

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

Effectivity Date:

November 25, 2022Model Code/Part Number: **310B / 7M0557-7021**Customer: **TRJ**

Validity Date:

n/a

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-415A

Revision No.:

2

Page No.:

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PARTS:

1. Black Corrugated tube (No slit) $\phi 5$ L=149 \pm 3mm
2. Black Sunprene tube $\phi 9$ L=97 \pm 3mm

3. Assy parts

JIG:

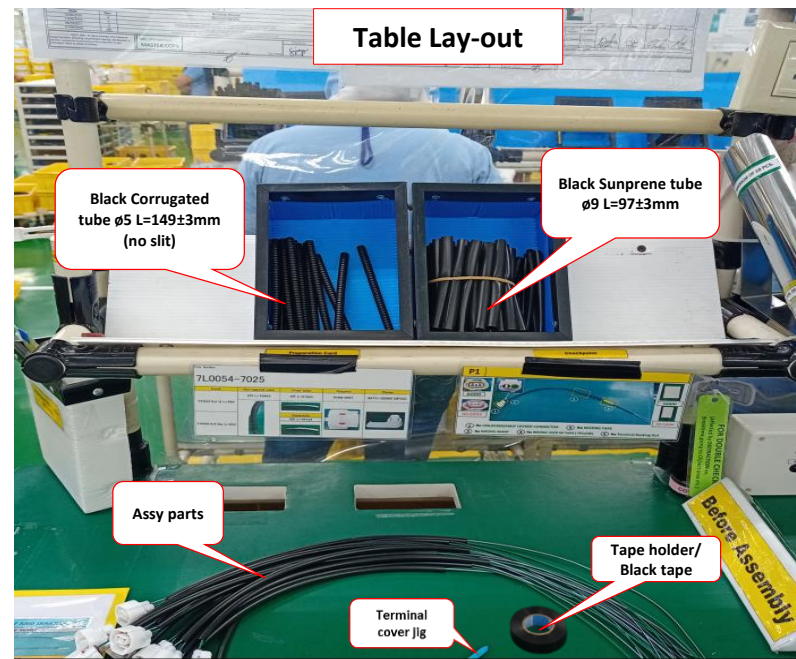
1. Terminal cover jig

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

1

P1

Table Lay-out

**Safety Instruction**

Be sure to wear required 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
11/25/22	2	Improve Quality pointers; Reminders/notes and references on page no.3 and 4. Additional Visual references on page no.5 as quality checkpoint.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes				
6/29/22	1	Remove Process no.2, 3, 4, and 5 then transfer to Offline Assembly Process (Please refer to WI-ENG-PDE-544) remove process no. 8 and transfer to P2; Transfer process no.3 and 4 from P2 due to Process improvement. Change Table Lay-out	M.Ariola	J. Loterte	C. Villanueva	A. Arañes				
02/18/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	February 18, 2022		

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



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Black Corrugated tube $\varnothing 5$ L=149 \pm 3mm (no slit) 2. Assy parts			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Wire insertion to Black Corrugated tube $\varnothing 5$ L=149 \pm 3mm (no slit)	<div data-bbox="602 560 947 754"></div> <div data-bbox="607 796 929 871">1. Get the terminal cover jig using right hand then insert the G and B/W wires.</div> <div data-bbox="976 627 1061 695"></div> <div data-bbox="1106 560 1442 754"></div> <div data-bbox="1075 796 1469 866">2. Get the Corrugated $\varnothing 5$ L=203\pm3mm (no slit) using right hand and insert the G and B/W wires</div> <div data-bbox="649 940 1016 1090"></div> <div data-bbox="1048 1038 1344 1086">3. After insertion, remove the terminal cover jig using right hand.</div>		<div data-bbox="1529 665 1762 805"><div>Terminal cover jig</div></div>	1. No wrong usage of parts 2. No deformed terminal

