



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **011B / 7M0365-7020A**

Customer: **TRJ**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 18, 2021

Validity Date:

n/a

Document No.:

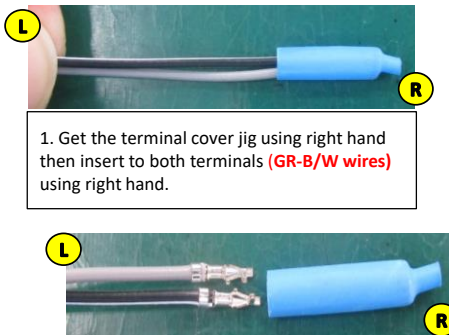
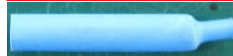
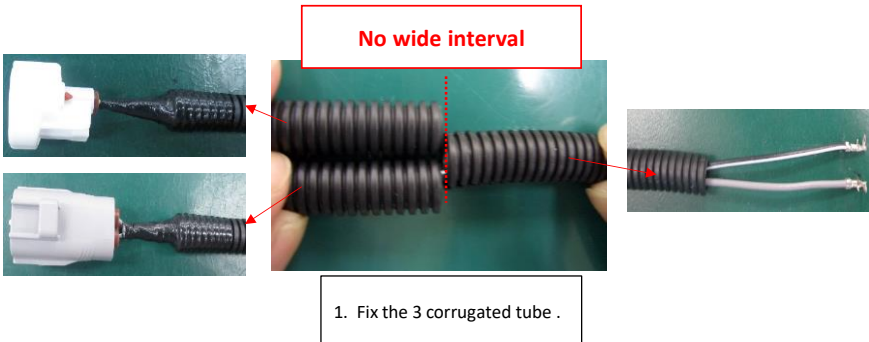
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PARTS:		1. Assy parts 2. Black corrugated tube (no slit) Ø5 L=435±4mm 3. Black tape		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2	 <p>1. Get the terminal cover jig using right hand then insert to both terminals (GR-B/W wires) using right hand.</p> <p>2. Hold the COT $\phi 5 L=435\pm 4mm$ using right hand then insert the GR-B/W wires using left hand.</p> <p>3. After insertion, remove the cover jig using right hand.</p>		<p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <p>TERMINAL COVER JIG</p> 	1. No wrong insertion 2. No deformed terminal
2		 <p>1. Fix the 3 corrugated tube .</p>			1. No wrong facing of connector

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/18/21	4	Removal of validity date. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
11/11/20	3	Transfer process owner from Production (WI-PRO-ASY-019A) to Engineering (WI-ENG-PDE-193B). Apply some improvements/update pictures.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
07/10/17	0	Previously established as Production work instruction (WI-PRO-ASY-019). Initial issue	J. Montecito L. Briones	O. Merin	T. Sugiyama	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
							Est. Date:	July 10, 2017		

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PARTS:

