



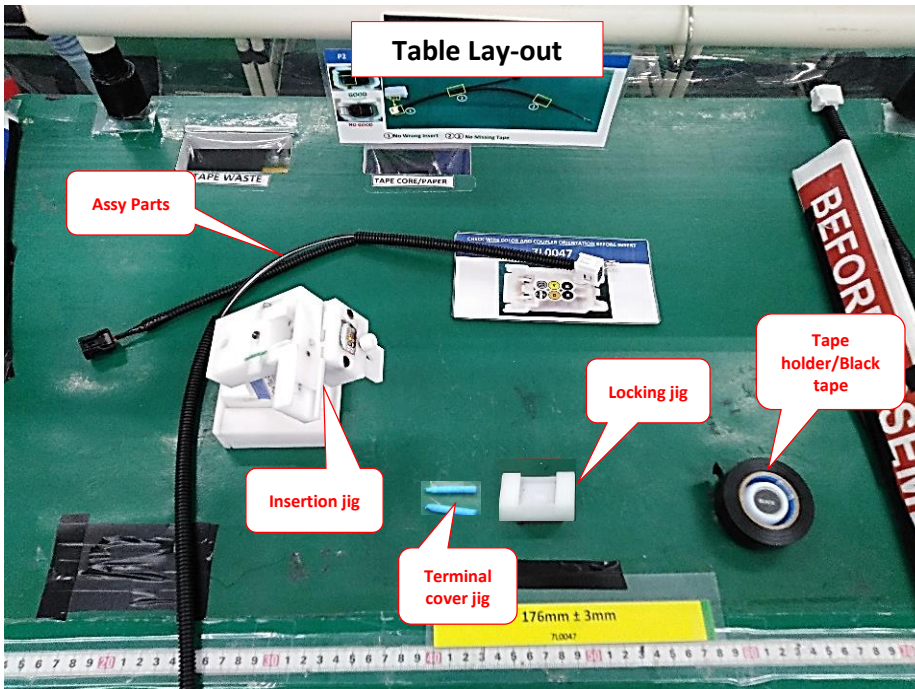
WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	January 24, 2022		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-173B		
Revision No.:	5	Page No.:	1 of 6

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number: **370B / 5 7L0047-7023** Customer: **TRQSS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts 2. Black tape [1pc.]		JIG:	1. Insertion jig 2. Terminal cover jig 3. Locking jig
NO.	PROCESS NAME	5 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2 5 Table Lay-out			<div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
01/24/22	5	Change part number from 7L0047-7022 to 7L0047-7023 due to additional quantity of clamp (82711-52090 (W) from 2 pcs. to 3pcs. (Refer to WI-ENG-PDE-173C). Improve work procedure and illustration. Additional table lay-out.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
03/29/21	4	Change connector color in accordance with color standardization for plastic parts refer to GL-COM-003; Put assy parts in pg. 4-5 parts section	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
09/24/20	3	Transfer process owner for Production (WI-PRO-ASY-074B) to Engineering (WI-ENG-PDE-173B) Apply some improvements/pictures	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted

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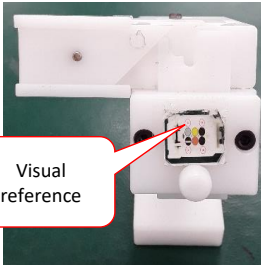
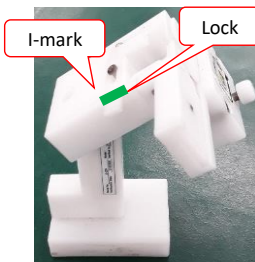

