

	WORK INSTRUCTION				Effectivity Date:		July 26, 2023	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model Code/Part Number: 101D / 7N0097-7020A		Customer: TRJ		Document No.: WI-ENG-PDE-239B	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		6	Page No.: 1 of 9

PARTS:	1. Assy parts; Black tape				JIG:	1. Insertion jig 2. Locking jig			
NO.	PROCESS NAME	6	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS	
1	P2	6	<div style="text-align: center;"> </div>				<div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> 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 missing parts/tools 2. No excess parts/tools	
Revision History				Prepared by	Reviewed by	Approved by	Noted by		
07/26/23	6	Changed table-Lay-out; Inclusion of Quality Checkpoints (page 9); Remove and transferred process of Clamp setting; Clamp assembly; Visual/By two's inspection and measurement from P2 to CLAMP ASSEMBLY PROCESS; Transferred process no.2;3;4;5 and 6 from P1 to P2 due to new process distribution.				M. Ariola	J. Loterte	C. Villanueva	A. Arañes
04/04/23	5	Correction of Part number from 7N0097-7020 to 7N0097-7020A. Change term from Vinyl tube to SV tube (Vinyl).				D. Castillo	J. Loterte	C. Villanueva	A. Arañes
12/02/22	4	Improvement Project: Change MP from 3MP to 2MP. Transfer Taping of Corrugated tube to vinyl tube process and Y-taping (Page 3-5)				D. Castillo	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	March 9, 2021		

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PARTS: 1. Assy parts

JIG

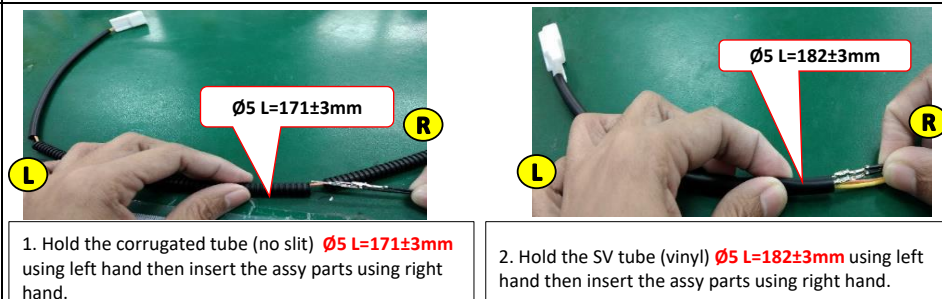
1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
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2

6

Wire insertion to assy parts



n/a

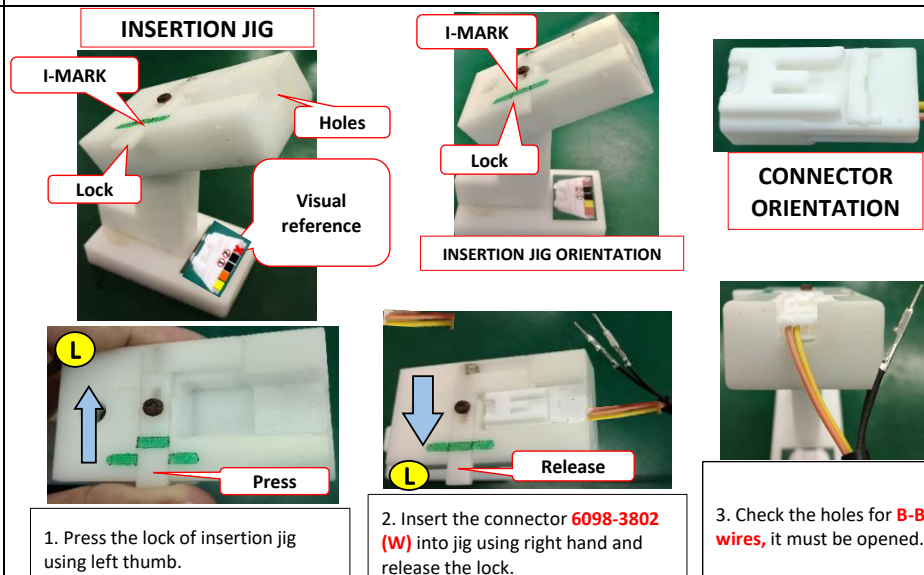
1. No wrong use of parts
2. No deformed terminal
3. No wrong insertion