4

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

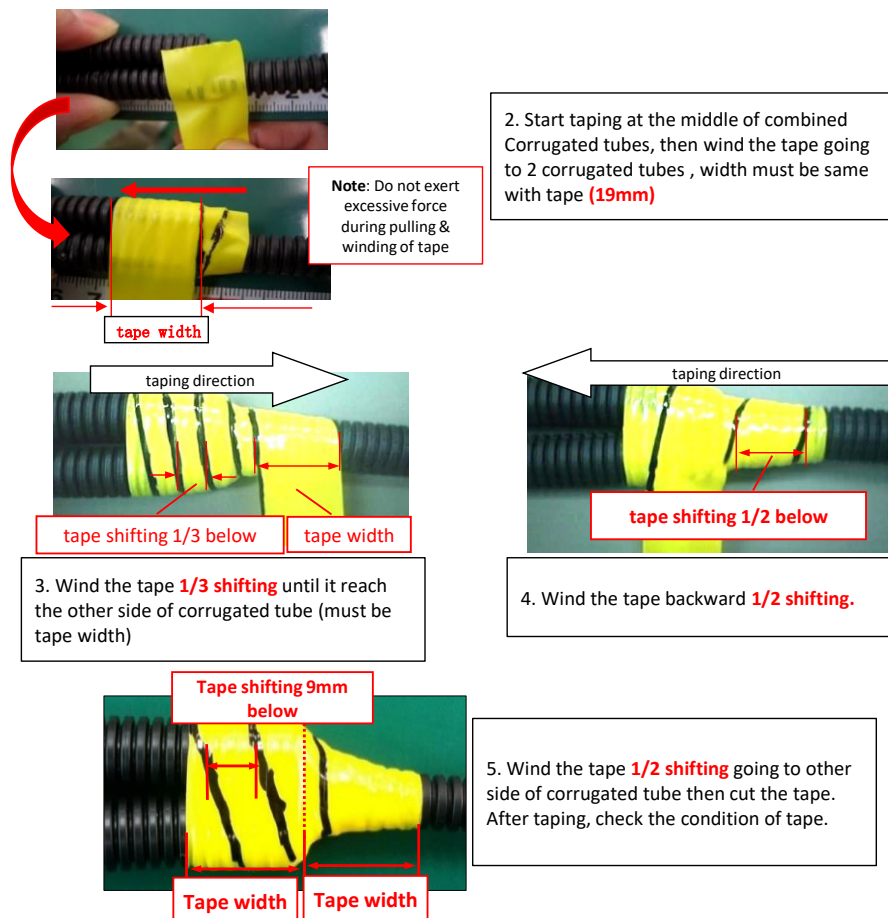
TOOLS/PPE

QUALITY POINTERS

2

P2

Y-Taping
(Continuation)



n/a

4

NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong dimension
6. No wrong use of tape

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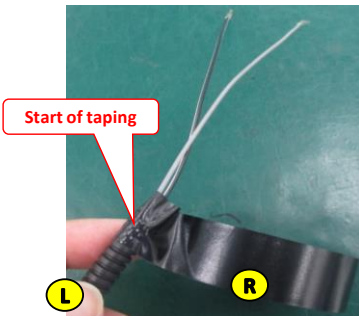
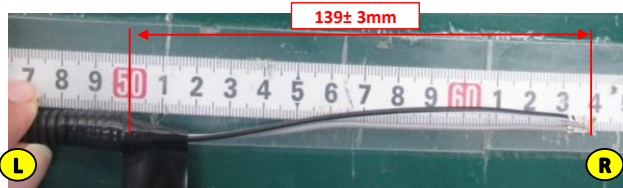
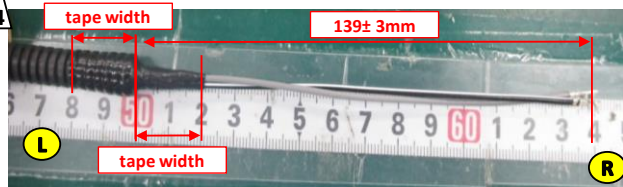

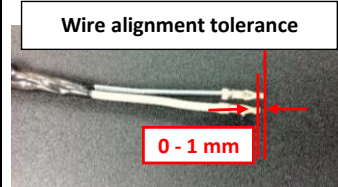
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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 1 Black corrugated tube to wire near terminal	<div><p>1. Hold the corrugated tube using left hand and start taping using right hand.</p></div> <div><p>2. Measure from end of the corrugated tube up to terminal tip 139±3mm and then continue the taping process. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p></div> <div><p>3. After taping, check the measurement, wire alignment and taping condition.</p></div>	<div>MEASURING TAPE </div>	<div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div> <div>Wire alignment tolerance <p>0 - 1 mm</p></div>

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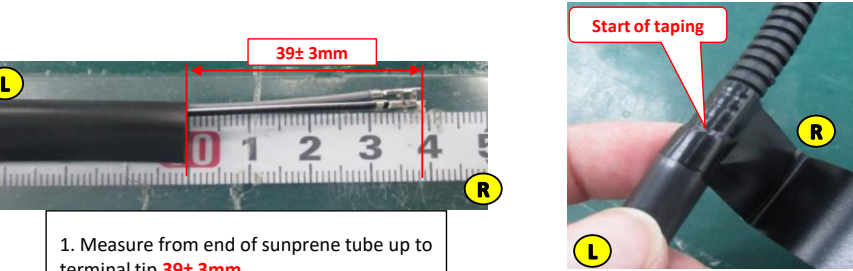


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PARTS:		1. Assy parts 2. Black sunprene tube Ø9 L=120±3mm 3. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black sunprene tube Ø9 L=120±3mm	 <p>1. Hold the sunprene tube $\phi 9$ L=120±3mm using right hand then insert the GR-B/W wires using left hand.</p>	n/a	1. No wrong use of parts 2. No damaged terminal
5	Taping 2 Black corrugated tube to Black sunprene tube	 <p>1. Measure from end of sunprene tube up to terminal tip 39 ± 3mm.</p> <p>2. Hold the sunprene tube using left hand and then start taping process using right hand. Note: Refer to WI-PRO-ASY-001 for taping procedure.</p>  <p>3. After taping, check measurement and taping condition.</p>	 <p>MEASURING TAPE</p>	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape Note: Please use calibrated/verified measuring tape when getting the measurement.

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