

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**Model Code/ Part Number: **D01L / 7M0651-7020C**Customer: **TRJ**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

**December 20, 2022**

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**WI-ENG-PDE-353B**

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**4**


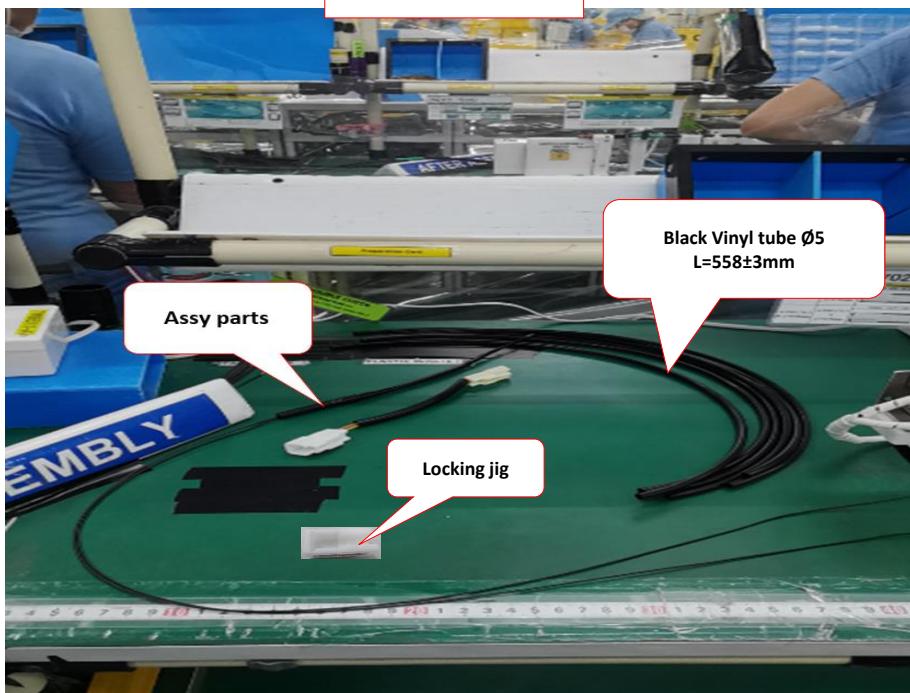
Page No.:

**1 of 7****PARTS:**

1. Assy parts; Black vinyl tube Ø5 L=558±3mm;Black tape

**JIG:**

1. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	 P2 Table Lay-out	 <p><b>TABLE LAY-OUT</b></p> <p>Black Vinyl tube Ø5 L=558±3mm</p> <p>Assy parts</p> <p>Locking jig</p>	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/tools 2. No excess parts/tools

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
12/20/22	4	Correction of process no. from P1 to P2 on page 1 to 4.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes				
12/09/22	3	Improve quality pointers; Reminders/notes and references on pages no.3 to 6 due to document improvements. Improve work procedure/illustration on process no.4-Connector lock. Inclusion of Quality pointers.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes				
05/25/22	2	Transferring Process no.12,14,15,16 from P1 to P2 Due to Process Improvements. Remove and Transfer process no. 2,6,7 and 8 to P3 due to process improvements. Change table lay-out.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 11, 2021		

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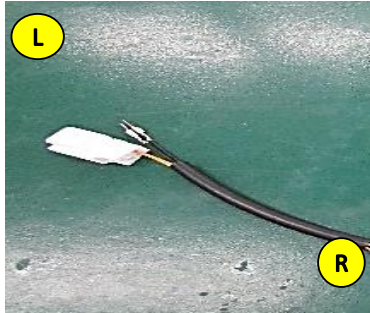
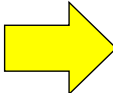
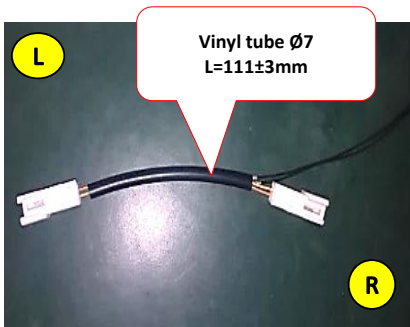
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black vinyl tube Ø5 L=558±3mm		JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	4 P2	Wire insertion to Black vinyl tube Ø5 L=558±3mm	<div><div>1. Get the vinyl tube Ø5 L=558±3mm using right hand then insert B-B wires using left hand.</div></div>	n/a	1. No wrong use of parts 2. No deformed terminal
3		Wire insertion to assy parts	<div><div></div><div>1. Hold the assy part using left hand. Get the B-B wires then insert using right hand.</div></div>	n/a	1. No wrong use of parts 2. No deformed terminal 3. No wrong insertion of parts.