3

6

P2

Connector setting to insertion jig 6098-3802 (W) (Assy parts)



n/a

- Connector Orientation Illustration**
- I-mark is align 2 Holes are open
- GOOD
1. Use the provided jig per model
 2. No wrong orientation of connector
 3. No wrong use of connector
 4. No damaged connector

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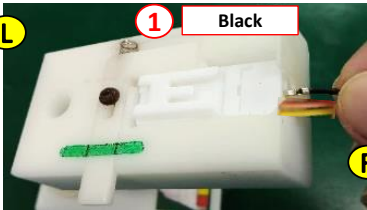
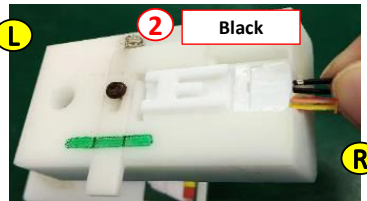
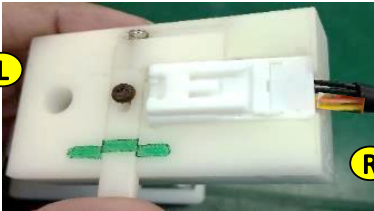
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PARTS:		1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P2	<div><div><div>Wire facing</div></div><div><div><div>1. Get the assy part and hold the B wire then insert to terminal slot 1 using right hand.</div></div><div><div>2. Hold the B wire then insert to terminal slot 2 using right hand.</div></div><div><div>3. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div></div></div></div>			n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Please hold the wire near terminal during insertion. 2. Insertion of wire must be from left to right. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div>

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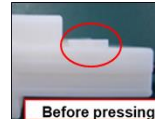



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PARTS:		1. Assy parts			JIG	1. Locking jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
5	P2	Connector lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div><div><p>Right thumb-Lower Left thumb-middle</p><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div><div><p>Right thumb-upper Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div><div><p>Right thumb-middle Left thumb-middle</p><p>5. Lift then press the connector in the middle using left and right hand.</p></div><div><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div> <div><div></div><div>LOCKING JIG</div></div> <div><p>Important reminders/Note/s:</p><p>1. Manual locking may cause damaged connector lock.</p><p>1. Use the provided locking jig per model</p><p>2. No unlock/half-lock connector</p><div><div><p>Before pressing</p></div><div><p>After pressing</p></div></div><div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div></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	Taping 1 Black SV tube (Vinyl) to wire near connector	<p>1. Measure from end of Sv tube (Vinyl) up to connector 25mm using both hands.</p> <p>2. Get the Black tape using right hand then conduct pre-taping between the SV tube (Vinyl) and wires near connector using both hands. <i>(Note: Do not fold the SV tube (Vinyl) ø5 with 3 wires)</i></p> <p>3. Make 1/2 shifting using both hands going to wire side then make 3 windings of tape then cut the tape.</p> <p>4. After taping, check the taping condition and measurement.</p>	<p>MEASURING TAPE</p>	<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>Important reminders/Note/s:</p> <p>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, But actual should BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p>

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

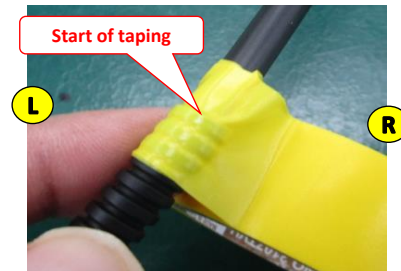
TOOLS/PPE

QUALITY POINTERS

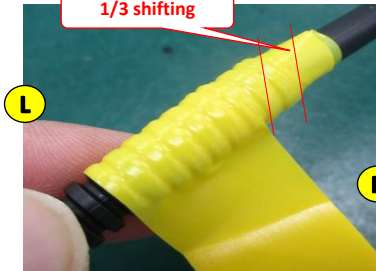
7

P2

Taping 2
Black Corrugated tube to
Black SV tube (Vinyl) near
connector



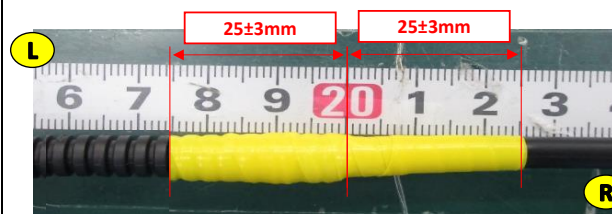
1. Get the **Black tape** using right hand then make **2 windings** of tape at the middle of COT and SV tube (Vinyl) using both hands.



