

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 3, 2022

Model Code/Part Number

840B**7N0120-7020B**

Customer:

TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-318A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

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PARTS:

1. Assy parts: Connector 6098-3810 (W); AVSSf 0.3 B/B L=1175±3mm); Black Corrugated tube $\phi 5$ L=871±8mm (no slit); Black vinyl tube $\phi 5$ L=185±3mm

JIG:

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>1. No missing parts/tools 2. No excess parts/tools</p> <p><i>Note: Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></p>

Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Checked	Checked	Approved	Prepared by	Reviewed by	Approved by	Noted by
01/03/22	2	Change part number from 7N0120-7020A to 7N0120-7020B due to interchanged in clamp (82711-12A80(W) (82711-12A60 (W) location and quantity. Refer to (WI-ENG-PDE-318B). Additional checkpoint in checking of wire tolerance (Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance). Improve work procedure in all process.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
09/10/21	1	Revise due to transfer of insertion process to Kitting process (Refer to WI-ENG-PDE-332); Improve process illustration; Interchange taping process of COT to vinyl; COT to wire near terminal. Change from pre-launch to masspro.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
08/06/21	0	Initial issue	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				

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PARTS:

1. Assy parts

2. Black corrugated tube $\phi 5$ L= 871 \pm 8mm (no slit)3. Black vinyl tube $\phi 5$ L=185 \pm 3mm**JIG**

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black corrugated tube $\phi 5$ L=871 \pm 8mm (no slit)	   <p>1. Get the terminal cover jig using right hand then insert to B/B wires.</p> <p>2. Get the corrugated tube (no slit) $\phi 5$ L=871\pm8mm using right hand and insert to B/B wires.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>		1. No wrong use of parts 2. No deformed terminal
3	Wire insertion to Black vinyl tube $\phi 5$ L=185 \pm 3mm	 <p>1. Get the Black Vinyl tube $\phi 5$ L=185\pm3mm using right hand then insert the B/B wires.</p>	n/a	1. No wrong use of parts 2. No deformed terminal

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PARTS:

1. Assy parts
2. Black tape

JIG

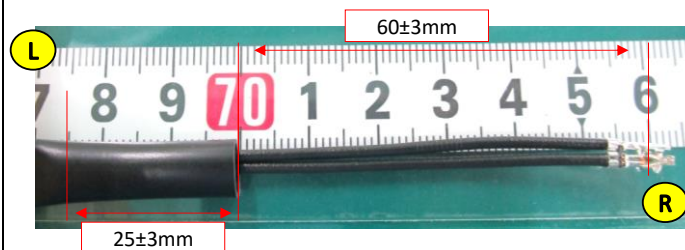
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

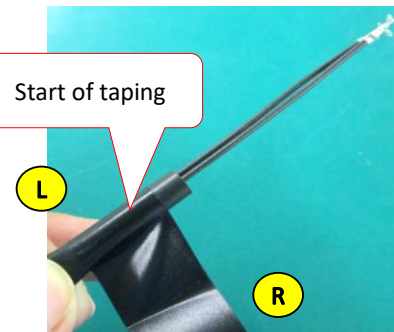
P1

Taping 1
Black vinyl tube to wire
near terminal

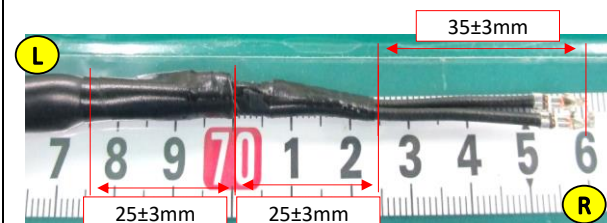


1. Hold the vinyl tube using left hand, measure from end of vinyl tube up to terminal tip **60±3mm**.

Start of taping



2. Hold the assy parts using left hand, get the **Black tape** using right hand then start taping process using both hands.