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### PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

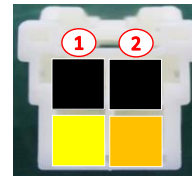
4

4  
P2

Wire insertion to  
Connector  
4G5400-0000 (W)



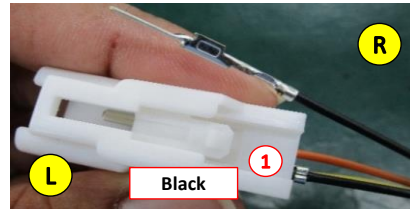
Connector Orientation



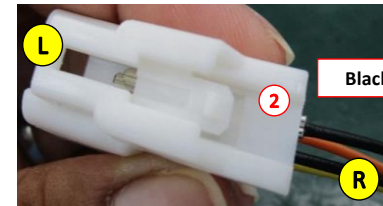
Visual Reference



Wire Facing



1. Hold the connector using left hand, get the **1st Black wire** then insert to terminal slot **1** using right hand.



2. Hold the **2nd Black wire** then insert to terminal slot **2** using right hand.

n/a

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

### Important reminders/Note/s:

1. Insertion of wire must be from left to right.
  2. Please hold the wire near terminal during insertion.
  2. Make sure wires are properly inserted.
- Conduct Pull-Push-Pull-Push after insertion.  
Do not exert extra force.

### Document reference/s:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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### PARTS:

1. Assy parts

### JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

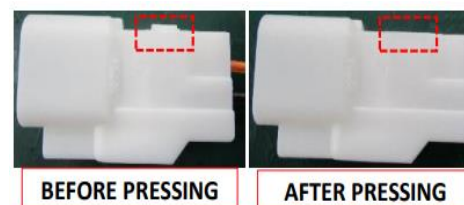
4

4  
P2

Connector lock



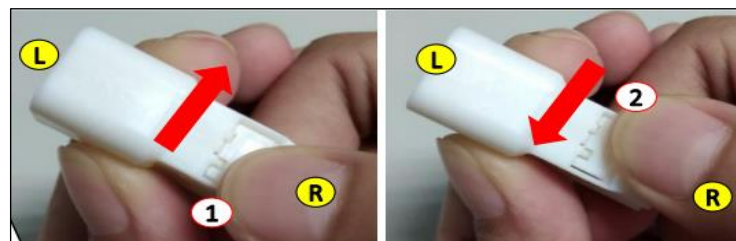
1. Put the connector into locking jig using both hands then press 2x using both hands.



BEFORE PRESSING

AFTER PRESSING

LOCKING JIG



2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

### Important reminders/Note/s:

1. Manual locking may cause damaged connector lock

1. Use provided jig tool per model to avoid damaged lock.
2. No unlock/half-locked connector

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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	P2 Taping 4 Vinyl tube to wire near assy parts	<div><div>SV tube ø7 L=111±3mm</div><div>20mm</div><div>SV tube ø5 L=558±3mm</div><div>1. Measure from vinyl tube to combined Connector and tube 20mm using both hands.</div><div>Start of taping</div><div>91±3mm</div><div>2. Hold the vinyl tube using left hand, get the <b>Black tape</b> then start taping using both hands.</div><div>3. Measure from end of tube up to end of tape 91±3mm using both hands.</div><div>4. Continue the taping process then make <b>3 windings</b> of tape before cut.</div><div>5. After taping, check the measurement and taping condition.</div></div>	<div>MEASURING TAPE</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</div> <div>Important reminders/Note/s:  <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b> <b>2. Used YELLOW TAPE for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</b></div>
6	Y-taping	<div><div>must be aligned</div><div>Start of taping</div><div>1. Fix the connector and vinyl tube before taping (<b>must be aligned</b>).</div></div>	n/a	<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</div>

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PROTOTYPE



PRE-LAUNCH



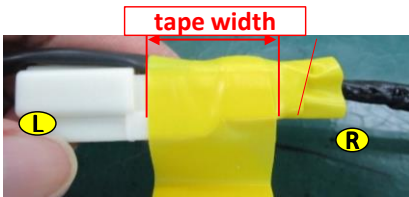
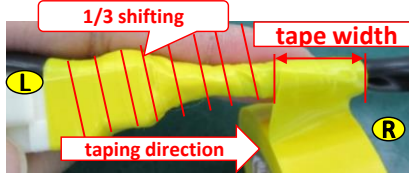
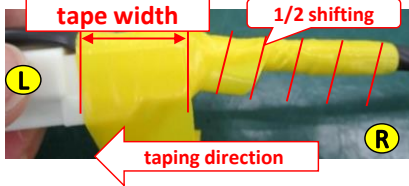
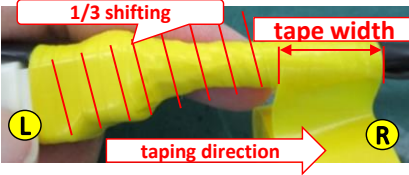
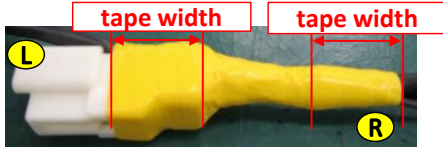


