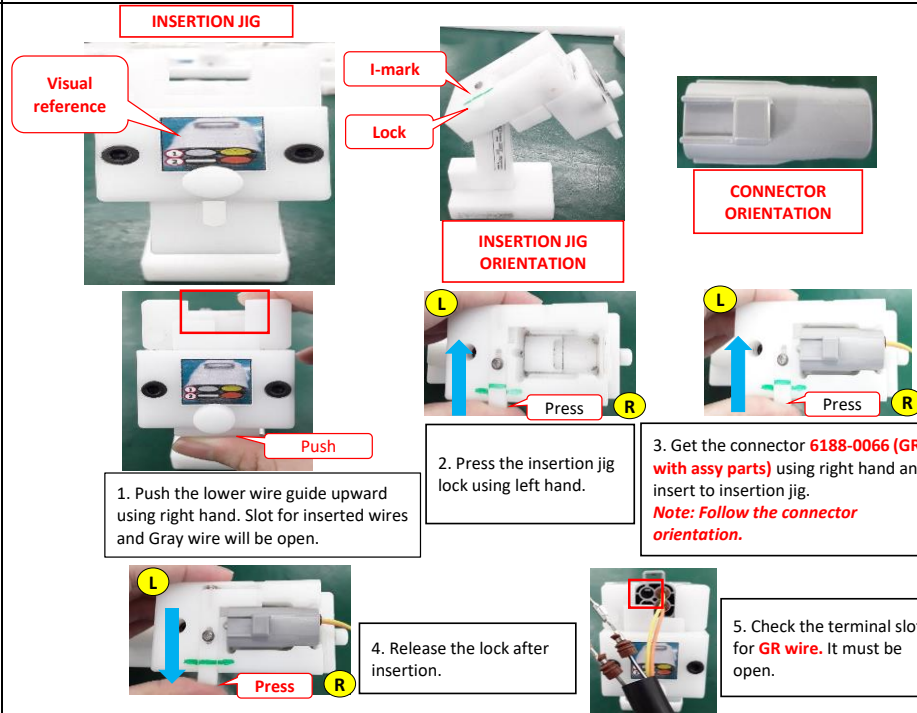
TOOLS/PPE

QUALITY POINTERS

1

P2

Connector setting to
insertion jig
6188-0066 (GR)
with assy parts

**Safety Instruction**

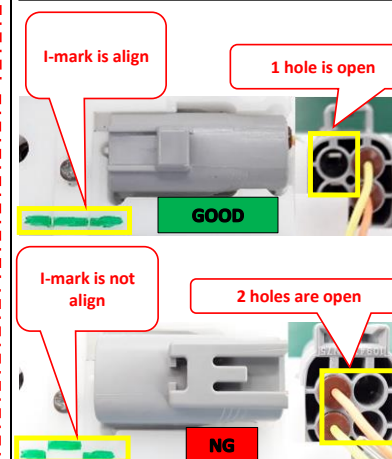
Be sure to wear
prescribed personal
protective equipment
during operation (gloves,
finger cots, etc.)

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.

CONNECTOR ORIENTATION ILLUSTRATION

1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

Revision History

Prepared by

Reviewed by

Approved by

Noted by

03/22/21

2

Change tape dimension from 10 +0 -10 to 7 +0 -7 due to encountered above maximum dimension after assembly. Apply some improvements.

M. Catapang

C. Villanueva

A. Shimamura

A. Arañes

11/12/20

1

Change process owner from Production (WI-PRO-ASY-046) to Engineering (WI-ENG-PDE-192B), Apply some improvements, include insertion jig, Update pictures.

J. Loterte

R. Peñaloza

A. Shimamura

A. Arañes

Eff. Date

Rev. No

Details of Change

Revised

Checked

Approved

Noted

Est. Date:

July 10, 2017

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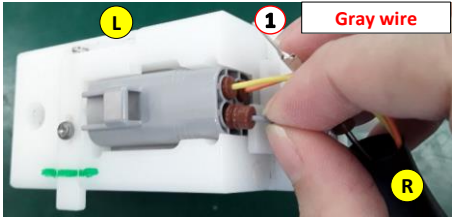
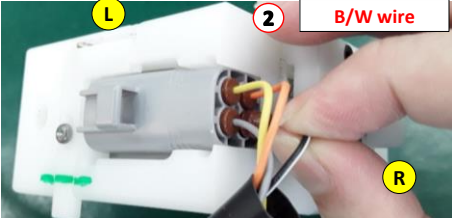
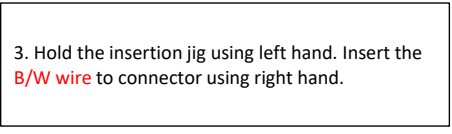
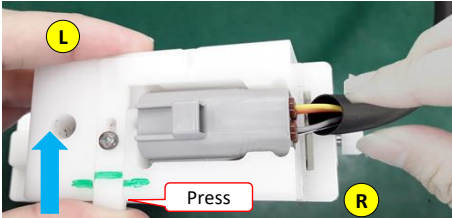
DCC Stamp



WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

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Revision No.:	2	Page No.:	2 of 4

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Product Name/Code:	291B / 7L0034-7020	Customer:	TRQSS
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	<p>Wire insertion to Connector 6188-0066 (GR) with assy parts</p> <div><p>WIRE FACING</p></div> <div><p>1. Hold the insertion jig using left hand. Insert the Gray wire to connector using right hand.</p></div> <div><p>2. Press the button using right thumb. Slot for B/W wire will be opened.</p></div> <div><p>3. Hold the insertion jig using left hand. Insert the B/W wire to connector using right hand.</p></div> <div><p>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.</p></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p>

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Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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Page No.:

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Locking jig

NO.