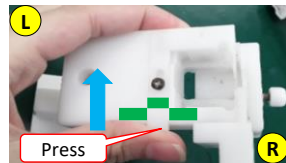
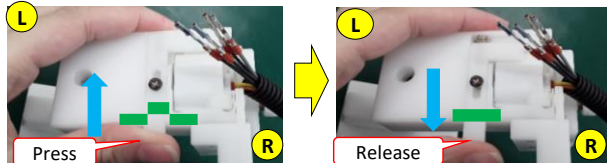
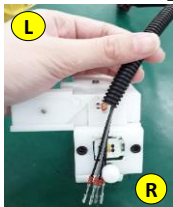
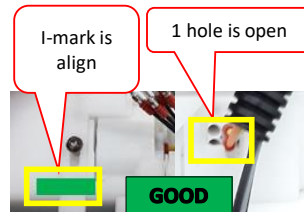
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PARTS:		1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Connector setting to insertion jig 6189-1142 (W) (Assy parts)	<div><div><p>Visual reference</p></div><div><p>Insertion Jig Orientation</p></div><div><p>Connector Orientation</p></div><div><p>Press</p></div><div><p>Press</p><p>Release</p></div><div><p></p></div><div><p>1. Press the insertion jig lock using left hand.</p><p>2. Get the connector 6189-1142 (W) using right hand and insert to insertion jig. Release the lock after insertion.</p><p>3. Push the lower wire guide upward using right hand. Slot for Gray wire will be open.</p></div></div>		n/a	<div><p>CONNECTOR ORIENTATION ILLUSTRATION</p><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p></div> <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>

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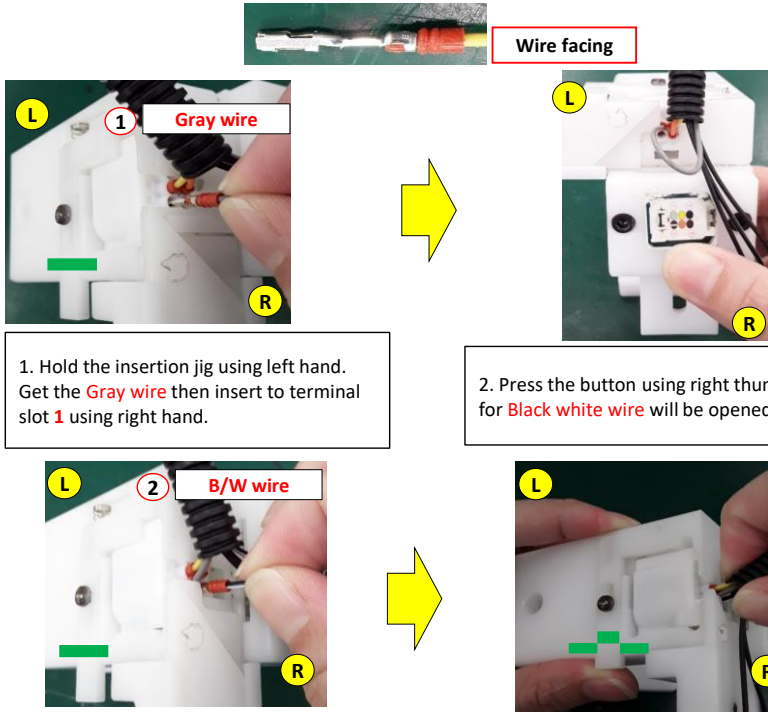
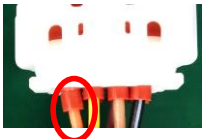
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PARTS:		1. Assy parts			JIG	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
3	P2	<div>Wire insertion to connector 6189-1142 (W)</div> <div><p>1. Hold the insertion jig using left hand. Get the Gray wire then insert to terminal slot 1 using right hand.</p><p>2. Press the button using right thumb. slot for Black white wire will be opened.</p><p>3. Get the Black white wire then insert to terminal slot 2 using right hand.</p><p>4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div>			n/a	<div>Note: During insertion, hold the wire not rubber seal to prevent sagging.</div>  <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>5 Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>	

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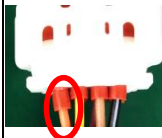