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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2 Y-taping (Continuation)	<div><p>2. Make <b>1/3 shifting</b> going to connector then make <b>2 windings</b> of tape before shifting (<b>must be tape width</b>).</p></div> <div><p>3. Wind the tape <b>1/3 shifting</b> until it reach the vinyl tube tape. Make <b>2 windings</b> of tape before shifting.</p></div> <div><p>4. Wind the tape backward <b>1/2 shifting</b> then make <b>2 windings</b> of tape before final shifting.</p></div> <div><p>5. Wind the tape <b>1/3 shifting</b> going to vinyl tube then make <b>3 windings</b> of tape before cut.</p></div> <div><p>6. After taping, check the measurement and taping condition.</p></div>	<div>MEASURING TAPE</div> 	<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</p> <p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Used <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</p> <div><p>ACTUAL ASSY PARTS AND CORRECT FACING</p></div>

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PARTS:

n/a

JIG

n/a

## QUALITY CHECKPOINTS

**P2**

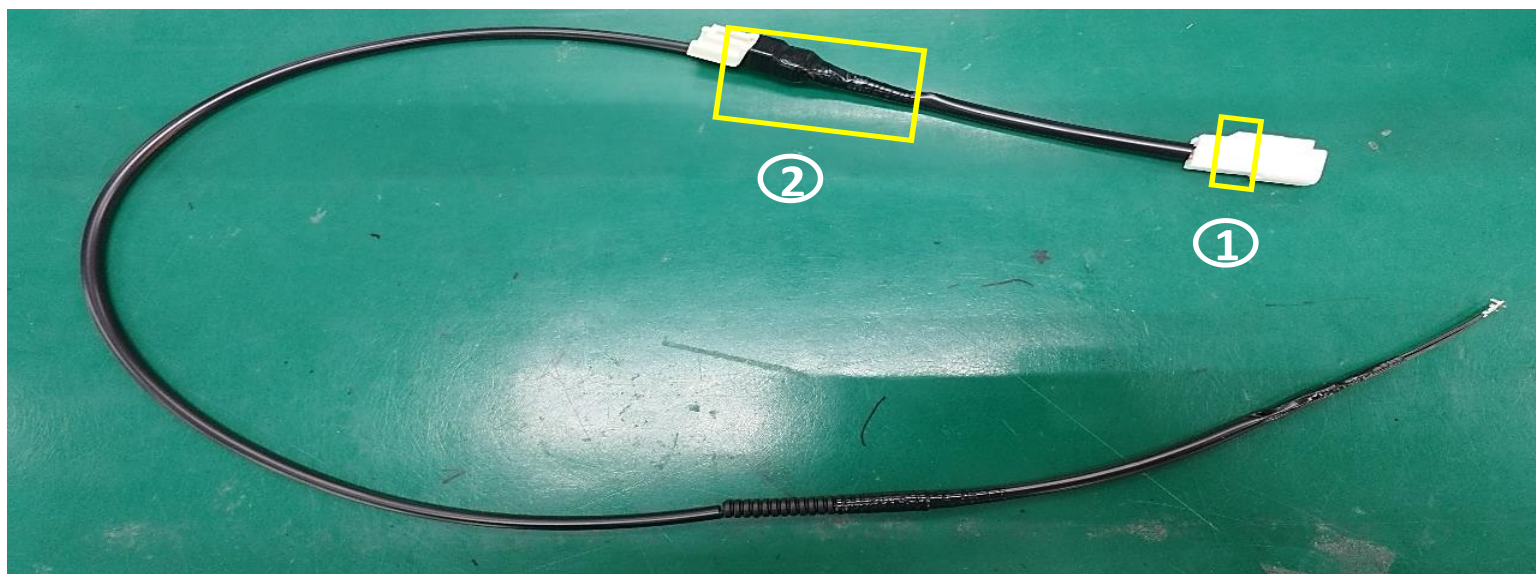
**7M0651-7020C**



**GOOD**



**NO GOOD**



**3** Sample Reference



**GOOD**



**NO GOOD**

**1** No **Unlock/ Half Lock Connector**

**2** No **Missing Tape**

**3** No **Terminal Backing**

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