2. Make **1/3 shifting** using both hands going to the side of COT until it reach **25mm** then make **2 windings** of tape before shifting to other side.

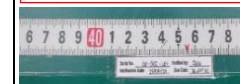


3. Make **1/2 shifting** using both hands going to other side of SV tube (Vinyl) then make **3 windings** of tape and cut the tape.



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

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. Use **YELLOW TAPE** for easy visualization of shifting lines, But actual should **BLACK TAPE**.
2. 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

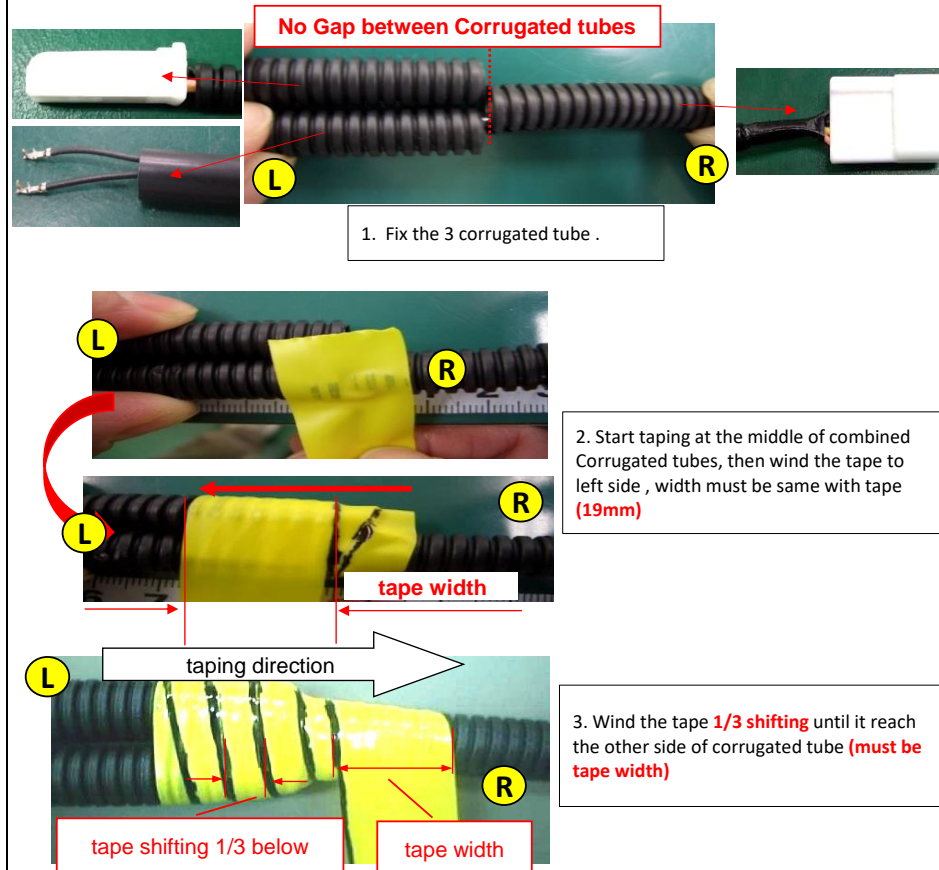
TOOLS/PPE

QUALITY POINTERS

8

P2

Y-Taping



n/a

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. Use **YELLOW TAPE** for easy visualization of shifting lines, But actual should **BLACK TAPE**.
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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

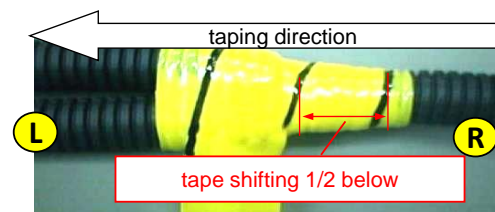
TOOLS/PPE

QUALITY POINTERS

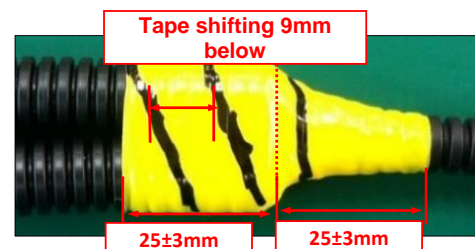
8

P2

Y-Taping
(Continuation)



