

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

Effectivity Date:

September 30, 2022Model Code/Part Number: **TP1 / 7L0090-7022** Customer: **TRQSS**

Validity Date:

n/a

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Document No.:

WI-ENG-PDE-056B

Revision No.:

5

Page No.:

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PARTS:		1. Assy parts 2. Gray tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Y-taping	<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div> <div>Wire alignment tolerance </div>	<div>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wide interval between COT 6. No exposed wire</div> <div>Important reminders/Note/s: 1. Used YELLOW TAPE for easy visualization of shifting lines, but actual should be GRAY TAPE. 2. Please use calibrated/ verified measuring tape when getting the measurement. 3. Do not exert excessive force during pulling & winding of tape.</div> <div>Y-TAPING ORIENTATION GOOD FACING NG FACING</div>
Revision History				
09/30/22	5	Change of tolerance from 35+/-3mm to 35+3/-1mm as countermeasure of encountered NG sample from end of tape up to terminal tip. Improve work procedure/illustration on process no. 5 (Visual/ by two's inspection) and process no.6 (Measurement). Quality pointers; Reminders and notes on pg. no.1 to 6.	M. Ariola	J. Loterte
2/22/21	4	Change part number due to changes Tape color from Black to Gray on Y-Taping process. Update illustration of Urethane foam attachment; Continuity tet; Visual/by two's inspection; measurement and master sample.	M. Ariola	J. Loterte
01/30/21	3	Removal of cycle time: Put Assy parts on parts section of Pg. 1-3; Conduct semi-annual review of doc's. Put additional illustration/picture on Y-Taping procedure 1.	J. Loterte	R. Peñaloza
Eff. Date	Rev. No	Details of Change	Revised	Reviewed
			Approved	Noted
			Est. Date:	Dec 16, 2019
			Prepared by	Reviewed by
			Approved by	Noted by

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PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

5

WORK PROCEDURE/ ILLUSTRATION

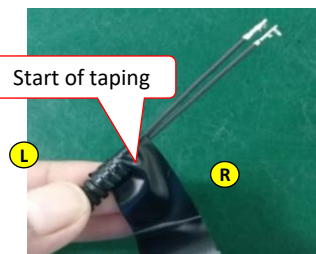
TOOLS/PPE

QUALITY POINTERS

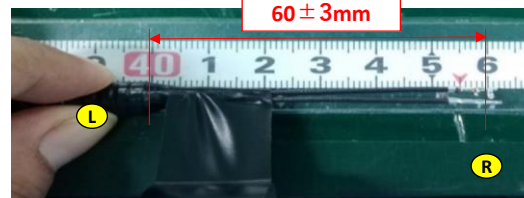
2

P2

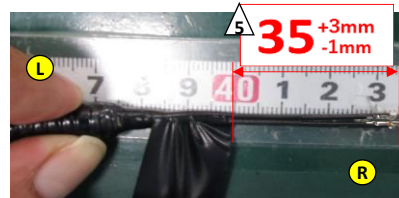
Taping 1
Corrugated tube to wire
near terminal



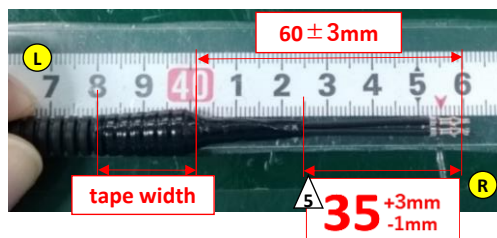
1. Hold the COT using left hand, get the **Black tape** using right hand then start pre-taping using both hands.



2. Measure from end of COT up to terminal pointed tip **60±3mm** then continue the taping process using both hands.



3. Confirm measurement of **35+3/-1mm** from end of tape up to terminal pointed tip then continue the taping process using both hands.

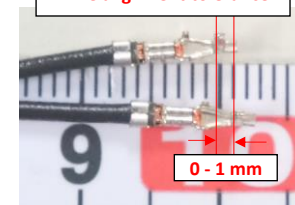


4. After taping, check the measurement, taping condition and terminal appearance.

MEASURING TAPE



Wire alignment tolerance



5

Important reminders/Note/s:

