

	WORK INSTRUCTION						Effectivity Date:		April 12, 2021	
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:				Product Name/Code: 780B / 1 7R0104-7021		Customer: TRMX		Document No.: WI-ENG-PDE-204B	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.: 1 Page No.: 1 of 7	

PARTS:	1. Assy parts 1						JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE	QUALITY POINTERS
1	P2 1 Wire insertion to assy parts	<div style="display: flex; justify-content: space-around; align-items: flex-start;"> </div> <div style="border: 1px solid black; padding: 5px; margin: 10px 0;"> 1. Get the assy parts, hold the COT $\phi 5$ L= 208\pm3mm then insert the GR-B/W hotmelted wires and B wires [2pcs.] using right hand. </div> <div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="border: 1px solid black; padding: 5px;"> 2. After insertion, check the inserted wires.. Note: No wires left inside COT. </div> </div>						<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1. No wrong use of parts 2. No deformed terminal

								Prepared by		Reviewed by		Approved by		Noted by	
04/12/21	1	Change part number from 7R0104-7020B to 7R0104-7021 due to change of tape color from Black tape to Yellow tape in process Y-Taping. Removal of cover jig during insertion of wires to COT. Transferring of process from P1 to P2.						M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
12/01/20	0	Initial issue						M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change						Revised	Checked	Approved	Noted	Est. Date:		December 04, 2020	

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☐ PROTOTYPE

☐ PRE-LAUNCH

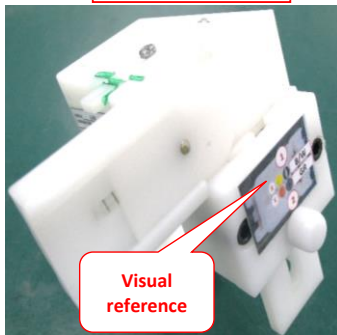
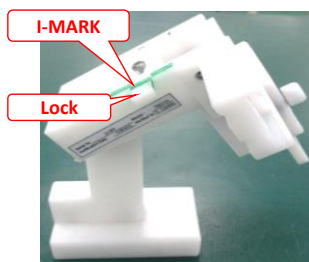
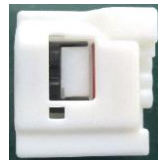
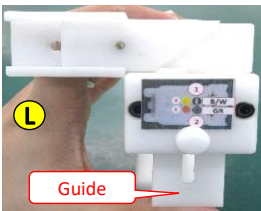
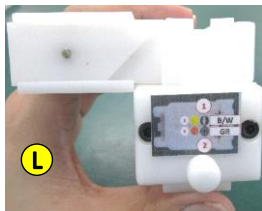
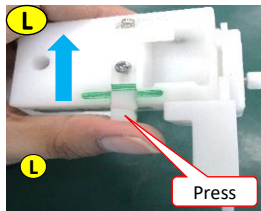
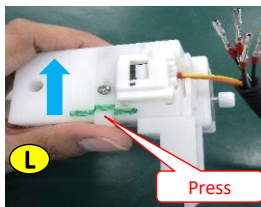
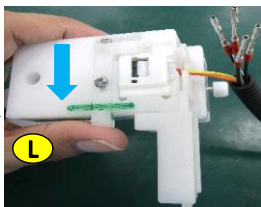
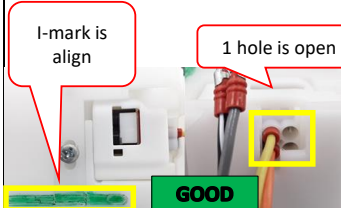
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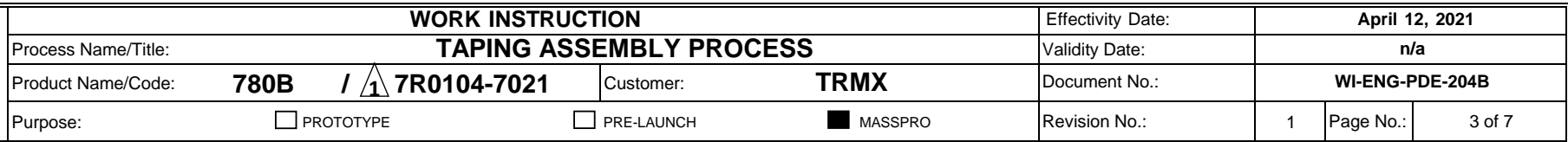
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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2	<div><div>1</div><div>Connector setting to insertion jig 6189-1142 (W) (Assy parts)</div></div>	<div><div><div>INSERTION JIG</div><div></div><div>Visual reference</div></div><div><div>I-MARK</div><div>Lock</div><div></div><div>INSERTION JIG ORIENTATION</div></div><div><div></div><div>CONNECTOR ORIENTATION</div></div></div> <div><div><div></div><div>Guide</div></div><div></div><div>L</div><div><div>1. Press the lower wire guide using right thumb to make sure connector with inserted wires will be inserted.</div></div></div> <div><div><div></div><div>L</div><div>Press</div></div><div><div>2. Press the insertion jig lock using left hand.</div></div></div> <div><div><div></div><div>L</div><div>Press</div></div><div></div><div>L</div><div><div>3. Get the assy parts and insert the connector using right hand. Release the lock after insertion.</div></div></div>	n/a	<div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div><div>I-mark is align</div><div>1 hole is open</div><div></div><div>GOOD</div></div></div><div><div>1. Use the provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div></div>

