



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 20, 2021

Process Name/Title:

Validity Date:

n/a

Product Name/Code:

550B



7L0082-7022

Customer:

TRQSS

Document No.:

WI-ENG-PDE-019A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

4

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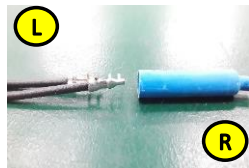


PARTS:

1. Assy parts (Connector 6098-3802 (W) ; AVSSf 0.3 B wires L=799mm [2pcs]
2. Vinyl tube ø5 L=213±3mm

3. Black Corrugated tube ø5 L=394±3mm (no slit)
4. Sunprene tube ø5 L=130±3mm

JIG:

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Wire Insertion to Vinyl tube ø5 L=213±3mm	 <p>Hold the assy part using left hand then get the Vinyl tube ø5 L= 213±3mm using right hand and insert the Black wires.</p>	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p>	<ol style="list-style-type: none"> 1. No wrong usage of parts. 2. No deformed terminal.
2	Wire Insertion to Corrugated tube ø5 L=394±3mm (no slit)	  <p>2. Get the corrugated tube ø5, L=394±3 (no slit) using right hand and insert to wires.</p> <p>1. Hold the wires using left hand, get the terminal cover jig using right hand and insert the wires.</p>  <p>3. After insertion, remove the terminal cover jig using right hand.</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>Terminal cover jig</p>  <ol style="list-style-type: none"> 1. No wrong usage of parts. 2. No deformed terminal.
3	Wire Insertion to Sunprene tube ø5 L=130±3mm	 <p>Hold the assy part using left hand then get the sunprene tube ø5 L= 130±3mm using right hand and insert the Black wires.</p>		<ol style="list-style-type: none"> 1. No wrong usage of parts. 2. No deformed terminal.

Revision History

Eff. Date	Rev. No	Details of Change	Prepared by:	Checked by:	Approved by:	Noted by:
05/20/21	4	Change part number from 7L0082-7021 to 7L0082-7022 due to change Vinyl tube length from L=188mm to L=213mm. Transfer Connector setting, Wire insertion and Connector lock process to Kitting.	D.Castillo	C. Villanueva	A. Shimamura	A. Arañes
05/03/21	3	Change connector colors in accordance with color standardization for plastic parts refer to GL-COM-003. Remove validity date. Add tape quantity.	D.Castillo	C. Villanueva	A. Shimamura	A. Arañes
07/16/19	n/a	Previously established Engineering Instruction(EI-ENG-PDE-098).Initial issue.	J. Loterte	A. Shimamura	A. Arañes	n/a
Est. Date:	July 8, 2019					

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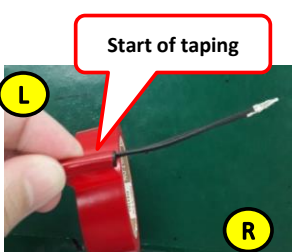
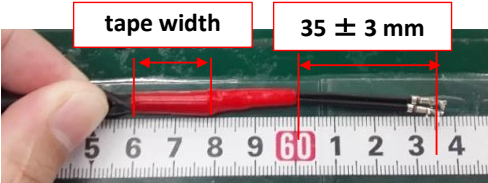

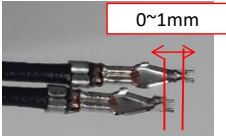
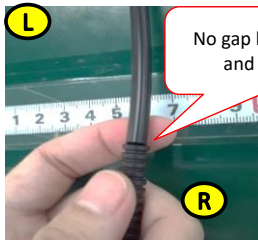
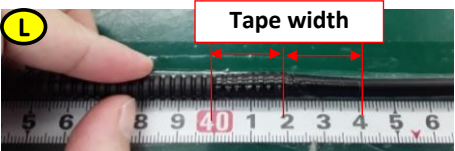

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Red tape [1pc] 2. Black tape [1pc]	3. . Assy parts	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 1 Sunprene tube to wire near terminal	 <p>1. Hold the sunprene tube using left hand. Measure from sunprene tube up to terminal pointed tip 55±3mm.</p>  <p>2. Get Red tape using right hand, hold the sunprene tube (ø5 L=130±3mm) using left hand then fold the sunprene tube and start taping using right hand. Refer to WI-PRO-ASY-001 for taping procedure</p>  <p>3. After taping check the measurement, wire alignment and taping condition.</p>		<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Measuring tape</p> 	<p>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</p>  <p>Wire alignment tolerance 0~1mm</p>
5	P1 Taping 2 COT to Sunprene tube	 <p>1. Fix the corrugated tube to Sunprene tube using left hand and start taping using right hand. Note: Please refer to WI-PRO-ASY-001 for taping procedure.</p>  <p>2. Check the measurement and taping condition after taping.</p>		<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Measuring tape</p> 	<p>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</p>

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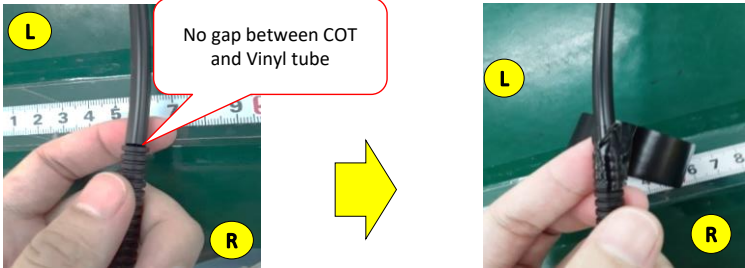


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PARTS:		1. Black tape [1pc] 2. Assy parts	JIG	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 3 Corrugated tube to Vinyl tube	<div><p>1. Fix the corrugated tube to Vinyl tube using left hand and start taping using right hand. Note: Please refer to WI-PRO-ASY-001 for taping procedure.</p><p>2. Check the measurement and taping condition after taping.</p></div>	<div>Measuring tape</div> 	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No loose tape2. No peel-off tape3. No flip-out tape4. No wrong dimension5. No wrong use of tape6. No missing tape

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