

	<b>WORK INSTRUCTION</b>				Effectivity Date:		July 9, 2021	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:				Document No.:		WI-ENG-PDE-224A	
	Product Name/Code: <b>587B / 7M0533-7020</b>		Customer: <b>TRJ</b>		Revision No.:		4	Page No.: 1 of 2
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO								

<b>PARTS:</b>	1. Pre-assy parts Connector 6188-0066 (GR) with inserted dummy seal; TVSSf 0.3 wires GR L=826mm; B/W L=826mm; Black COT $\phi 7$ L=650 $\pm$ 4mm (no slit)	JIG:	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1  Taping COT to wire near terminal	<div style="text-align: center;"> </div> <div style="text-align: center; margin-top: 10px;"> </div> <div style="text-align: center; margin-top: 10px;"> </div> <div style="margin-top: 10px;"> <p>1. Hold the corrugated tube using left hand, get the Black tape then start taping using both hands.</p> <p>2. Measure from end of corrugated tube up to terminal pointed tip <b>139<math>\pm</math>3mm</b> then continue the taping process.  <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p> <p>3. After taping, check the measurement, wire alignment and taping condition.</p> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Housekeeping</b>            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; margin-bottom: 10px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>MEASURING TAPE</b>  </div>	<div style="text-align: center; margin-bottom: 10px;"> </div> <div> <p>1. No loose tape</p> <p>2. No flip-out tape</p> <p>3. No peel-off tape</p> <p>4. No wrong use of tape</p> <p>5. No wrong dimension</p> <p style="color: red; margin-top: 10px;"><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></p> </div>

Revision History								Prepared by		Reviewed by	Approved by	Noted by
07/08/21	4	Removal of validity date	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	 J. Loterte	 C. Villanueva	 A. Shimamura	 A. Arañes		
01/20/21	3	Transfer process owner from Production (WI-PRO-ASY-059A) to Engineering (WI-ENG-PDE-224A); Change taping procedure of COT to wire near terminal;	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes						
07/09/19	2	Include process distribution	A. Roxas	W. Carbillon	O. Merin	n/a						
11/03/17	0	Initial issue.	J. Montealto/ L. Briones	O. Merin	T. Sugiyama	n/a						
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Note	Est. Date:	July 30, 2020				

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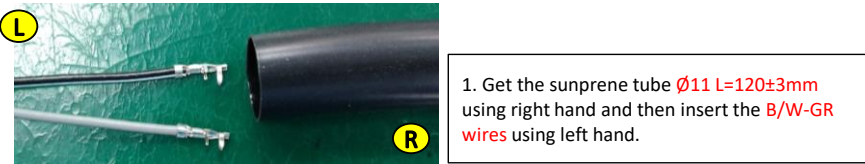

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Black Sunprene tube $\varnothing 11$ L=120 $\pm$ 3mm 2. Black tape			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to Sunprene tube $\varnothing 11$ L=120 $\pm$ 3mm				1. No wrong use of parts 2. No deformed terminal
3		Taping COT to Sunprene tube	 <p>1. Measure from end of sunprene tube up to terminal pointed tip 39<math>\pm</math>3mm.</p> <p>2. Hold the sunprene tube using left hand, get the Black tape then start taping process using both hands. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p> <p>MEASURING TAPE</p> <p>3. After taping, check the measurement and taping condition.</p>			<p><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension</p>

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