
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:	October 22, 2024		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: J34A / 7L0107-7020D		Customer: TRQSS	Car Model: MAZDA CX	Document No.:	WI-ENG-PDE-235		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	1 of 5

PARTS:	1. Connector 7188-337510 (GR); AVSSf 0.3 B wire L=556mm [2 pcs]; Black SV tube(Vinyl) Ø5, t=0.5 L=459+4mm			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 5px; display: inline-block;">TABLE LAY-OUT</div>  </div>		<div style="border: 1px dashed red; padding: 5px;"> <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> </div>	<p>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
10/22/24	3	Inclusion of all improvements Table lay-out; important reminders and note/s; Document references; Visual inspection/Quality checkpoints; car model "MAZDA CX".	D.Castillo	C.Villanueva	A. Arañes	n/a	
06/18/21	2	Change part number from 7L0107-7020A to 7L0107-7020D due to change vinyl tube length from L=480mm to L=459mm. Change taping location from vinyl tube to wire near terminal to vinyl tube to wire near connector.	D.Castillo	C.Villanueva	A.Shimamura	A. Arañes	
04/30/21	1	Change from pre-launch to masspro. Add tape quantity.	D.Castillo	C.Villanueva	A.Shimamura	A. Arañes	
01/29/21	0	Initial issuance.	D.Castillo	R. Peñaloza	A.Shimamura	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: January 29, 2021

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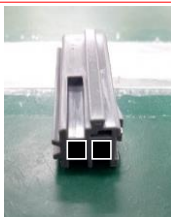

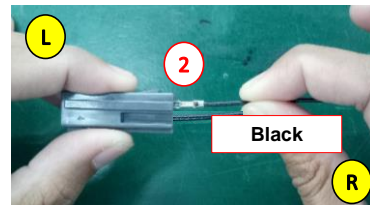

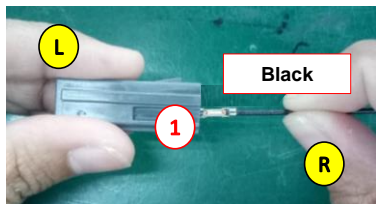
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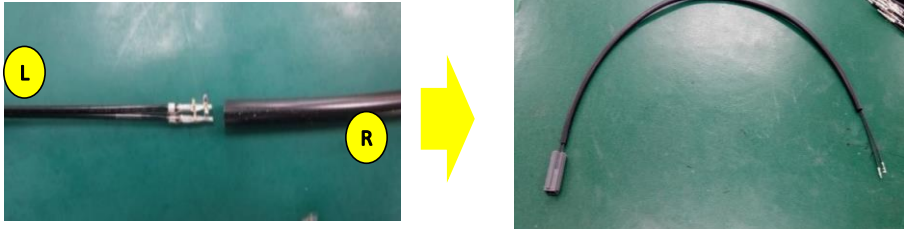
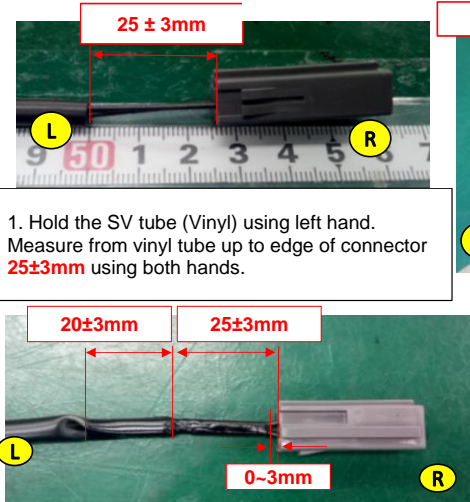
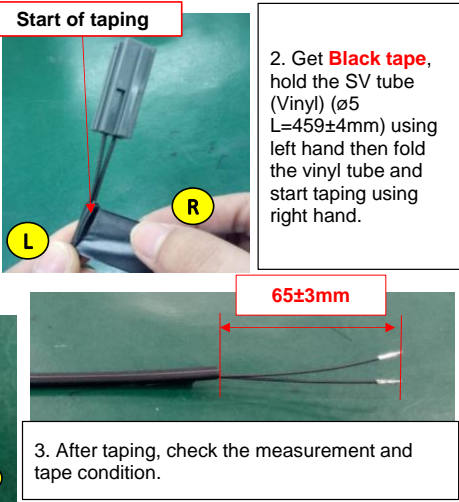

