

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

Effectivity Date:

June 22, 2021Product Name/Code: **100B / 7M0594-7020D**Customer: **TRJ**

Validity Date:

n/aPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:


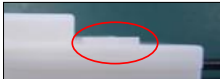
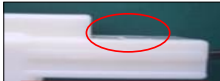






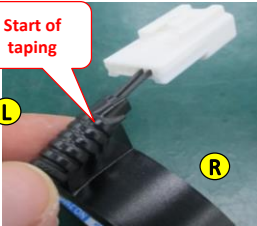
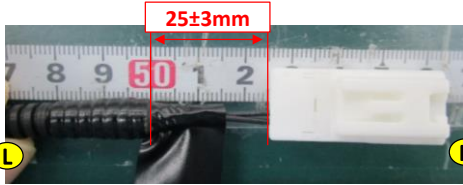
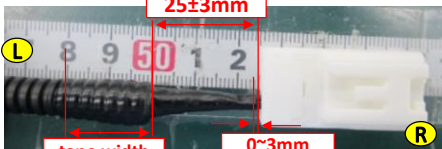
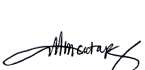





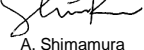





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PARTS:		1. Assy parts 2. Black tape				JIG:		1. Locking jig									
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS									
1	Connector lock	<div><div></div><div><p>Put the connector into locking jig using right hand then press 2x to lock using both hands. Touch the connector lock to confirm if properly locked. <i>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</i></p></div><div><p>Before pressing</p><p>After pressing</p></div><div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div></div> <div><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>MEASURING TAPE</p></div> <td><div><p>LOCKING JIG</p></div><div><p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p></div><div><p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p></div></td>				<div><p>LOCKING JIG</p></div> <div><p>NOTE: MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p></div> <div><p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p></div>											
2	P2 Taping 1 Black corrugated tube to wire near connector	<div><div><p>Start of taping</p></div><div><p>1. Hold the corrugated tube using left hand, get the black tape then start taping process using both hands.</p></div><div><p>25±3mm</p><p>2. Measure from end of the corrugated tube up to connector 25±3mm then continue the taping process using both hands. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure</i></p></div><div><p>25±3mm</p><p>tape width 0~3mm</p><p>3. After taping, check the measurement and tape condition.</p></div></div> <div><p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p><p>MEASURING TAPE</p></div> <td><p>Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p><div><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</p></div></td>				<p>Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p> <div><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</p></div>											
Revision History						Prepared by		Reviewed by		Approved by		Noted by					
06/22/21	3	Transfer process owner from Production (WI-PRO-ASY-122B) to Engineering (WI-ENG-PDE-286B). Apply some improvements and update picture in all process.				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes								
03/17/20	2	Include locking jig				J. Silang	A. Morcozo	O. Merin									
04/10/18	n/a	Previously established as Engineering instruction (EI-ENG-PDE-030). Initial issue				D. Castillo	R. Alcantara	A. Arañes	n/a								
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted	Est. Date:		April 10, 2018					

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☐ PRE-LAUNCH

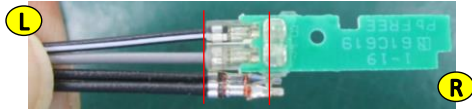
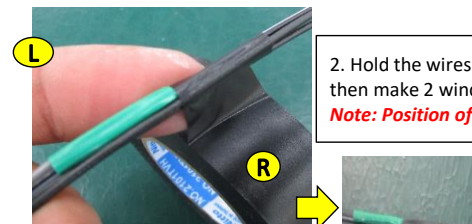

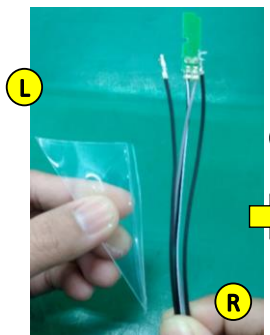
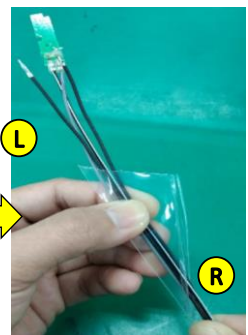
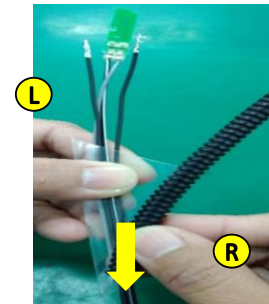


☒ MASSPRO

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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	Taping 2 Spot taping	  	n/a	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape
4	Wire insertion to Black Corrugated tube (w/slit) ø5 L=410±3mm	   	COT Adaptor 	1. No wrong use of parts 2. No wires left between COT with slit

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

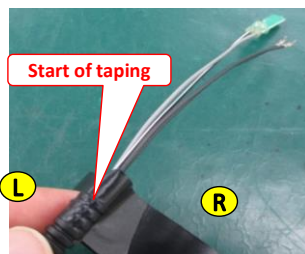
TOOLS/PPE

QUALITY POINTERS

5

P2

Taping 3
Black Corrugated tube
(w/slit) to wire near PCB
and terminal tip



1. Hold the corrugated tube using left hand then start taping using right hand.



2. Measure from end of the corrugated tube up to hotmelted wires **131±3mm** then continue the taping process using both hands.
Note: Refer to WI-PRO-ASY-001 for taping procedure



3. After taping, check the measurement and tape condition.

MEASURING 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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1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

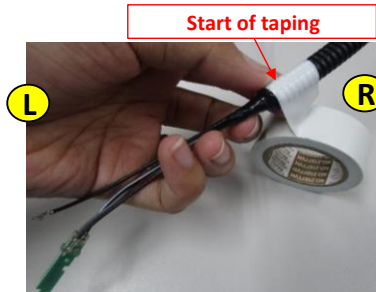
TOOLS/PPE

QUALITY POINTERS

6

P2

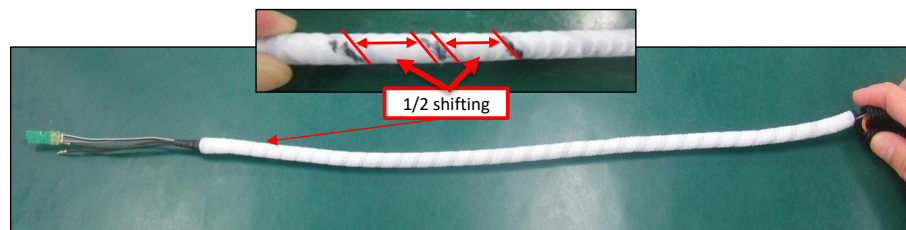
Taping 4
Half-wrap taping



1. Hold the corrugated tube using left hand and begin taping using right hand.



2. Make **1/2 shifting**. Repeat the process until the end of corrugated tube. Make **3 winds** and then cut the tape.



3. Check the taping condition.

MEASURING 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

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

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