4. Wind the tape backward **1/2 shifting**



5. Wind the tape **1/2 shifting** going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.

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. Use **YELLOW TAPE** for easy visualization of shifting lines, But actual should **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

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PARTS:

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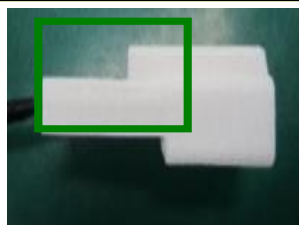
JIG

n/a

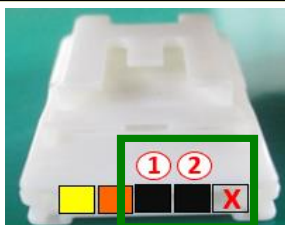
QUALITY CHECKPOINTS

P2

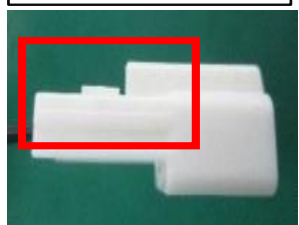
7N0097-7020A



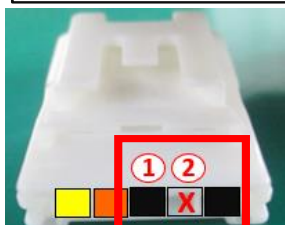
GOOD



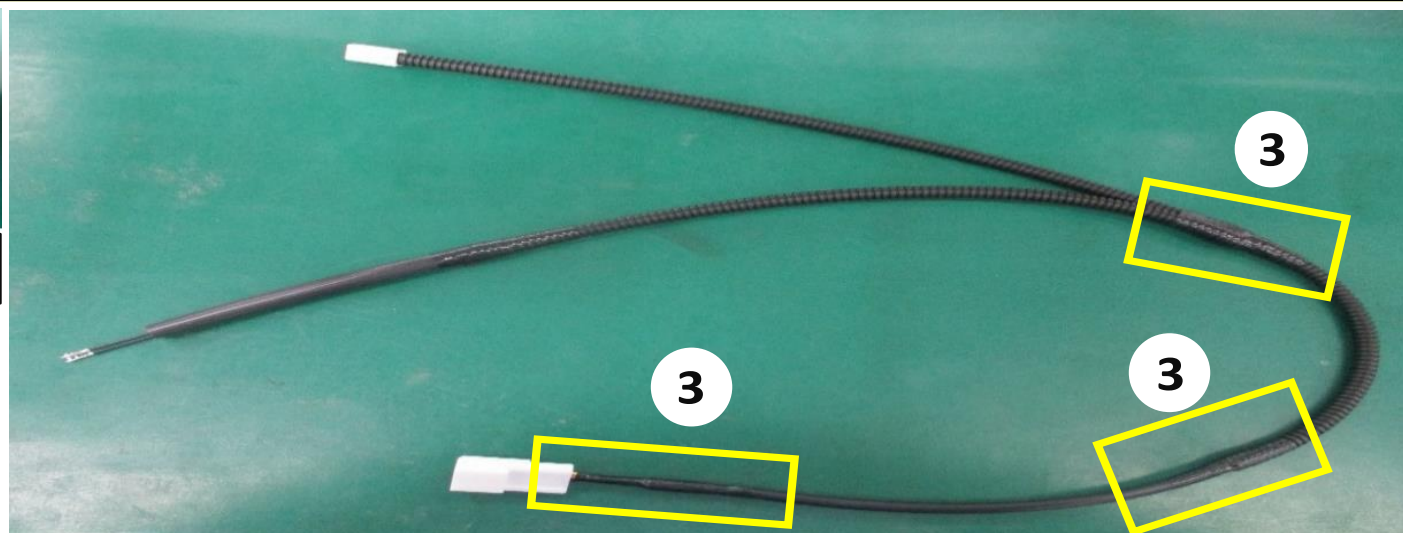
GOOD



NO



NO



3 No Missing Tape

**1 No Unlock/
Halflocked Connector**

**2 No Wrong Insert
(no wrong slot)**

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