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

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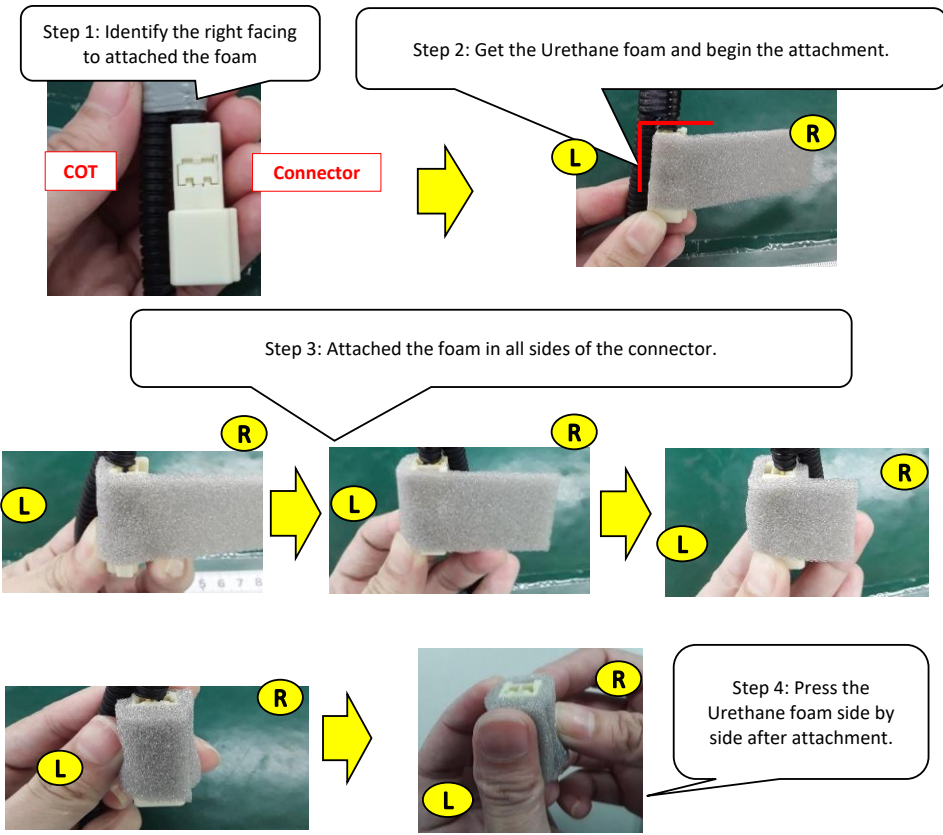
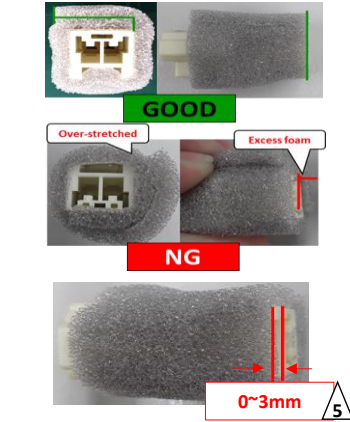
WORK INSTRUCTION TAPING ASSEMBLY PROCESS

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Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Gray Urethane foam t=4; 75mm X 30mm 2. Assy parts		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Urethane foam manual attachment to connector	<p>Step 1: Identify the right facing to attached the foam</p> <p>Step 2: Get the Urethane foam and begin the attachment.</p> <p>Step 3: Attached the foam in all sides of the connector.</p> <p>Step 4: Press the Urethane foam side by side after attachment.</p> 		n/a	<p>1. No damaged Urethane foam 2. No missing Urethane foam 3. No stretched Urethane foam</p> <p>Important reminders/Notes:</p> <ol style="list-style-type: none">1. Foam and connector must be align2. Follow the attachment sequence based on the illustration.3. Do not stretch the urethane foam.4. Tolerance from Urethane foam to Connector must be 0~3mm <p>URETHANE FOAM</p> 

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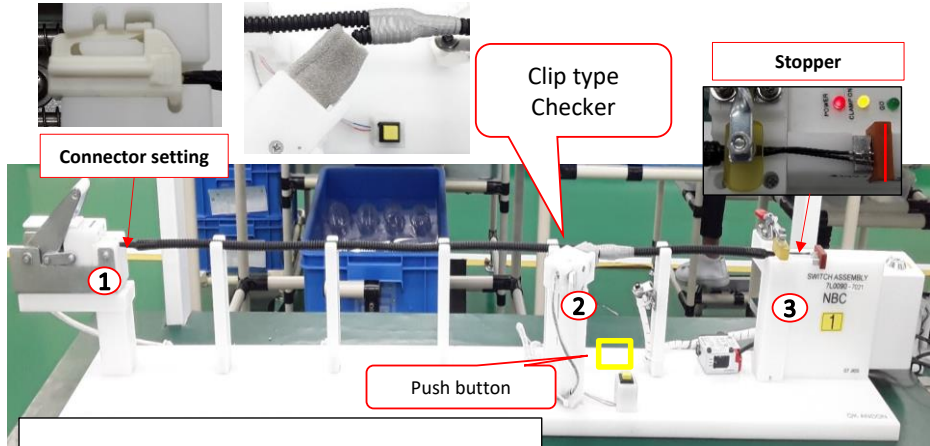

