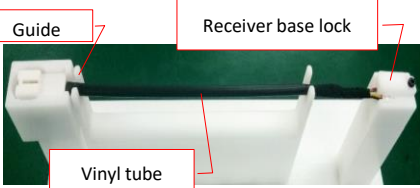
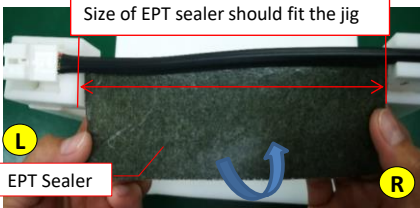
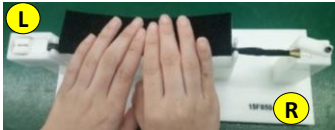
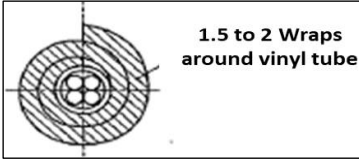



	<b>WORK INSTRUCTION</b>				Effectivity Date:		June 28, 2021	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:		Product Name/Code: <b>RE7 / 15F855-0050</b>		Customer: <b>TRP</b>		Document No.: WI-ENG-PDE-022C	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		5	Page No.: 1 of 3

<b>PARTS:</b>	1. EPT Sealer No.686 170x52x3 2. Assy parts	<b>JIG:</b>	1. EPT sealer attachment jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3 EPT Sealer attachment	<div style="display: flex; flex-direction: column; align-items: center;">  <p>1. Set the harness to EPT sealer attachment jig and lock the receiver base lock. Make sure vinyl tube was not offset to jig.</p>  <p>2. Get the EPT sealer and attached initially at the bottom part of vinyl tube. (See illustration). Slowly wrap the EPT sealer on the vinyl tube in clockwise direction. Make 1.5 to 2 wraps around the vinyl tube.</p>  <p>3. Flatten the EPT sealer during attachment to maximize the length and to avoid shrinkage.</p>  <p>1.5 to 2 Wraps around vinyl tube</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;"> <b>Alert level</b>          For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.       </div>	<div style="margin-bottom: 10px;">         1. No peel-off attachment   </div> <div>         2. No loose/tight attachment          3. No wrong attachment          4. Must be 1.5 to 2 wraps around vinyl tube.       </div>

Revision History				Prepared by		Reviewed by	Approved by	Noted by
06/28/21	5	Removal of validity date.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	   	   
01/28/21	4	Change over-all length from 243mm to 246mm as per customer request; Change effective and validity date	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes		
12/18/20	3	Put assy parts in Parts section for page 1~2; Update Effective and validity date.	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes		
02/08/19	n/a	Previously established as Engineering Instruction (EI-ENG-PDE-068). Initial issue.	R. Alcantara	A. Shimamura	A. Arañes	n/a		
Eff. Date	Rev. No	Details of Change		Revise	Check	Approve	Noted	Est. Date: February 08, 2019

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DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

June 28, 2021

Product Name/Code:

**RE7 / 15F855-0050**

Customer:

**TRP**

Validity Date:

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**PARTS:**

1. Assy parts

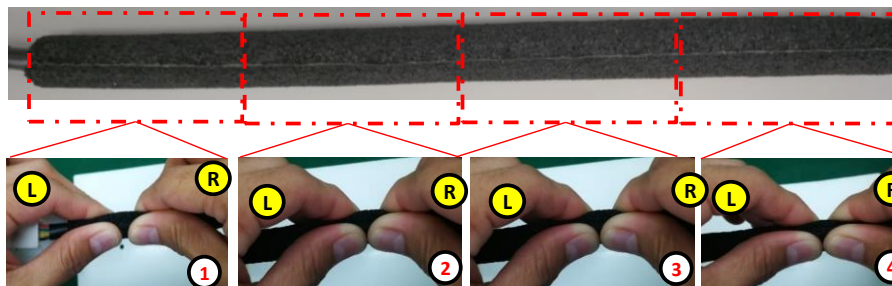
JIG:

N/A

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P3

EPT Sealer attachment  
(continuation)

4. After attachment of EPT sealer, press using left and right thumb from left to right direction until all edge was pressed.  
Make sure all surface was pressed.

n/a

1. No peel-off attachment



2. No loose/tight attachment  
3. No wrong attachment  
4. Must be 1.5 to 2 wraps around vinyl tube.

*Note: Please refer to WI-PRO-ASY-159 for Continuity test and WI-PRO-ASY-167 for End Tape Process.*

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

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June 28, 2021

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Validity Date:

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Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	N/A			JIG:	N/A		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
2	P3	Visual/By two's Inspection	<div><div>1. Check the double lock, terminal condition and presence of clamp</div><div>2. Check the EPT sealer attachment</div><div>3. Check the taping condition.</div><div></div><div>4. Check the presence of terminal claw on connector holes</div><div>5. Compare to Master sample. <i>Note: Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.</i></div><div></div></div> <td></td> <td>MASTER SAMPLE</td>				MASTER SAMPLE
3	P3	Measurement	<div></div> <div><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div></div> <td><b>FOR HATSUMONO AND OWARIMONO</b></td>			<b>FOR HATSUMONO AND OWARIMONO</b>	

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