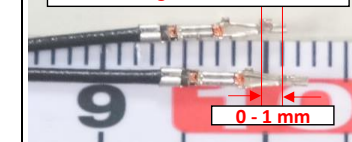


3. After taping, check the measurement, taping condition and wire alignment.

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

Wire alignment tolerance



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PARTS:

1. Assy parts
2. Black tape

JIG

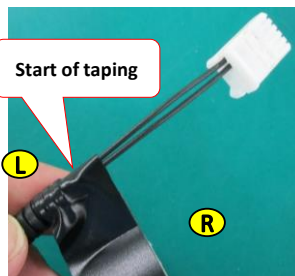
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

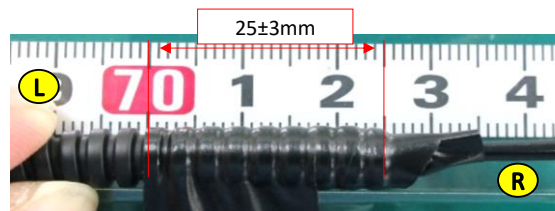
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P1

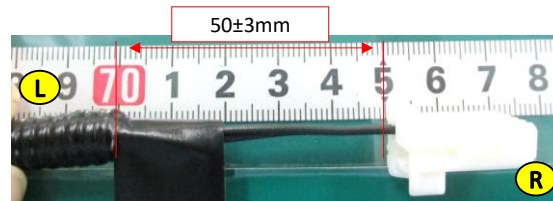
Taping 2
Black COT to wire near
connector



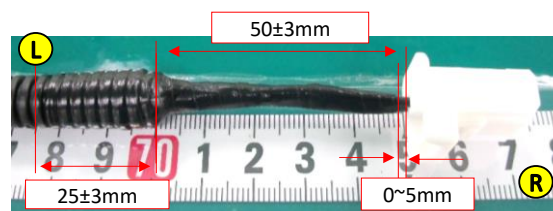
1. Hold the assy parts, get the **Black tape** using right hand then start taping process using both hands.
(Refer to WI-PRO-ASY-001 for taping procedure)



2. Confirm measurement of **25±3mm** from end of tape up to end of COT then continue the taping process using both hands.



3. Measure from end of COT up to edge of connector **50±3mm** then continue the taping process using both hands.



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

MEASURING TAPE

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

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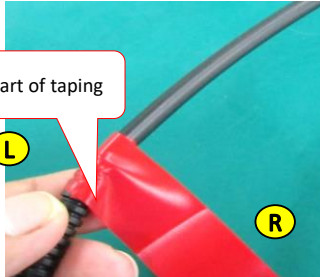
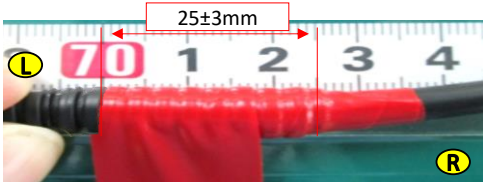

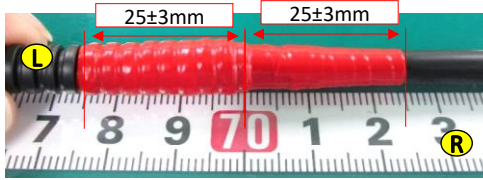

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PARTS:

1. Assy parts
2. Red tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 3 Black COT to Black vinyl tube	<div><p>no gap</p></div> <div><p>Start of taping</p></div> <div><p>1. Fix the COT and vinyl tube using both hands.</p></div> <div><p>25±3mm</p></div> <div><p>25±3mm</p></div> <div><p>25±3mm 25±3mm</p></div> <div><p>2. Hold the assy parts, get the Red tape using right hand then start taping process using both hands. (Refer to WI-PRO-ASY-001 for taping procedure)</p></div> <div><p>3. Confirm measurement of 25±3mm from end of tape up to end of COT then continue the taping process using both hands.</p></div> <div><p>4. Confirm measurement of 25±3mm from end of COT up to end of tape using both hands.</p></div> <div><p>5. After taping, check the measurement and taping condition.</p></div>	<p>MEASURING TAPE</p> 	<p>NOTE: USE RED TAPE ONLY.</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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