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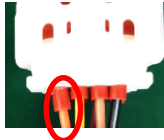

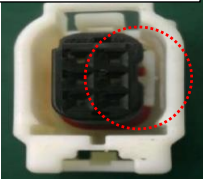
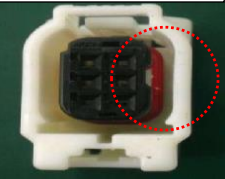
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PARTS:	1. Assy parts			JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	1 Wire insertion to connector 6189-1142 (W) (Assy parts)	<div data-bbox="907 424 1169 502"></div> <div data-bbox="1205 459 1323 480">WIRE FACING</div> <div data-bbox="658 539 909 560">Connector Orientation</div> <div data-bbox="607 587 958 745"></div> <div data-bbox="1005 612 1064 716"></div> <div data-bbox="1095 587 1451 745"></div> <div data-bbox="618 794 943 890">1. Hold the connector using left hand and insert first B wire to connector using right hand. <i>Note: Insertion starts from left to right</i></div> <div data-bbox="1106 794 1453 866">2. Hold the connector using left hand and insert second B wire to connector using right hand.</div>	n/a	<div data-bbox="1776 424 1939 564"></div> <div data-bbox="1973 440 2107 536"><i>Note: During insertion, hold the wire not rubber seal to prevent sagging.</i></div> <div data-bbox="1776 612 1995 735">1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div data-bbox="1787 783 2112 903"><i>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i></div>
5		1 Connector lock	<div data-bbox="633 986 943 1187"></div> <div data-bbox="1005 1078 1205 1099">BEFORE PRESSING</div> <div data-bbox="1245 1078 1429 1099">AFTER PRESSING</div> <div data-bbox="1014 1123 1216 1302"></div> <div data-bbox="1227 1123 1451 1302"></div> <div data-bbox="607 1222 949 1318">1. Put the connector into locking jig using right hand and then press 2x using both hands. Check the connector lock if properly locked.</div>	LOCKING JIG	<div data-bbox="1809 986 2089 1058"><i>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED CONNECTOR LOCK</i></div> <div data-bbox="1776 1110 2112 1182">1. Use the provided jig tool per model 2. No unlock/half-locked connector 3. No damaged lock</div>