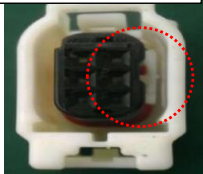


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PARTS:		1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Wire insertion to connector 6189-1142 (W) (continuation)	<div><div>Connector Orientation</div><div>5. Hold the connector using left hand and insert first Black wire to connector using right hand. <i>Note: Insertion starts from left to right</i></div></div> <div><div><div>Wire facing</div><div>6. Hold the connector using left hand and insert second Black wire to connector using right hand.</div></div></div>		n/a	 <div>Note: During insertion, hold the wire not rubber seal to prevent sagging.</div> <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div>
5		Connector lock	<div><div>1. Put the connector into locking jig and push down using right thumb.</div></div> <div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div></div>		LOCKING JIG 	<div>1. No unlock/Half-locked connector 2. No damaged lock</div>

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PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

6

P2

Taping 1
Corrugated tube to
Sunprene tube



1. Measure the end of the corrugated tube up to the edge of hotmelt and terminal pointed tip **176mm**.



2. Hold corrugated tube 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 jig



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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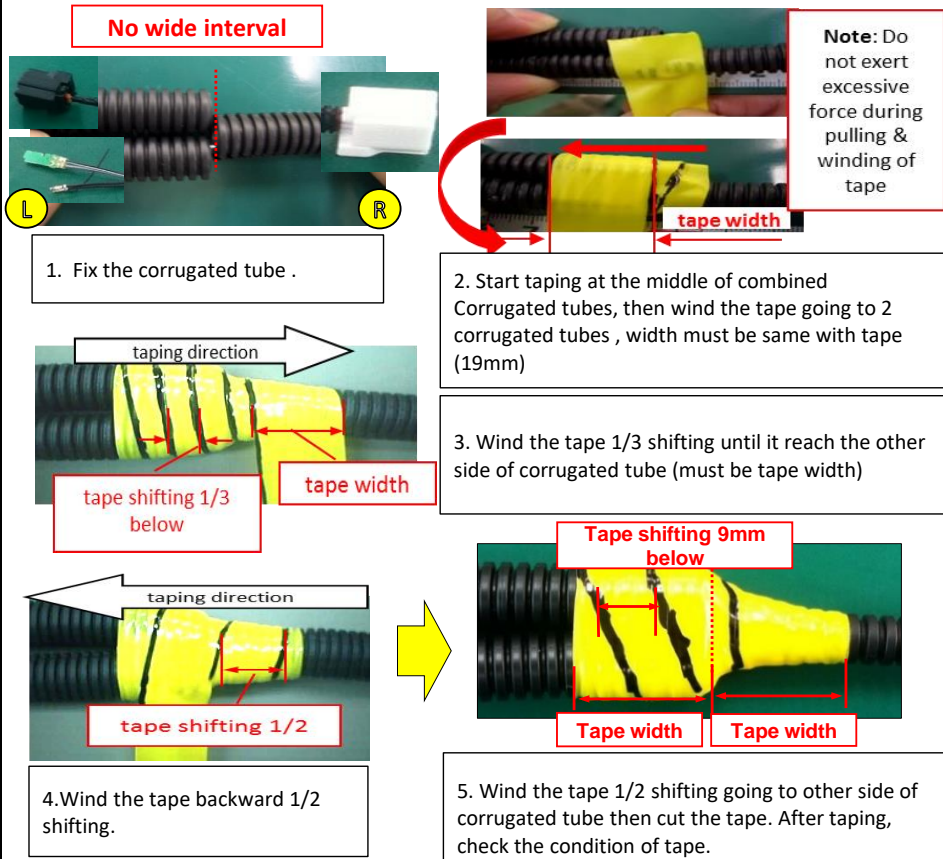
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PARTS:		1. Black tape 2. Assy parts	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P2	Y-Taping 	n/a	<p>Note: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape

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