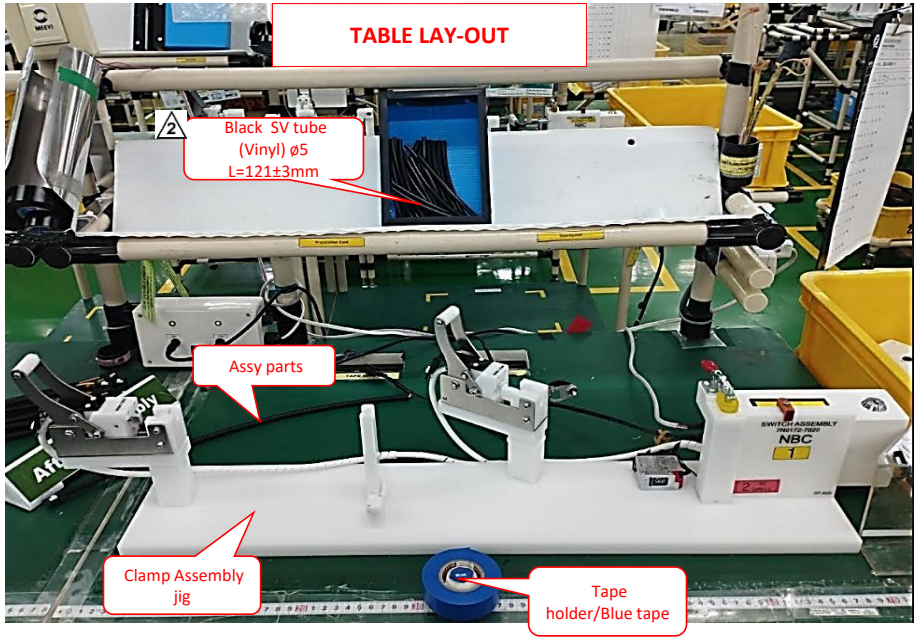
	WORK INSTRUCTION			Effectivity Date:	May 20, 2023		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model Code/Part Number:	373D / 7N0172-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-603B		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	2	Page No.:	1 of 8

PARTS: ② 1. Assy parts; Black SV tube (Vinyl) ø5 L=121±3mm; Blue tape

JIG: 1. Assembly jig

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

Revision History							Prepared by	Reviewed by	Approved by	Noted by
05/20/23	2	Work Instruction improvement from Genba check audit. Standardized tube description: SV tube (Vinyl). Correction on measurement (Connector to Terminal tip) from 247mm to 249mm.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
01/31/23	1	Change purpose from pre-launch to Masspro.Additional Table lay-out. Inclusion of Quality Checkpoint; Improve Work Procedue/ illustration and references. Change length of Black SV Tube (Vinyl) from L=118mm to L=121mm.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
11/28/22	0	Initial issue.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	November 28, 2022		

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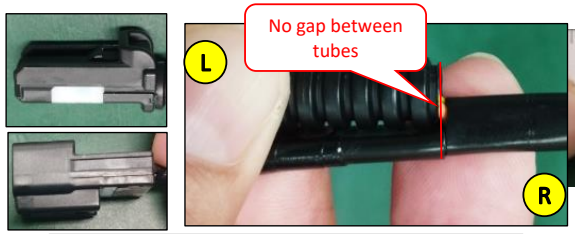
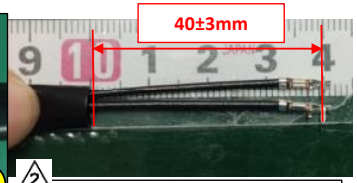
PARTS:	1. Assy parts 2. Black SV tube (Vinyl) ø5 L=121±3mm	3. Blue tape	**JIG** n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2		▲2 Wire Insertion to Black SV tube (Vinyl) ø5 L=121±3mm	 ▲2 1. Get the Black SV tube (Vinyl) **ø5 L=121±3mm** using right hand then insert the B-B wires.	n/a	1. No wrong use of parts
3	P2	Y-Taping	 ▲2 1. Fix the COT and of SV tube (Vinyl) . Make sure no gap in between.  ▲2 2. Measurement from end of SV tube (Vinyl) up to terminal tip. Must be **40±3mm**.	**MEASURING TAPE** 	1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension 6. No gap between tubes 7. No exposed wire. ***Important reminders/Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***2. Use YELLOW tape to easily visualize the tape shifting. But actual should be BLUE TAPE.***

