

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

Effectivity Date:

June 28, 2023Model Code/Part Number: **240B / 7M0516-7021**Customer: **TRJ**

Validity Date:

n/aPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-387B

Revision No.:

2

Page No.:

1 of 7**PARTS:** 1. Assy parts; Black COT (with slit) $\phi 5$ L=237 \pm 3mm; Black tape

JIG:

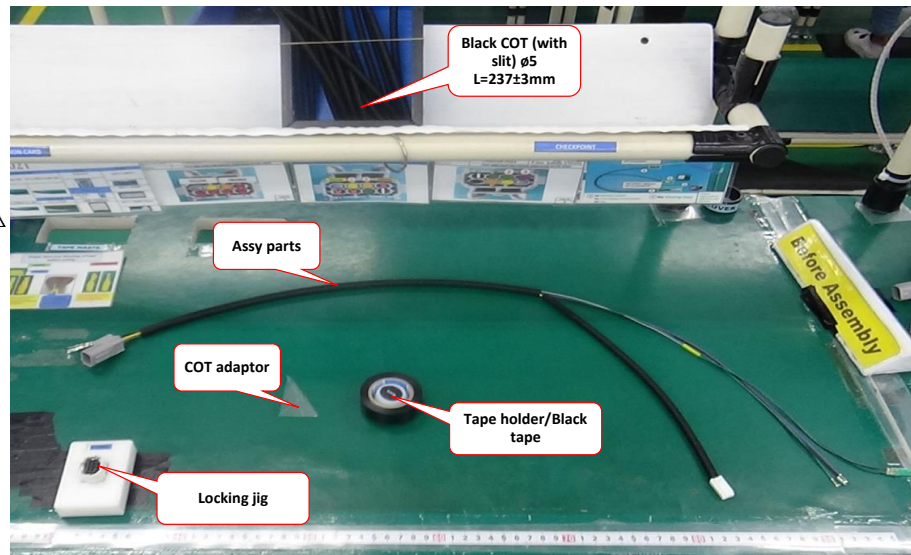
1. Locking jig
2. COT adaptor

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

1

P2

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	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	Prepared by	Reviewed by	Approved by	Noted by
06/28/23	2	Excluded process from P1 to P2 due to new process distribution; Changed table lay-out; Inclusion of Quality Checkpoints (page 7); Removed and Transferred process of Taping 1- Half wrap taping, Wire insertion to VM tube (Sunprene), Taping 2- COT to VM tube (Sunprene) and Taping 3: T-Taping from P2 to P3 due to new process distribution.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
09/23/22	1	Improve quality pointers: Reminders/notes and references in process no.2, 4 and 5 due to document improvement. Table lay-out. Removal of process 'Taping of COT to wire near terminal and PCB - transfer to P1' due to capacity improvement.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
02/14/22	0	Initial Issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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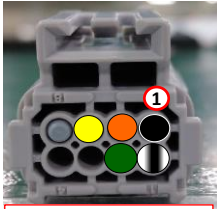



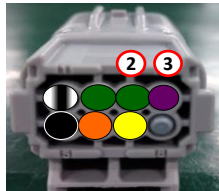


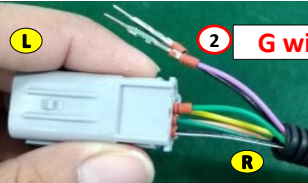
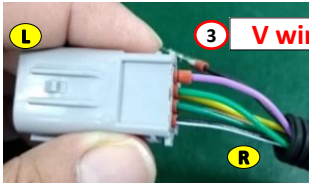
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PARTS:		1. Assy parts			JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Wire Insertion to Connector 6188-0779 (GR)	<div><div><p>VISUAL REFERENCE</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>WIRE FACING</p></div><div><p>1 B wire</p><div>1. Hold the connector 6188-0779 (GR) then hold the B wire and insert beside OR wire using right hand.</div></div></div> <div><div><p>VISUAL REFERENCE</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>WIRE FACING</p></div><div><p>2 G wire</p><div>2. Flip the connector 6188-0779 (GR) using left hand, get the G wire then insert beside G wire using right hand.</div></div><div><p>3 V wire</p><div>3. Hold the connector using left hand, get the V wire then insert beside G wire using right hand.</div></div></div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing 6. No wrong orientation of connector</div> <div>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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PARTS:

