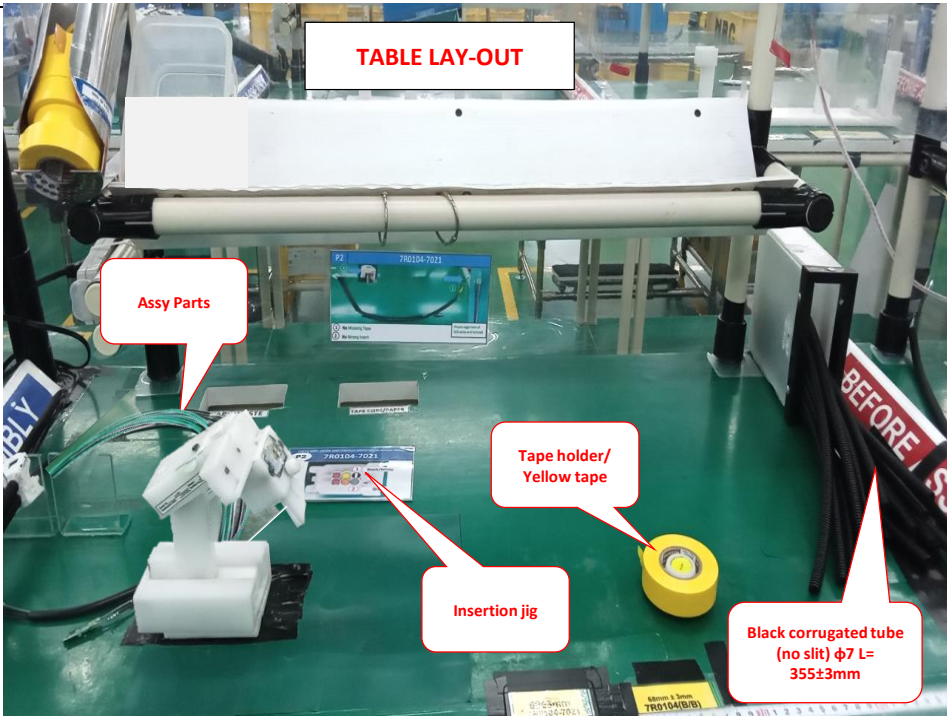
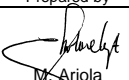



	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effect: January 28, 2022		February 14, 2022	
	Process Name/Title:				Valid:		n/a	
	Model Code/ Part Number: 780B / 7R0104-7022		Customer: TRMX		Document No.:		WI-ENG-PDE-391B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 1 of 5

PARTS:		1.All Parts; Assy parts; MRSW CP L0125-7R01040-7040 TVSSf 0.3 B/W L=757±3mm; G wires L=757±3mm; AVSSf 0.3 B wires L=756±3mm [2pcs.]; Yellow tape [1pc]				JIG:		1.Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P2 Table Layout					<div style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px;"> Housekeeping 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;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		<div style="border: 1px solid red; padding: 5px;"> Note: Please refer to WI-PRO-CNC-017 for Wire and Strip Length tolerance </div> 1. No missing parts/tools 2. No excess parts/tools	

				Prepared by		Reviewed by		Approved by		Noted by	
											
02/14/22	0	Initial issue.		M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:		February 14, 2022	

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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Model Code/ Part Number: 780B / 7R0104-7022

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Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts
2. Yellow tape