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☐ PROTOTYPE

☐ PRE-LAUNCH

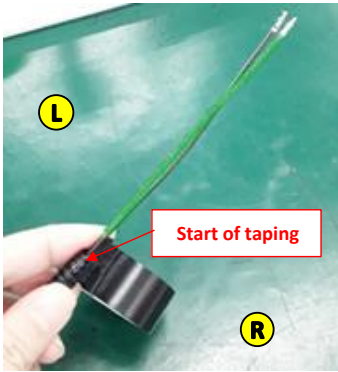
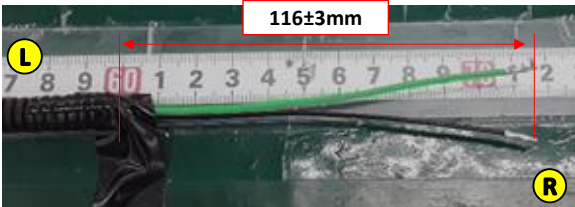
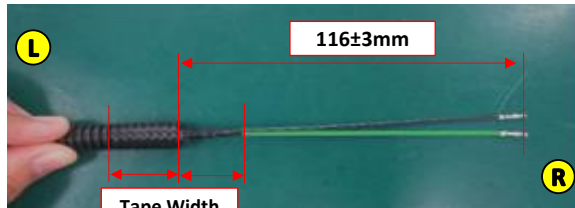

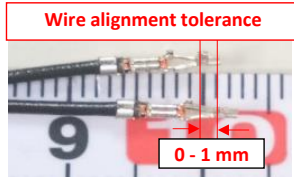
☒ MASSPRO

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Page No.:


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PARTS:		1. Black tape 2. Assy parts	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Taping 1 COT to wire near terminal	<div><div>1. Hold the assy parts, get the Black tape using right hand then conduct taping process using both hands.</div></div> <div><div>2. Measure the end of COT up to terminal pointed tip $L=116 \pm 3\text{mm}$ then continue the taping process using both hands.</div></div> <div><div>3. After taping, check the dimension, taping condition and wire alignment</div></div>	<p>MEASURING TAPE</p> 	<div>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</div> <div>2. Important reminders/Note/s: <i>1. Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div><p>Wire alignment tolerance 0 - 1 mm</p></div>

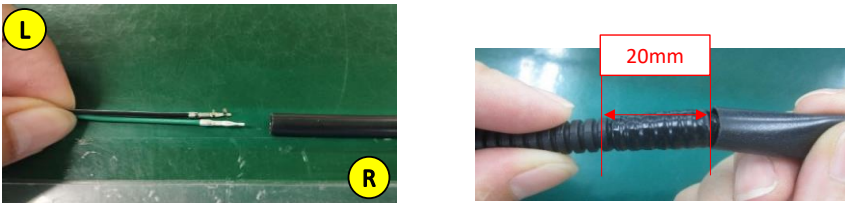
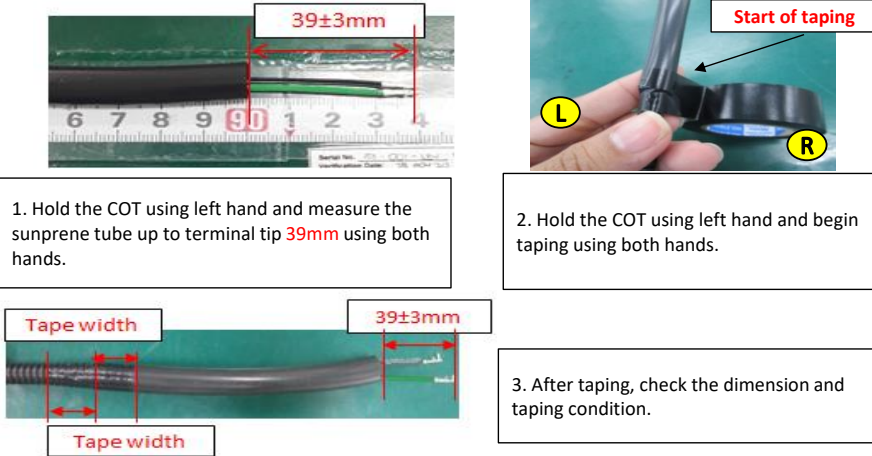

