

	WORK INSTRUCTION				Effectivity Date:		November 26, 2021	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model Code/Part Number: 320B / 6 7L0052-7023		Customer: TRQSS		Document No.: WI-ENG-PDE-138B	
	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.: 6 Page No.: 1 of 6	

PARTS: 6 1. Assy parts; Black tape [2pcs.]			JIG: 1. Insertion jig 2. Locking jig 3. Terminal cover jig 4. Spot taping jig	
NO.	PROCESS NAME	6 WORK PROCEDURE/ ILLUSTRATION <div style="text-align: center; border: 1px solid black; padding: 5px; margin: 10px auto; width: 80%;">Table Lay-out</div>	TOOLS/PPE <div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 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>	QUALITY POINTERS 1. No missing parts/tools 2. No excess parts/tools

Revision History								Prepared by	Reviewed by	Approved by	Noted by
11/26/21	6	Change part number from 7L0052-7022 to 7L0052-7023 due to additional clamp (82711-52090 (W)) (Refer to WI-ENG-PDE-138C). Improve work procedure and illustration in all process. Additional table lay-out.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	 M. Catapang	 J. Loterte	 C. Villanueva	 A. Arañes	
08/12/21	5	Remove Taping 3 Black Corrugated tube to Black Sunprene tube and transfer to P3. Add Spot taping process from P3 to P2. Add guidelines for Pull-Push-Pull-Push method.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes					
05/18/21	4	Change connector colors in accordance with color standardization for plastic parts refer to GL-COM-003. Add tape quantity. Change from 2x pulling to Pull-Push-Pull-Push insertion quality pointers. Transfer Taping of COT to wire near connector to P1 and add process Taping of COT to sunprene from P3. Remove cycle time.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes					
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	October 11, 2018		

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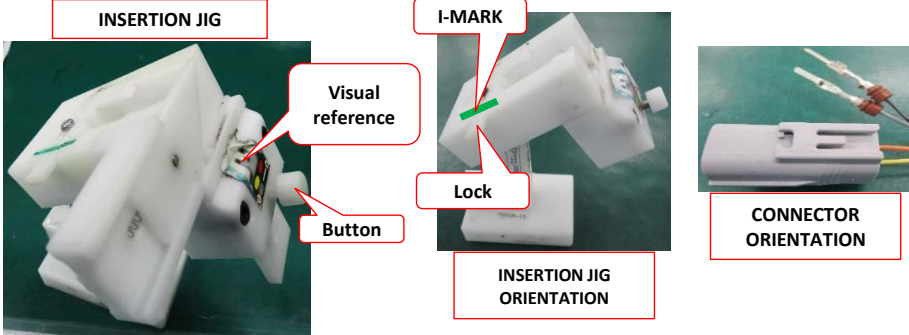
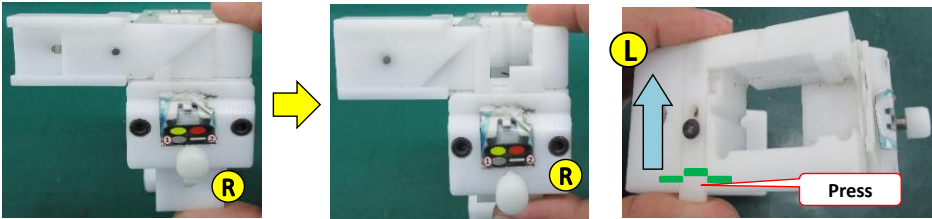
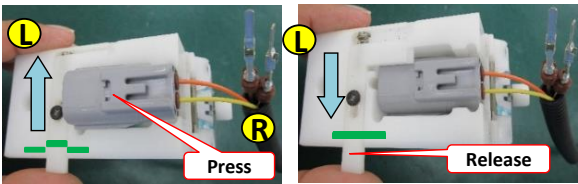
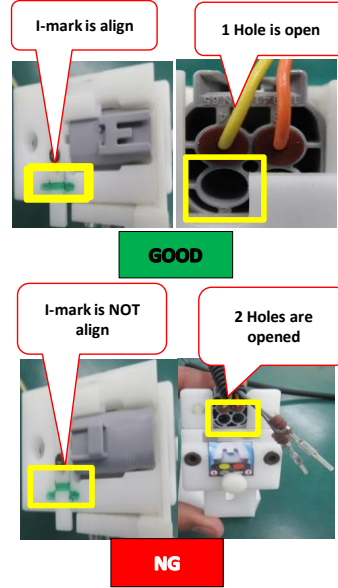
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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	P2	<p>Connector setting to insertion jig 6188-0066 (GR) (Assy parts)</p> <p>6</p>    <p>1. Press the guide using right thumb. The slot for GR wire will be opened.</p> <p>2. Press the lock of insertion jig using left thumb.</p> <p>3. Insert the connector 6188-0066 (GR) with inserted Y/OR wire using right hand. <i>Note: Follow the connector orientation.</i></p>	n/a	<p>Connector Orientation Illustration</p>  <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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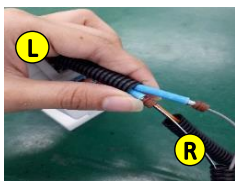
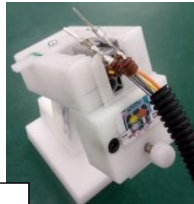