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

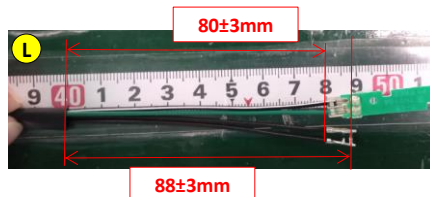
TOOLS/PPE

QUALITY POINTERS

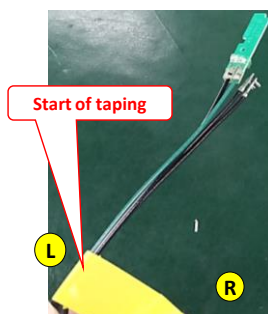
2

P2

Taping 2
Black sunprene tube to
wire near terminal and
hotmelted wires

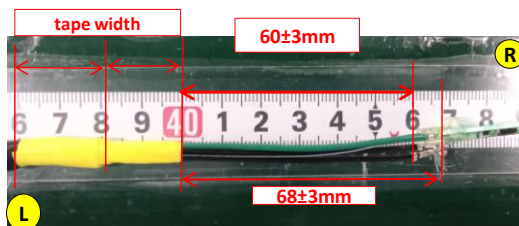


1. Hold the sunprene tube using left hand. Measure from end of sunprene up to the edge of hotmelted wires **80±3mm** and up to terminal pointed tip **88±3mm** using right hand.



2. Hold the sunprene tube using left hand. Get the **Yellow tape** using right hand then start taping process using both hands. **Refer to WI-PRO-ASY-001 for taping procedure.**

MEASURING TAPE



3. After taping, check the measurement, wire alignment and taping condition.

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

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

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Model Code/ Part Number: **780B / 7R0104-7022**Customer: **TRMX**

Document No.:


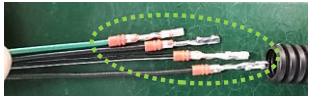


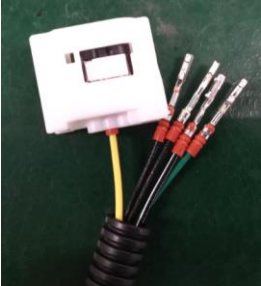
WI-ENG-PDE-391BPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts 2. Black corrugated tube (no slit) $\phi 7$ L= 355 \pm 3mm			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	Wire insertion to Black corrugated tube (no slit) $\phi 7$ L= 355 \pm 3mm	 <div data-bbox="730 587 1406 708">1. Hold the wires using left hand, get the corrugated tube (no slit) $\phi 7$ L= 355\pm3mm using right hand then insert the G-B/W hotmelted wires and B/B wireS using left hand.</div>	n/a	 <div data-bbox="1917 533 2016 558">GOOD</div>  <div data-bbox="1917 676 1993 702">NG</div> <div data-bbox="1787 730 2016 782">1. No wrong use of parts 2. No deformed terminal</div>	
4	P2 Wire insertion to assy parts	 <div data-bbox="1016 852 1447 995">1. Get the assy parts, hold the COT $\phi 7$ L= 208\pm3mm then insert the G-B/W hotmelted wires and B wires [2pcs.] using right hand.</div>  <div data-bbox="994 1104 1406 1216">2. After insertion, check the inserted wires.. Note: No wires left inside COT.</div>	n/a	<div data-bbox="1787 1053 2016 1104">1. No wrong use of parts 2. No deformed terminal</div>	

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/ Part Number: **780B / 7R0104-7022**