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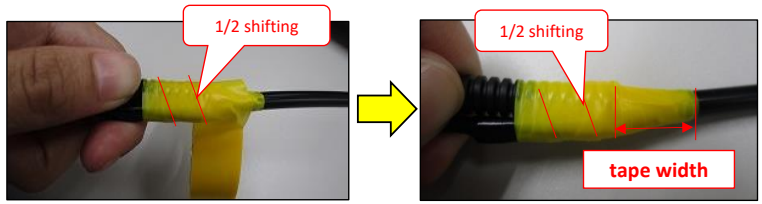
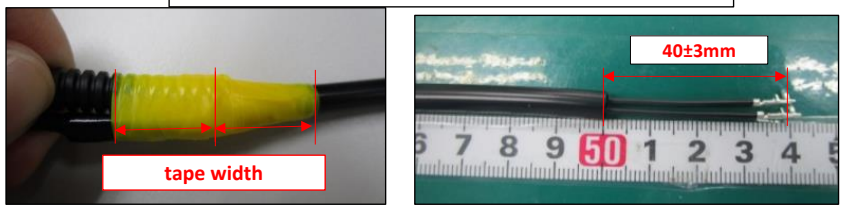
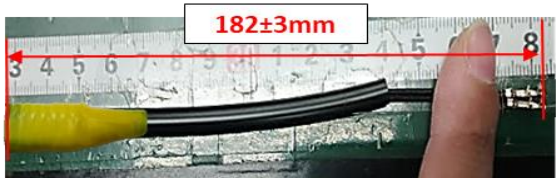
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 3 of 8

PARTS:	1. Assy parts 2. Blue tape	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Y-Taping (Continuation)	 7. Make 1/2 shifting to the right until tape width on of SV tube (Vinyl) , wind the tape 2x then cut the tape.  8. After taping, check the measurement from of SV tube (Vinyl) up to terminal pointed **40±3mm** and taping condition  8. After taping, check the measurement from end of Y-Taping to terminal pointed **182±3mm** and taping condition	MEASURING TAPE 	1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension 6. No gap between tubes 7. No exposed wire ***Important reminders/Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***2. Use YELLOW tape to easily visualize the tape shifting. But actual should be BLUE TAPE.***

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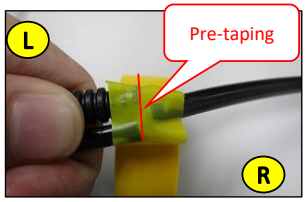
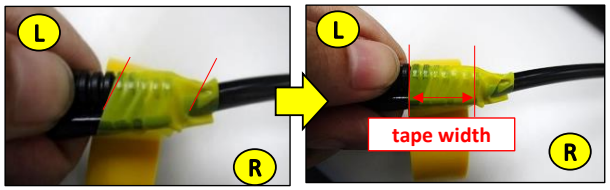
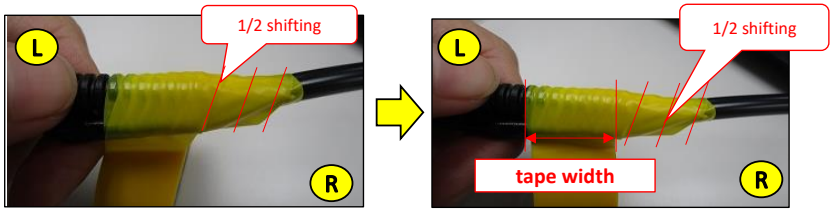
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 4 of 8

PARTS:	1. Assy parts 2. Blue tape	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Y-Taping (Continuation)	 2 3. Get the tape and fix the COT to of SV tube (Vinyl) . Make 1 wind pre-taping before shifting.  4. Make 1 shifting to the left until tape width then wind the tape 2x. 5. Make 1/3 shifting to the right side until tape width on of SV tube (Vinyl) 2  6. Make 1/2 shifting to the left until tape width then wind the tape 2x.	MEASURING TAPE 	1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension 6. No gap between tubes 7. No exposed wire ***Important reminders/Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***2. Use YELLOW tape to easily visualize the tape shifting. But actual should be BLUE TAPE.***