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

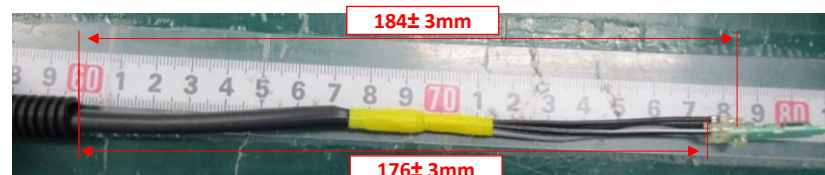
TOOLS/PPE

QUALITY POINTERS

6

P2

Taping 1
Black corrugated tube to
Black sunprene tube



1. Measure the end of the corrugated tube up to the edge of hotmelt 176mm and terminal pointed tip 184mm.

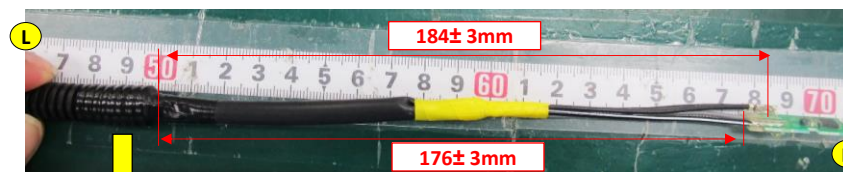
Start of taping

L

R

2. Hold the corrugated tube using left hand. Get the Black tape using right hand and start taping process using both hands.
Refer to WI-PRO-ASY-001 for taping procedure.

MEASURING TAPE



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

- Note:
Please use calibrated/verified measuring tape when getting the measurement.
1. No peel-off tape
 2. No flip out tape
 3. No loose tape
 4. No wrong use of tape
 5. No wrong dimension

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PROTOTYPE



PRE-LAUNCH



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PARTS:



1. Assy parts
2. Yellow tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

7

P2

Y-Taping



No wide interval

1. Fix the vinyl and corrugated tube using both hands.
See illustration for correct facing of connector.



2. Start taping at the middle of combined Corrugated tubes & vinyl tube, make **1 winding** pre-tape before shifting.

3. Make 1 wind going to Vinyl tube & corrugated tube , width must be same with tape (**19mm**).

tape width

n/a

NOTE:
Use YELLOW TAPE only.

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape
5. No wrong dimension

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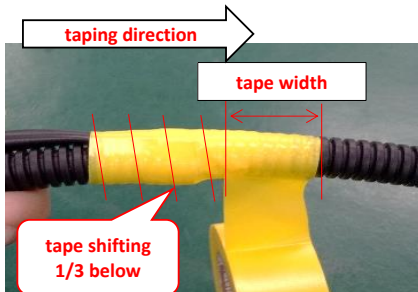
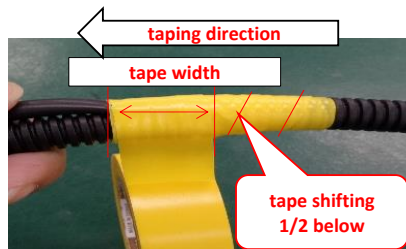
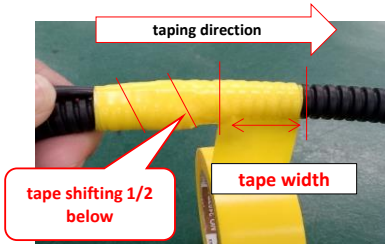
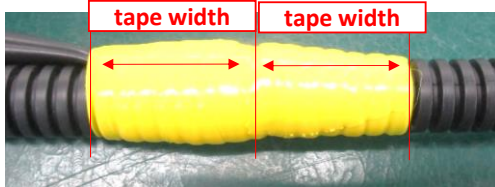

PARTS:

1

1. Assy parts
2. Yellow tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P2 1 Y-Taping (Continuation)	 4. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width).  5. Wind the tape backward 1/2 shifting.  6. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape.  7. After taping, check the measurement and taping condition.	<div>MEASURING TAPE</div> 	<div>NOTE: Use <u>YELLOW TAPE</u> only.</div> <div>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</div> <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div>

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