

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**Model Code/Part Number **240B / 7M0514-7021**Customer: **TRJ**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

April 30, 2024

Validity Date:

n/a

Document No.:

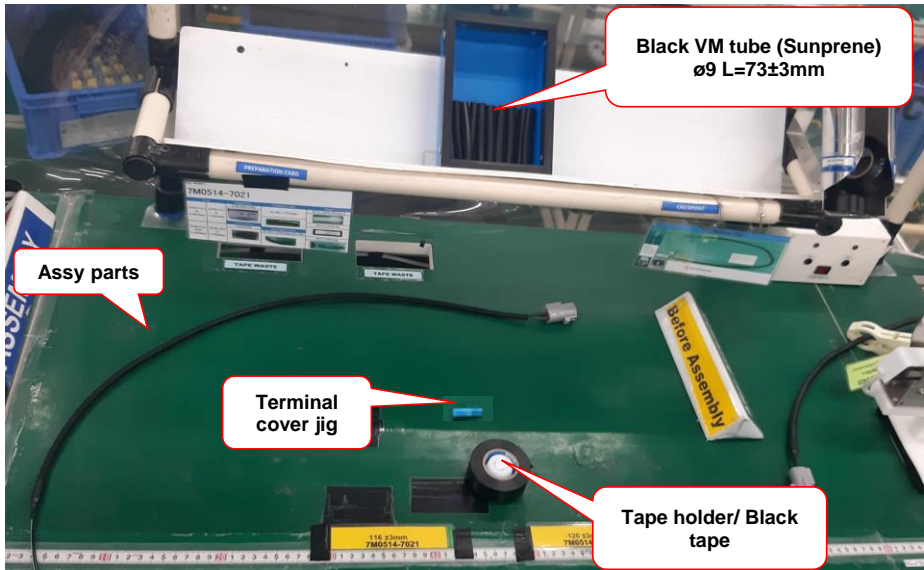



WI-ENG-PDE-440B

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PARTS:		1. All parts (Black VM tube (Sunprene) ø9 L=73±3mm; Assy parts; Black tape)						JIG:		1. Terminal cover jig									
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE		QUALITY POINTERS							
1		P2		Table Lay-out						<div><div>Table Lay-out</div><div></div></div>		<div><div>Safety Instruction</div><div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>		1. No missing parts/tools 2. No excess parts/tools					
												Prepared by		Reviewed by		Approved by		Noted by	
04/30/24		4		Additional Important reminders/Note/s in Process 2 (Page 2) due to customer claim countermeasure.						D.Castillo		C. Villanueva		A. Arañes		n/a		<div><div> D. Castillo</div><div> C. Villanueva</div><div> A. Arañes</div></div>	
03/31/23		3		Work instruction improvement. Transfer Black Corrugated tube to VM tube (Sunprene) taping from P3 to P2 (Page 3). Change term from sunprene tube to VM tube (Sunprene). Inclusion of quality checkpoints (Page 5).						D.Castillo		J. Loterte		C. Villanueva		A. Arañes			
09/21/22		2		Transfer Half-warp and Taping 2 (Black Corrugated tube to wire near connector 6188-0066 (GR) from P1 to P2. Transfer Clamp Setting, Clamp Assembly and Taping 3 (Black Corrugated tube to Sunprene tube) process to new stablish work instruction (WI-ENG-PDE-440C). Update Table lay-out.						K. Doria		J. Loterte		C. Villanueva		A. Arañes			
Eff. Date		Rev. No		Details of Change						Revised		Checked		Approved		Noted		Est. Date: March 29, 2022	

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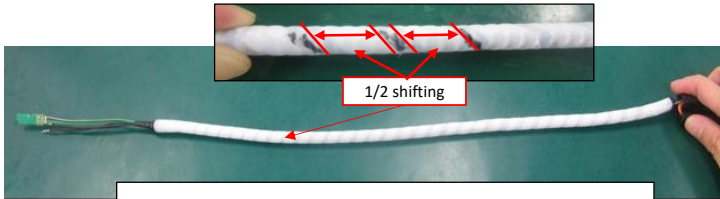
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PARTS:

1. Assy parts
2. Black tape [1pc]

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Half-wrap taping	<div><div><div>Start of taping</div><div>1. Hold the corrugated tube using left hand and begin taping using right hand.</div></div><div><div>1/2 shifting</div><div>2. Make 1/2 shifting. Repeat the process until the end of corrugated tube. Make 3 winds and then cut the tape.</div></div><div><div>1/2 shifting</div><div>3. Check the taping condition.</div></div></div>	n/a	<p>Important reminders/Note/s</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.2. Used <u>WHITE TAPE</u> to easily visualize the tape shifting, but actual should be <u>BLACK TAPE</u>.3. Internal tolerance for halfwrap taping shifting should be 0~14mm only. <div>4</div> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape