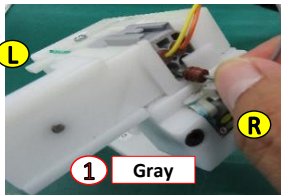

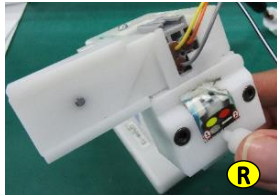
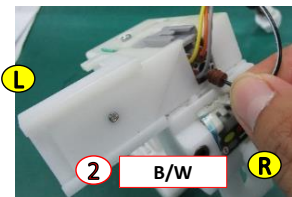
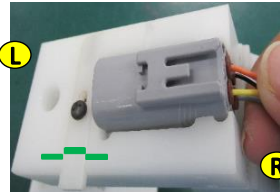
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PARTS:		1. Assy parts		JIG	1. Insertion jig 2. Terminal cover jig
NO.	PROCESS NAME	6 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to assy parts	   <p>1. Get the terminal cover jig using right hand then insert to both terminals (Gray and Black/White with COT and sunprene tube) using right hand.</p> <p>2. Insert the Gray and Black/White (with COT and sunprene tube) to assy part (COT L=52±3mm) using right hand.</p>		 <p>TERMINAL COVER JIG</p>	1. No wrong usage of parts 2. No damaged rubber seal 3. No wrong insertion on COT
4	P2 Wire insertion to connector 6188-0066 (GR) (Assy parts)	   <p>1 Hold the GR wire then insert to terminal slot 1 using right hand.</p> <p>2. Press the button using right thumb. The slot for B/W wire will be opened.</p>   <p>3. Hold the B/W 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>		n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 6 Note: Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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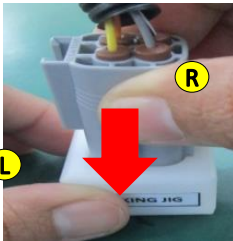




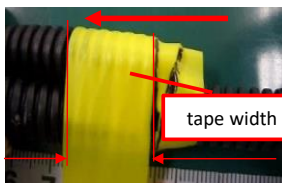

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PARTS:		1. Assy parts 2. Black tape		JIG	1. Locking jig								
NO.	PROCESS NAME	6 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS								
5	Connector lock	<div><div><div><div></div><div><p>1. Put the connector into locking jig using both hands and then conduct 2x pressing. Check the connector if properly locked.</p></div></div></div><div><p>Coupler Cross Sectional View</p><table><tr><td>NG</td><td>NG</td><td>GOOD</td></tr><tr><td></td><td></td><td></td></tr><tr><td>Unlock</td><td>Half Lock Condition</td><td>Full Lock Condition</td></tr></table><div><p>Before pressing</p></div><div><p>After pressing</p></div></div></div> <div>Locking jig</div> <div></div> <div><p>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK</p><p>1. No unlock/half-locked connector 2. No damage connector</p></div>		NG	NG	GOOD				Unlock	Half Lock Condition	Full Lock Condition	
NG	NG	GOOD											
Unlock	Half Lock Condition	Full Lock Condition											
6	Y-taping	<div><div><div><div></div><div></div></div></div><div><p>No wide interval</p><p>1. Fix the corrugated tube .</p></div><div><div><div></div><div></div></div><div><p>2. Start taping at the middle of combined Corrugated tubes, then winding the tape to left side , width must be same with tape (19mm)</p></div></div></div> <div><p>Y-TAPING ORIENTATION</p><div></div></div> <div><p>Note: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</p><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>											