1. Assy parts
2. Black tape

JIG

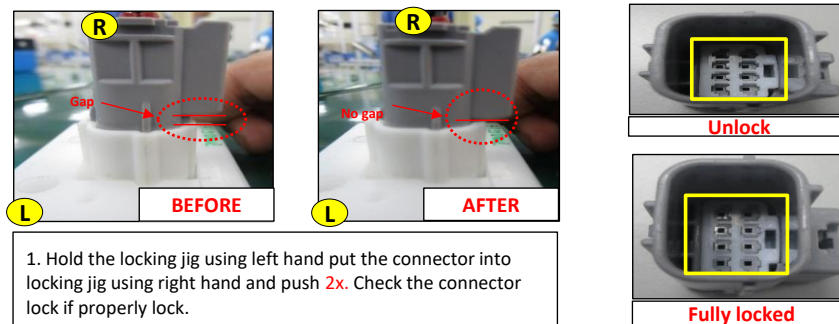
1. Locking jig

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

3

2

Connector Lock



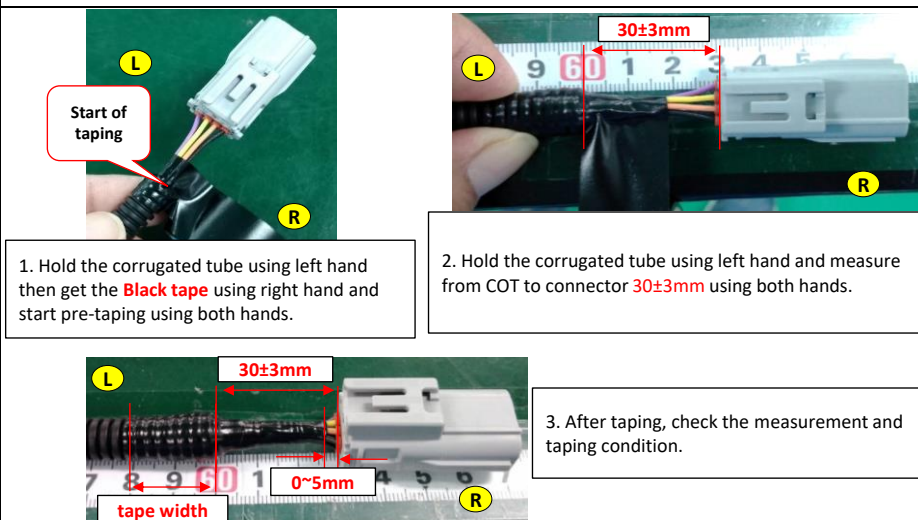
Important reminders/Note/s:
1. Manual locking may cause damaged connector lock

1. Use the provided locking jig per model
2. No unlock/half-lock connector

4

2

P2

Taping 1
COT to wire near
connector

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

Important reminders/Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

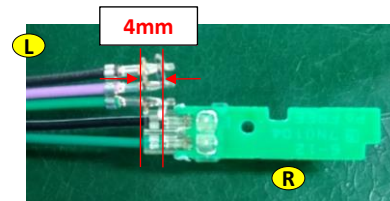
TOOLS/PPE

QUALITY POINTERS

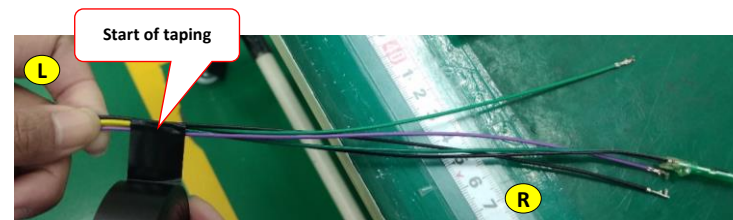
5

2

P2

Taping 2
Spot taping

1. Align the edge of hotmelted wire to terminal stabilizer (4mm gap) using both hands.



2. Hold the wires using left hand, get the **Black tape** then conduct spot taping beside **Yellow tape** using both hands. Make **2 windings** of tape then cut.