PARTS:		1. Connector 7188-337510 (GR) 2. AVSSf 0.3 B wire L=556mm [2 pcs]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Wire insertion to connector 7188-337510 (GR)	<div><div>Connector Orientation</div></div> <div><div>Connector Setting</div></div> <div><div>Wire facing</div></div> <div><div></div><div>1. Get the Connector 7188-337510 (GR) using left hand and get the 1st Black wire using right hand then insert to terminal slot ①.</div><div>2. Get 2nd Black wire then insert to terminal slot ② using right hand.</div></div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</div> <div>Important reminders/note/s: <i>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i> <i>2. This connector has NO DOUBLE LOCK, proper insertion method must be followed.</i> <i>3. Insertion should be from left to right.</i></div>

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PARTS:		1. Black SV tube (Vinyl) ø5 L= 459±4mm 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3		<div><p>1. Get the Black wires using left hand and insert to SV tube (Vinyl) ø5 L=459±4mm using right hand.</p></div>		n/a	1. No wrong use of parts 2. No deformed terminal
4	P1	<div><div><p>1. Hold the SV tube (Vinyl) using left hand. Measure from vinyl tube up to edge of connector 25±3mm using both hands.</p></div><div><p>2. Get Black tape, hold the SV tube (Vinyl) (ø5 L=459±4mm) using left hand then fold the vinyl tube and start taping using right hand.</p><p>3. After taping, check the measurement and tape condition.</p></div></div>		<div></div>	<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 dimension 5. No wrong use of tape 6. No missing tape</p> <p>Document references:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure</p>

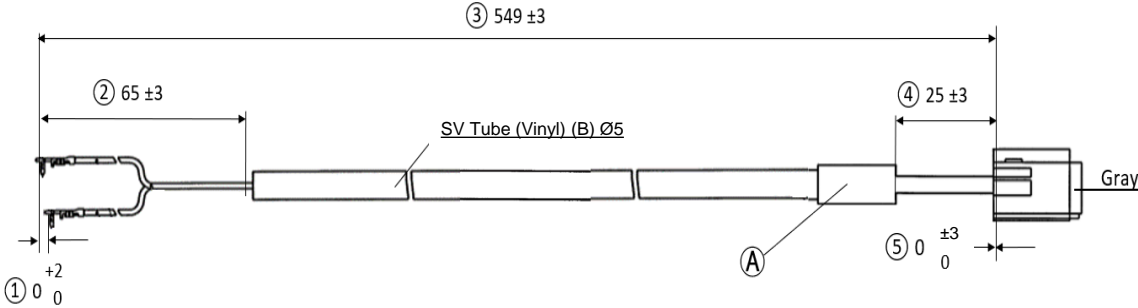

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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	<div>3</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	P1	Measurement <div><div>NOTE: A - Taping (B)</div></div>	<div>MEASURING TAPE</div> 	<div>Important reminders and note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>	

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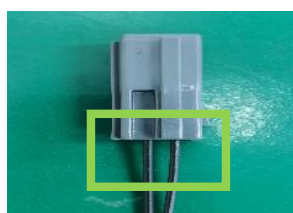
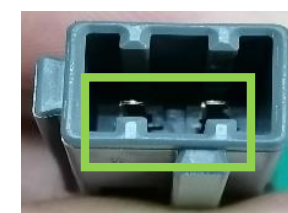
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7L0107-7020D****GOOD****NO GOOD****GOOD****NO GOOD****① No Terminal
Backing Out****② No Missing Tape****③ No Deformed Terminal****④ Not Fully
Inserted**

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