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Purpose: ☐ PROTOTYPE

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

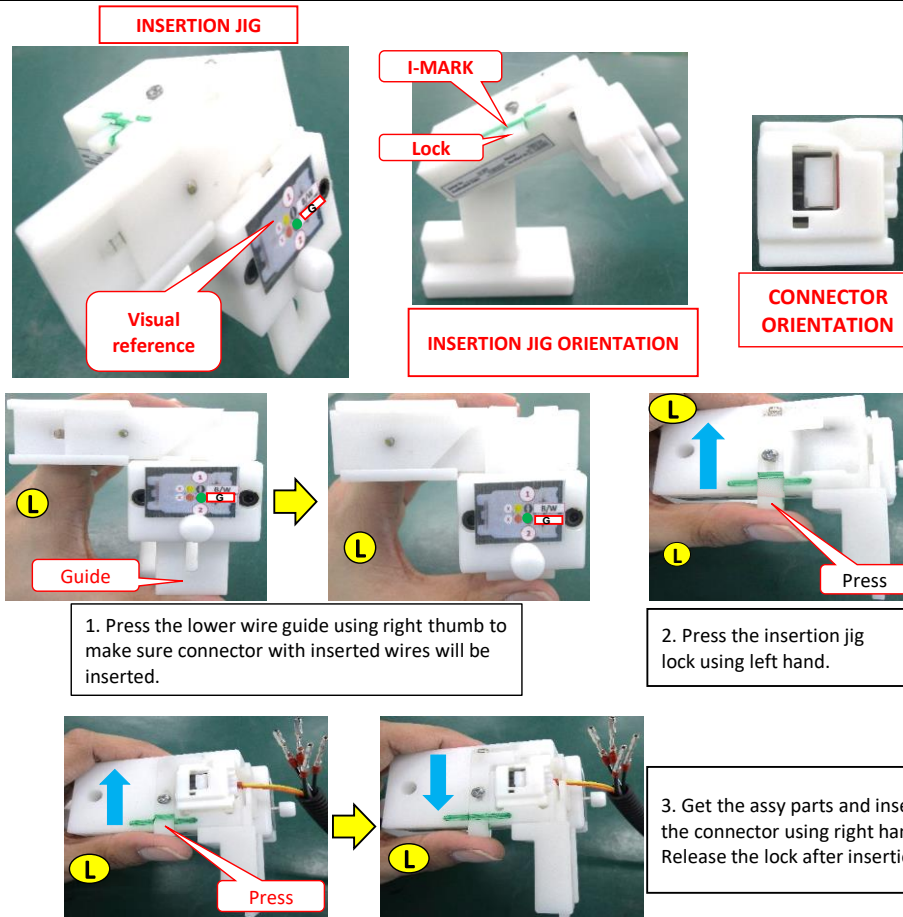
TOOLS/PPE

QUALITY POINTERS

5

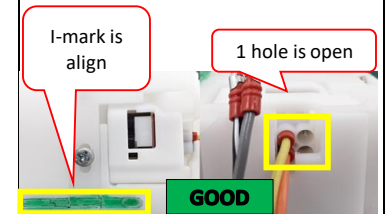
P2

Connector setting to
insertion jig
6189-1142 (W)
(Assy parts)



n/a

CONNECTOR ORIENTATION ILLUSTRATION



1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

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WI-ENG-PDE-391B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

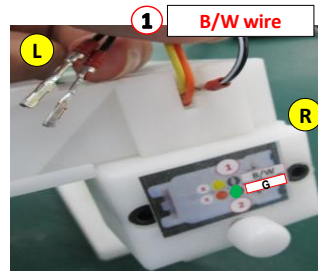
TOOLS/PPE

QUALITY POINTERS

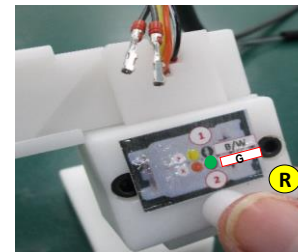
6

P1

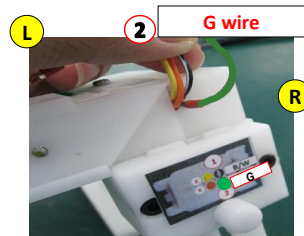
Wire insertion to connector 6189-1142 (W) (Assy parts)



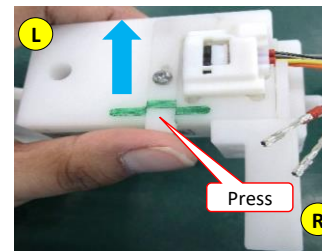
1. Hold the insertion jig using left hand. Get the **B/W wire** and insert to connector using right hand.



2. Press the button using right thumb. The slot for **G wire** will be opened.



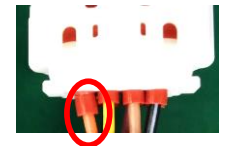
3. Hold the **G wire** and insert to connector using right hand.



4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.

n/a

Note: During insertion, hold the wire not rubber seal to prevent sagging.



1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

Note: Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force.

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