PROCESS NAME

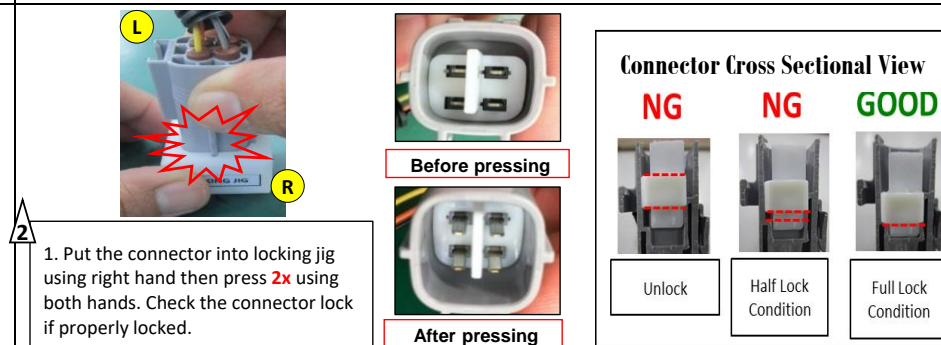
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

Connector lock



Locking jig



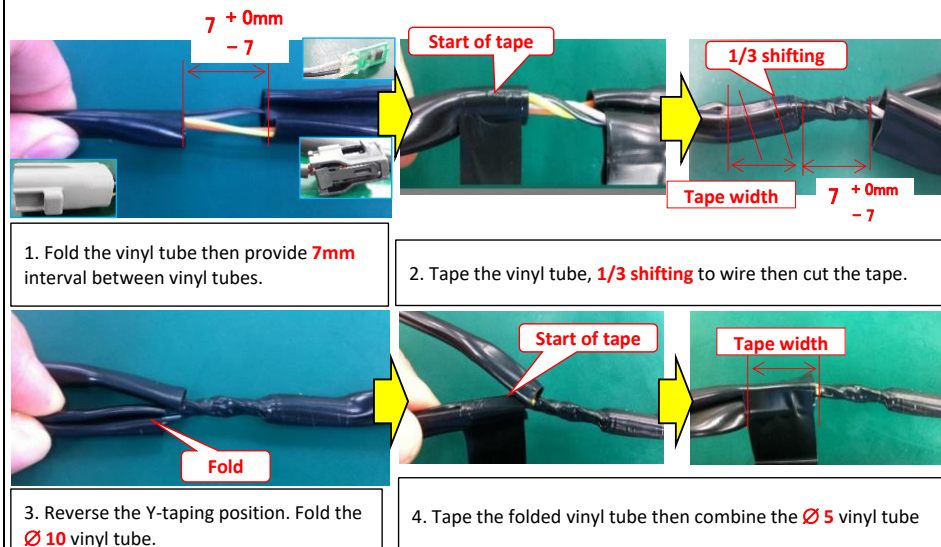
NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK

1. No unlock/half-locked connector
2. Use provided jig tool to lock the connector

4

P2

Y-taping



Measuring tape



Connector Orientation



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

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

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2. Black tape

JIG

n/a

NO.

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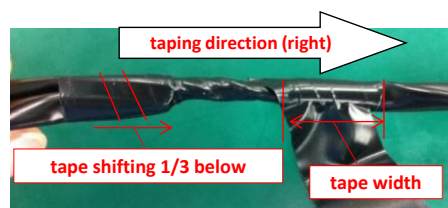
TOOLS/PPE

QUALITY POINTERS

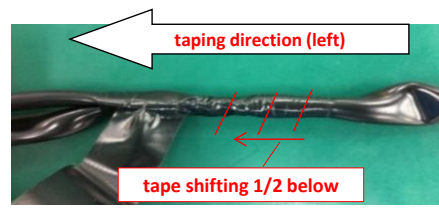
4

P2

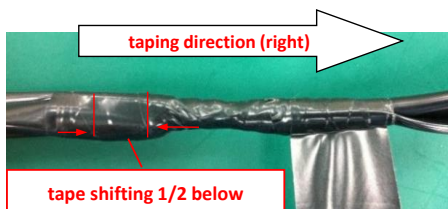
2
Y-taping
Continuation



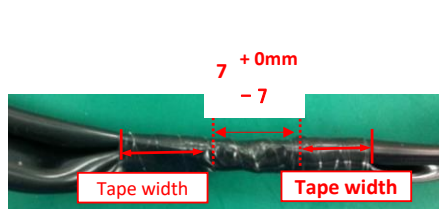
5. Wind the tape 1/3 shifting until it reach the other side of vinyl tube (must be tape width).



6. Wind the tape backward 1/2 shifting



7. Wind the tape 1/2 shifting going to other side of vinyl tube then cut the tape.



8. After taping, check the condition of tape.

Measuring tape



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Connector Orientation



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