3. Check the wire alignment and taping condition.

MEASURING TAPE

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

Important reminders/Note/s:

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

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PARTS:

1. Assy parts
2. Black COT (with slit) $\phi 5$ L=237 \pm 3mm

JIG

1. COT Adaptor

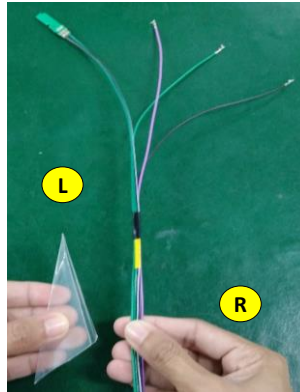
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

6

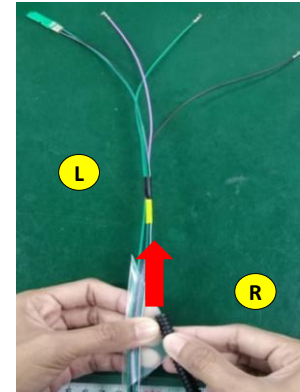
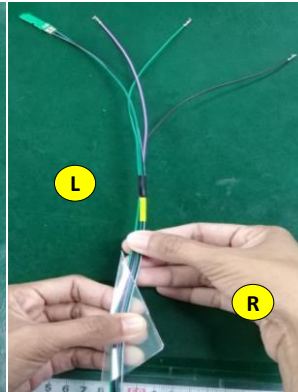
2

P2

Wire insertion to COT (with slit)
 $\phi 5$ L=237 \pm 3mm



1. Hold the COT adaptor using left hand. Combined the 2 assy parts and put inside the COT adaptor using right hand



2. Hold the COT adaptor with wires using left hand, get the **Black Corrugated tube (w/slit) $\phi 5$ L=237 \pm 3mm** using right hand and insert to COT adaptor. Pull the adaptor and push the COT (**same timing**) using both hands. Make sure all wires are inserted.

COT Adaptor

1. No wrong use of parts
2. No wires left in between the COT slit

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

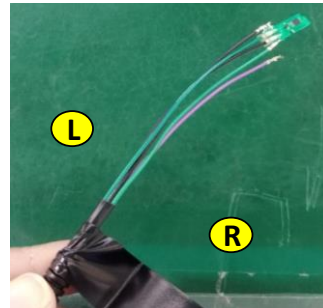
QUALITY POINTERS

2

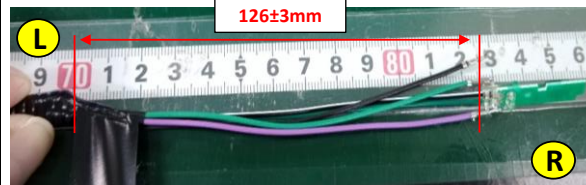
7

P2

Taping 3
COT w/slit to wire near
terminal and PCB



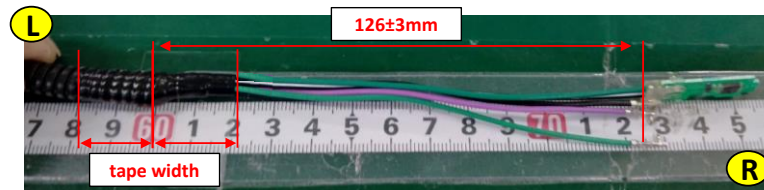
1. Hold the corrugated tube using left hand, get **Black tape** and start pre-taping using right hand.



2. Measure from COT up to the hotmelted wire **126±3mm**. Continue the taping process using both hands.

MEASURING TAPE

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



3. After taping, check the measurement and taping condition.

Important reminders/Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

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PARTS:

n/a

JIG

n/a



QUALITY CHECKPOINTS

P2

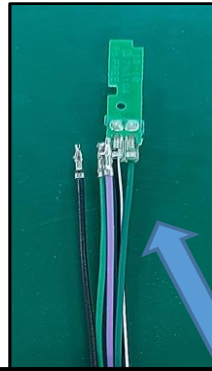
7M0516-7021



GOOD



NO GOOD



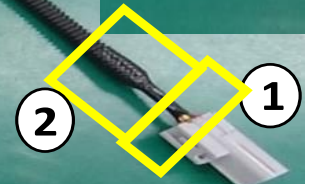
Proper
alignment of
B-B wires
and hotmelt

TAPE WIDTH * 131±3 mm
COT TO HOTMELT



2

TAPE WIDTH * 30±3 mm
COT TO CONNECTOR



2

1



1

No **WRONG INSERT**

No **TBO**

No **UNLOCK/HALFLOCK CONNECTOR**

2

No **Missing tape**

3

No **NG dimension**

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