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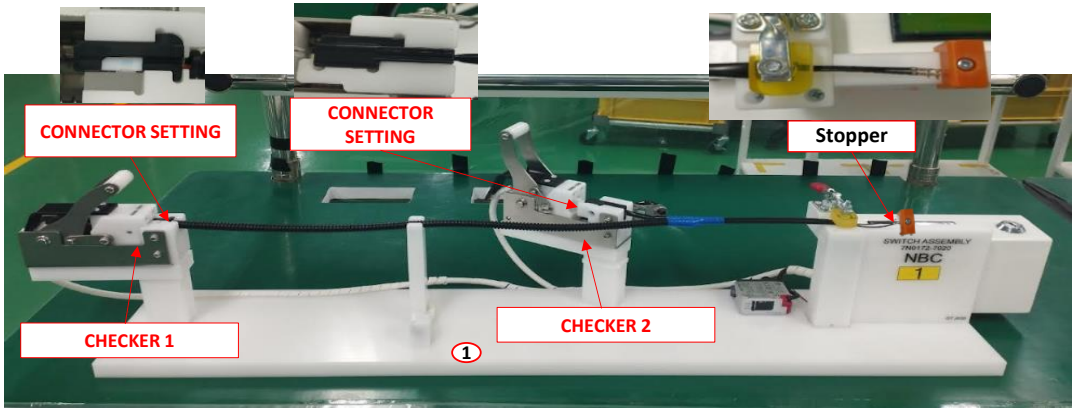
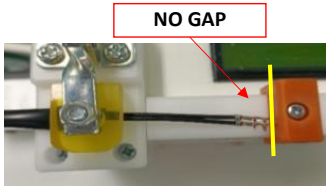
	Purpose: ☐PROTOTYPE ☐PRE-LAUNCH ■MASSPRO			Revision No.:	2	Page No.: 5 of 8

PARTS:	1. Assy parts	JIG	1. Continuity tester jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Assembly jig			1. No wrong insertion of connector 2. Make sure no gap between terminal and stopper jig  ***Important reminders/Note/s:*** ***1. Make sure no gap between stopper and terminals***

1. Get the assy parts then set into jig ***(See above illustration).*** First, set the connector **6098-6663 (B)** to **Checker 1** then pull the checker ficture for continuity checking. Second, set the connector **6098-3803 (B)** to **Checker 2** then pull the checker ficture for continuity checking. Last, put the terminal into stopper jig then pull the toggle clamp using both hands.

2. Check in the counter if **Wire 1 and Wire 2** was **ON**. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.

3. If the **Color sensor** is **ON.** Press the SW button. **GO** buzzer will be heard.

4. Conduct **POINT CHECKING** before removal from jig.

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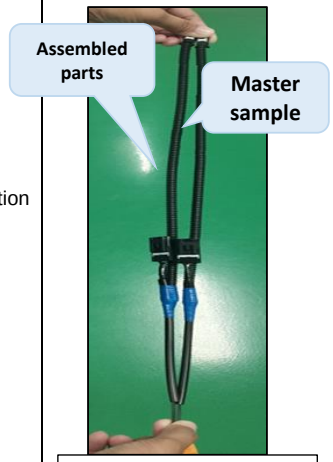
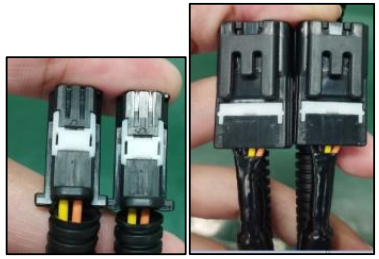
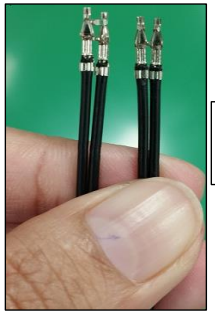
PARTS:	1. Assembled parts 2. Master sample	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	Visual/By two's inspection	  1. Conduct **alignment of harness(Engineering sample vs. Assembled parts)** using both hands  2. Check the **connector lock condition** and **wire insertion**. 3. Check **the Y-taping condition** and **color of tape (Must be Blue tape only).**  4. Check the **terminal appearance**. Must be **no deformed terminal**.		1. No skip checking during inspection **MASTER SAMPLE**

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PARTS:	n/a	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2	Measurement			***Important reminders/Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***2. For Hatsumono and Owarimono.*** 1. No wrong dimension

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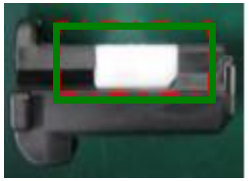
PARTS:	n/a	JIG	n/a

QUALITY CHECKPOINTS

P2 — 7N0172-7020



GOOD

NO GOOD

1 No Unlock/ Halflock Connector (2 connector)

2 No Missing Tape

3 No Deformed Terminal

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