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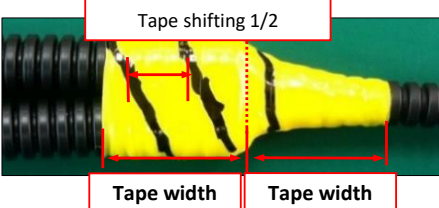
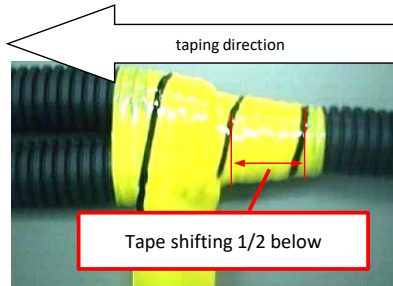
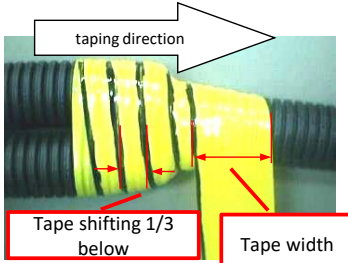

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PARTS:		1. Assy parts 2. Black tape		JIG	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2 Y-taping (Continuation)	<div></div> <p>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)</p> <p>4. Wind the tape backward 1/2 shifting.</p> <p>5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p>		<p>MEASURING TAPE</p> 	<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 <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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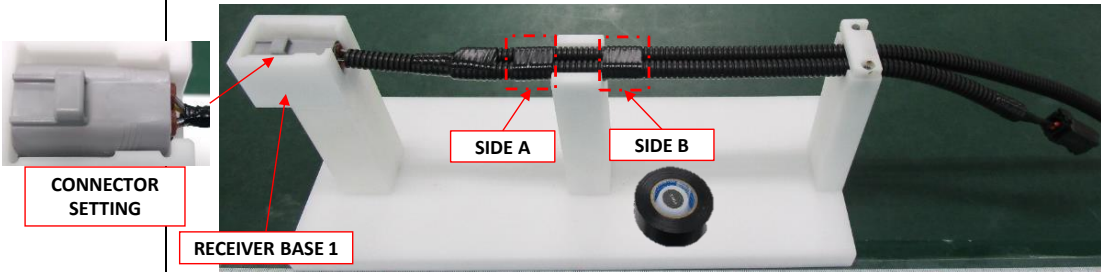
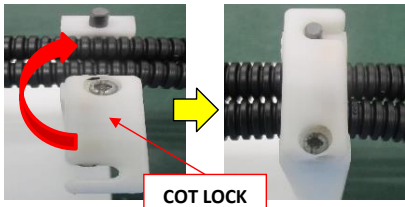
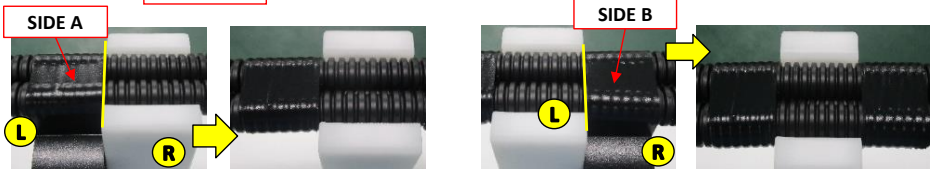
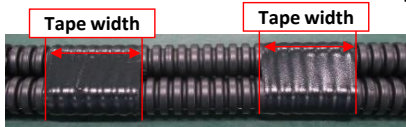

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PARTS:		1. Assy parts 2. Black tape	JIG	1. Spot taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P2 Spot taping	<div><p>CONNECTOR SETTING</p><p>RECEIVER BASE 1</p><p>COT LOCK</p><p>SIDE A</p><p>SIDE B</p></div> <div><p>1. Get the assy parts then set into jig using both hands. (See above picture for correct setting). First, set the connector 6188-0066 (GR) to Receiver base. Continue to set the 2 COT in the COT guide then lock.</p></div> <div><p>SIDE A</p><p>SIDE B</p><p>L</p><p>R</p></div> <div><p>Tape width</p><p>Tape width</p><p>2. Hold the assy parts using left hand, get the Black tape then conduct 2 windings of tape on SIDE A then cut using both hands.</p><p>3. Hold the assy parts using left hand, get the Black tape then conduct 2 windings of tape on SIDE B then cut using both hands.</p><p>4. Check the measurement and taping condition.</p></div>	<p>MEASURING 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 <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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