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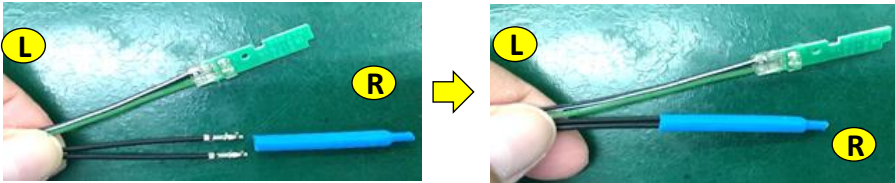
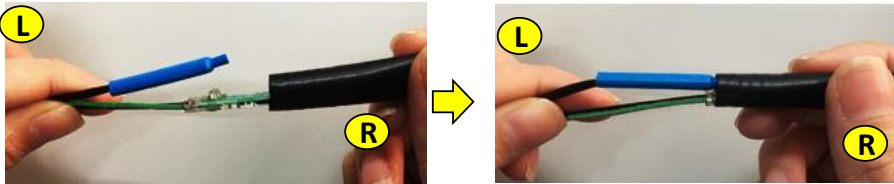
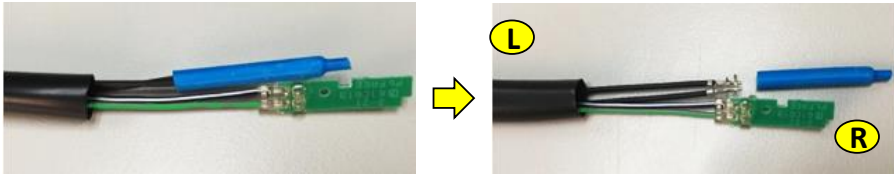

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PARTS:		1. Black VM tube (Sunprene) $\varnothing 9$ L=73 \pm 3mm		JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ L=73 \pm 3mm	 <p>1. Get the terminal cover jig using right hand then insert the terminal B-B wires using left hand.</p>  <p>2. Hold the Black VM tube (Sunprene) $\varnothing 9$ L=73\pm3mm using right hand then Insert first the hotmelted wires and then next the B-B wires with cover jig using left hand.</p>  <p>3. After insertion, remove the terminal cover jig using right hand.</p>		TERMINAL COVER JIG 	1. No wrong use of parts 2. No deformed terminal

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PARTS:		1. Assy parts 2. Black Tape [1pc]	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3 Taping 3 Black Corrugated tube to VM tube (Sunprene)	<p>VM tube (Sunprene) to edge of PCB</p> <p>58±3mm</p> <p>VM tube (Sunprene) to terminal pointed tip</p> <p>62±3mm</p> <p>1. Hold the assy parts using left hand. Measure from VM tube (Sunprene) to terminal pointed tip 62±3mm and PCB 58±3mm.</p> <p>2. Hold the assy parts using left hand. Get the Black tape and start taping using right hand.</p> <p>3. After taping, check the measurement and taping condition.</p>	<p>BENDING POSITION</p> <p>Conduct slightly bending</p> <p>MEASURING TAPE</p>	<p>1. Check the tape from COT to SV/VM tube (Conduct bending for verification)</p> <p>2.No flip out tape.</p> <p>3.No tape peeling.</p> <p>4.No loose tape</p> <p>5. No missing tape</p> <p>6. No wrong dimension</p> <p>7. No wrong use of tape</p> <p>Important reminder/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document references:</p> <p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</p> <p>2. GL-PRO-ASY-005 for Bending Guidelines to Check Missing tape</p>

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PARTS:

n/a

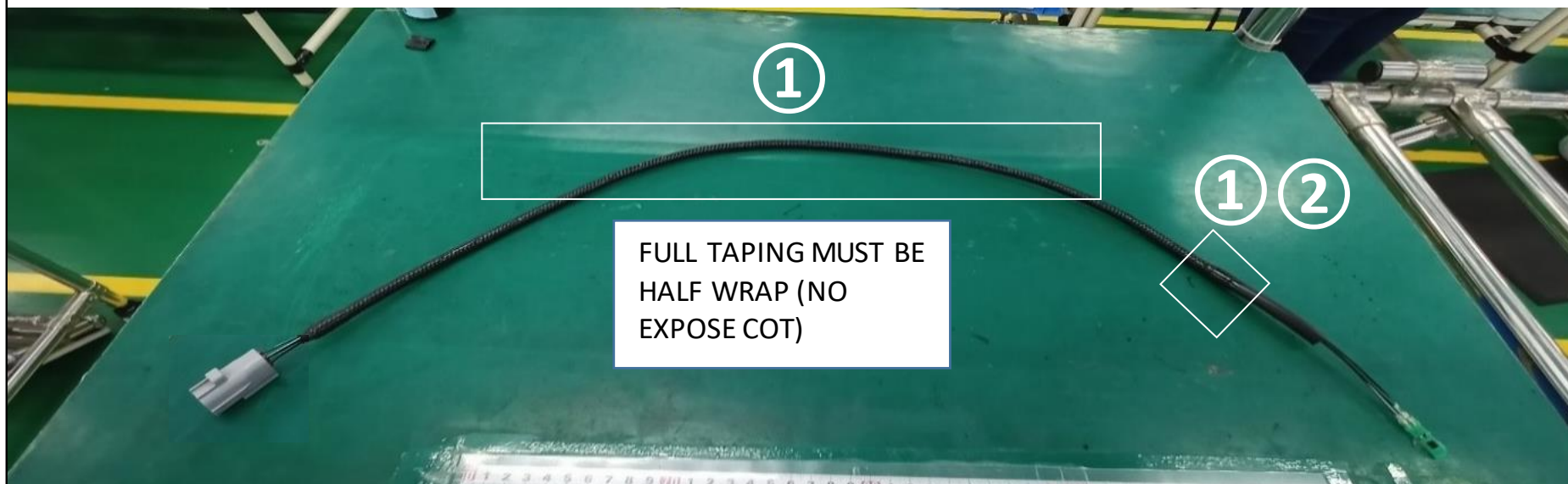
JIG

n/a

QUALITY CHECKPOINTS

P2

7M0514-7021



① No MISSING TAPE

② No MISSING VT

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