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	4 of 5

PARTS:	1. Black Sunprene tube $\phi 9$ L=97 \pm 3mm 2. Black tape 3. Assy parts			JIG	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Sunprene tube $\phi 9$ L=97 \pm 3mm	 <div> <p>1. Get the Sunprene tube $\phi 9$ L=97\pm3mm using right hand then insert the Green and Black/White wire using left hand.</p> <p>2. Insert the Sunprene to COT 20mm (Tape width) using both hands.</p> </div>	n/a	1. No wrong use of parts 2. No deformed terminal.
4	Taping 2 COT to Sunprene tube	 <div> <p>1. Hold the COT using left hand and measure the sunprene tube up to terminal tip 39mm using both hands.</p> <p>2. Hold the COT using left hand and begin taping using both hands.</p> <p>3. After taping, check the dimension and taping condition.</p> </div>	MEASURING TAPE 	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 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

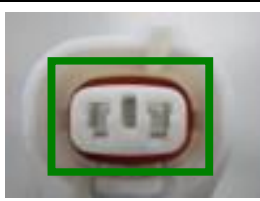
2 VISUAL REFERENCE

P1

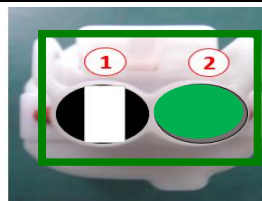
7M0557-7021



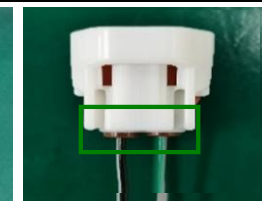
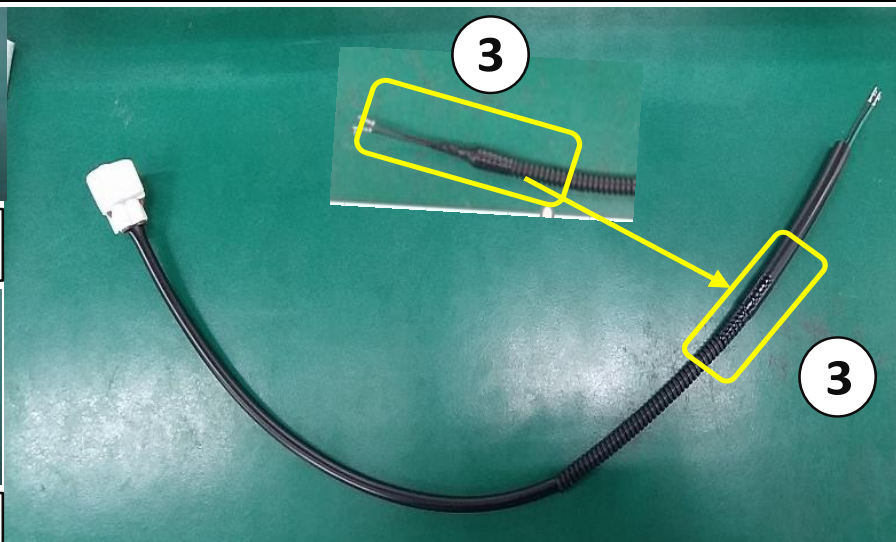
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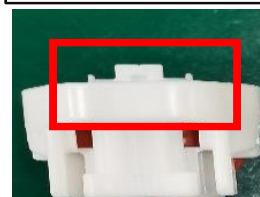
GOOD



GOOD



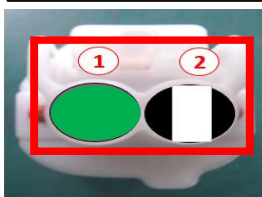
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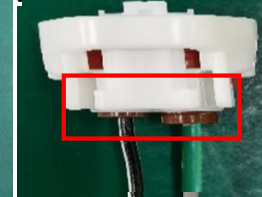
NO GOOD



NO GOOD



NO GOOD



NO GOOD

1 No Unlock/Halflock Connector

2 Checking of Double Lock Deformation

3 No Wrong Insert

3 No Missing Tape
(taping on COT-wire and taping on sunprene tube)

4 No Terminal Backing Out

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