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Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts		JIG	1. Continuity test jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	<div><p>1. Get the assy parts and set to tester jig using both hands. First put the connector into CHECKER 1 and pull down to lock. Second, put the connector with foam to CHECKER 2. And last, put the wires into stopper jig and pull down the toggle clamp. <i>Refer to above illustration for proper setting.</i></p><p>2. Check if all LED light for Power ON, Clamp on was ON. If encounter abnormality or hearing NG buzzer, STOP and immediately CALL the attention of the leader. WAIT for further instruction before proceed to process.</p><p>3. Press the SW button using right hand. Conduct POINT CHECKING before removing from jig.</p></div>		n/a	<div><p>Important reminders/Note/s:</p><p>1. Must be no gap between the terminal and stopper jig.</p></div>

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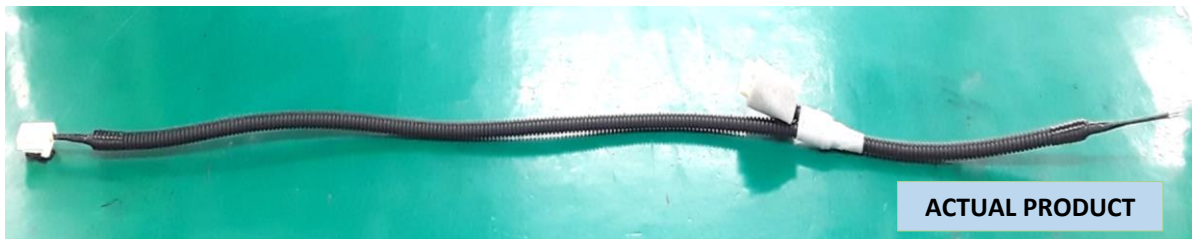
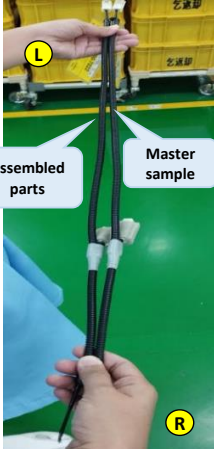
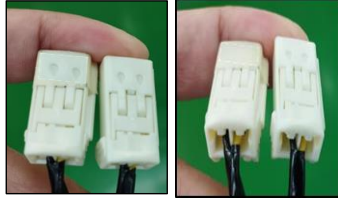
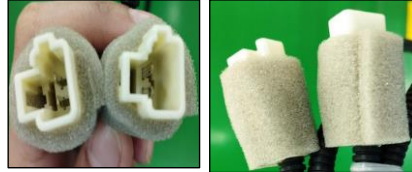


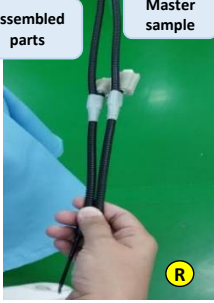

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PARTS:		1. Assembled parts 2. Master sample		JIG	n/a
NO.	PROCESS NAME	5 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2 Visual/By Two's inspection	<div><div><p>ACTUAL PRODUCT</p></div><div><div><p>Assembled parts Master sample</p></div><div><div><p>2. Check the connector lock, wire insertion and taping condition.</p></div><div><div><p>3. Check the terminal, insertion and presence of urethane foam.</p></div><div><div><p>4. Check the Y-Taping condition.</p></div><div><div><p>5. Check the terminal, insertion and taping condition. Must no deformed terminal.</p></div><div><p>1. Conduct alignment of harness (Master sample vs. Assembled parts) using both hands.</p></div></div></div></div><div><div><p>MASTER SAMPLE</p></div><div>5 1. No skip checking during inspection.</div></div></div></div></div>			

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

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WORK PROCEDURE/ ILLUSTRATION

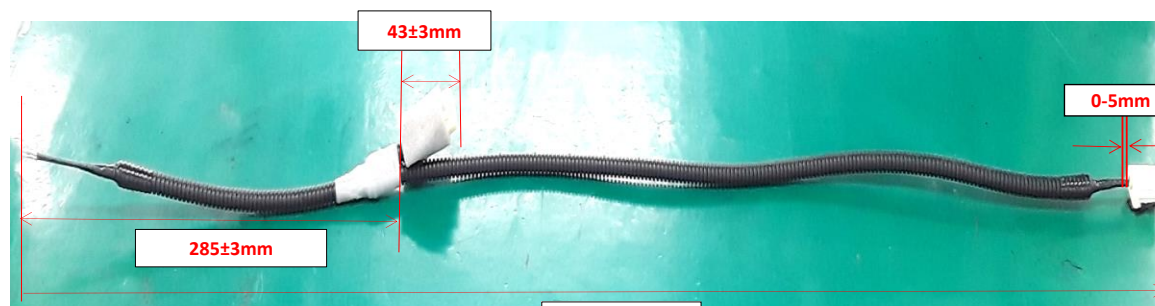
TOOLS/PPE

QUALITY POINTERS

6

P2

Measurement



MEASURING TAPE



5

Important reminders/Note/s:

1. No wrong dimension

1. For Hatsumono and Owarimono.

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

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