

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Product Name/Code:

480B**/****A7043E**

Customer:

TRQSS

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 03, 2021

Validity Date:

n/a

Document No.:

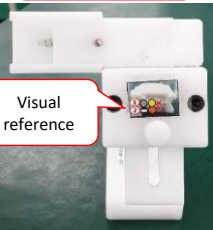
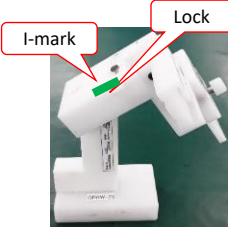

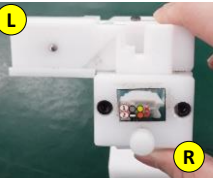
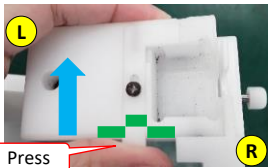
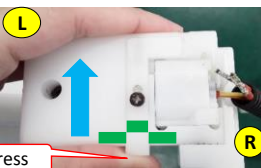
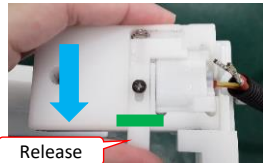

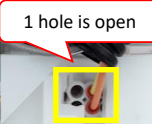




WI-ENG-PDE-185B

Revision No.:

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PARTS:		1. Assy parts				JIG:	1. Insertion jig						
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS			
1		P2 Connector setting to Insertion jig 6189-1142 (W)		<div><div><div>Insertion Jig</div><div><div>Visual reference</div></div></div><div><div><div>I-mark</div><div>Lock</div><div>Insertion Jig Orientation</div></div><div><div><div>Connector Orientation</div></div><div><div><div>L</div><div>R</div></div><div><div><div>L</div><div>R</div><div>Press</div></div><div><div><div>L</div><div>R</div><div>Press</div></div><div><div><div>Release</div></div><div><div>1. Press the lower wire guide using right thumb to make sure connector with inserted wires will be inserted.</div><div>2. Press the Insertion jig lock using left thumb. Get the assy parts and insert the connector using right hand.</div><div>3. After insertion, release the insertion jig lock using left thumb.</div></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><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><div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div></div></div></div></div></div></div>				<div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div><div>I-mark is align</div></div><div><div><div>1 hole is open</div></div><div><div>GOOD</div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector</div></div></div></div>					
Revision History													
05/03/21	4	Put measuring tape illustration and instruction in Y-taping process.				J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	Prepared by	Reviewed by	Approved by	Noted by
10/30/20	3	Transfer process owner from Production (WI-PRO-ASY-11B) to Engineering (WI-ENG-PDE-185B); Apply some improvements; Updated pictures				J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
07/10/17	0	Initial issue.				J. Monetealto/ L. Briones	O. Merin	T. Sugiyama	n/a	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change				Revise	Check	Approve	Noted	Est. Date:	July 10, 2017		

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PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

4

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P2

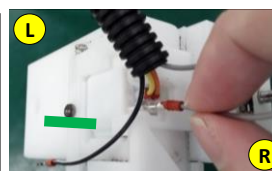
Wire insertion to
Connector
(Assy parts)



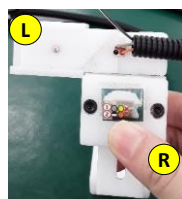
1. Hold the assy parts upward using left hand. Slot for GR wire must be open.



Wire facing



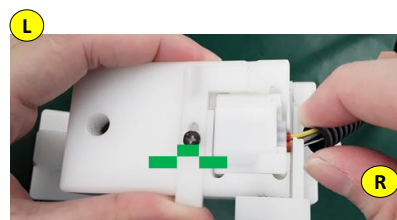
2. Insert the GR wire using right hand.



3. Press the push button using right hand. Slot for B/W wire will be open.



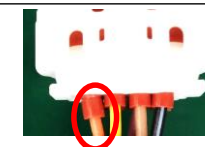
4. Insert the B/W wire using right hand.



5. After insertion, press the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.

n/a

Note: During insertion, hold the wire not rubber seal to prevent sagging.



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

Make sure wires are properly inserted.
Conduct **Pull-Push-Pull-Push** after insertion.
Do not exert extra force.

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PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts
2. Black tape

JIG

1. Locking jig

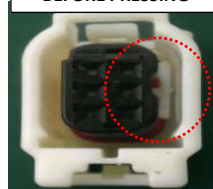
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

3

Connector lock



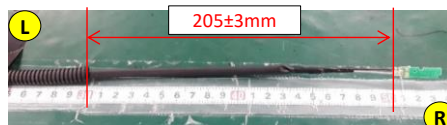
1. Put the connector into locking jig and push down to lock using right thumb.

BEFORE PRESSING**AFTER PRESSING****LOCKING JIG**

1. No unlock/Half-locked connector
2. No damaged lock

4

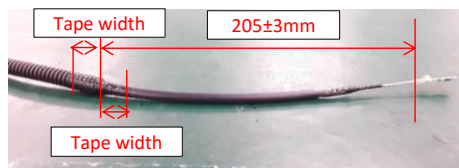
P2

Taping
COT to Vinyl tube

1. Hold the COT using left hand. Measure the end of COT up to the edge of Hotmelt **205±3mm** using right hand.



2. Hold the COT using left hand then start taping using right hand.
Refer to WI-PRO-ASY-001 for taping procedure.



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

MEASURING TAPE

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

Note:
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

5

P2

Y-Taping

L **No wide interval**

1. Fix the corrugated tube .

R

Note: Do not exert excessive force during pulling & winding of tape

tape width

2. Start taping at the middle of combined Corrugated tubes, then wind the tape going to 2 corrugated tubes , width must be same with tape (19mm)

3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)

taping direction

tape shifting 1/3 below

tape width

taping direction

tape shifting 1/2

4. Wind the tape backward 1/2 shifting.

Tape shifting 9mm below

Tape width

Tape width

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



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

Note:
Used **Yellow** tape to easily visualize the tape shifting.
But actual should be **Black**.

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wide interval between the COT
5. No wrong use of tape

Connector Orientation



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