

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**February 26, 2021**

Product Name/Code:

**370B / 7L0045-7022**

Customer:

**TRQSS**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-158A**

Revision No.:

4

Page No.:

1 of 5

**PARTS:**

1. Pre-assy parts from Kitting: Connector 6098-5677 (W); B wires L=272±2mm [2pcs.]; V wires L=312±2mm [2pcs.];  
Black corrugated tube ø7 L=71±3mm  
2. Black Corrugated tube (no slit) ø5 L=133±3mm

4

JIG:

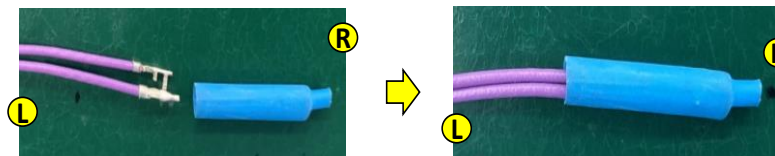
1. Terminal cover jig

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

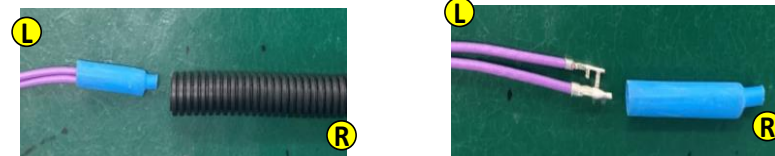
1

P1

Wire insertion to  
Black Corrugated tube  
(no slit)  
ø5 L=133±3mm



1. Get the terminal cover jig using right hand and then insert the **V/V wires** using left hand.



2. Get the Black corrugated tube (no slit) **ø5 L=133±3mm**  
using right and insert the **V/V wires** using left hand.

3. After insertion, remove the terminal cover jig  
using right hand.

**Safety Instruction**

Be sure to wear  
prescribed 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.

**TERMINAL COVER JIG**

1. No wrong use of parts
2. No deformed terminal

**Revision History**

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
02/26/21	4	Apply some improvements. Removal of cycle time.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
08/12/20	3	Transferred process owner from Production to Engineering. Changed document control number from WI-PRO-ASY-072A to WI-ENG-PDE-158A. Changed part number from 7L0045-7021A to 7L0045-7022 due to removal of vinyl tube Ø4 L=25mm and changed vinyl tube dimension from Ø4 L=65mm to Ø4 L=45mm. Include cycle time per process.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
03/03/20	1	Additional work procedure in wire insertion of COT and VT	A. Roxas	A. Morcozo	O. Merin		M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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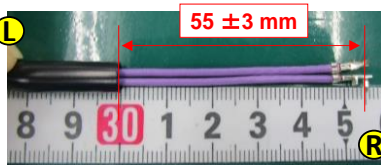
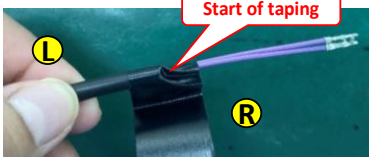
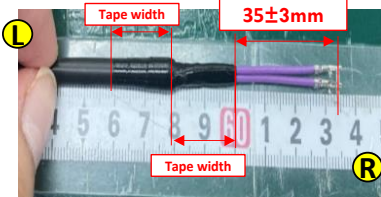

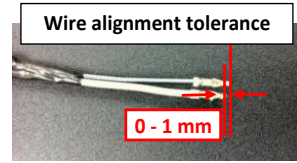
2 of 5

**PARTS:**

1. Assy parts
2. Black vinyl tube  $\phi 4$  L=45 $\pm$ 3mm
3. Black tape

**JIG**

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	 Wire insertion to Black vinyl tube $\phi 4$ L=45 $\pm$ 3mm	 1. Get the Black vinyl tube $\phi 4$ L=45 $\pm$ 3mm using right hand then insert the <b>V/V wires</b> using left hand.	n/a	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No deformed terminal</li></ol>
3	 P1 Taping 1 Black vinyl tube to wire near terminal	 1. Measure from end of vinyl tube up to terminal pointed tip <b>55<math>\pm</math>3mm</b> using both hands.  2. Hold the vinyl tube using left hand, get the <b>Black tape</b> using right hand then begin taping process. <b>Note: Refer to WI-PRO-ASY-001 for taping procedure.</b>  3. After taping, check the measurement, terminal appearance and taping condition. <b>Note: No need to fold the vinyl tube since it is <math>\phi 4</math>.</b>	<b>MEASURING TAPE</b> 	<p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none"><li>1. No loose tape</li><li>2. No peel-off tape</li><li>3. No flip out tape</li><li>4. No wrong dimension</li><li>5. No wrong use of tape</li></ol>  <b>Wire alignment tolerance</b> <b>0 - 1 mm</b>

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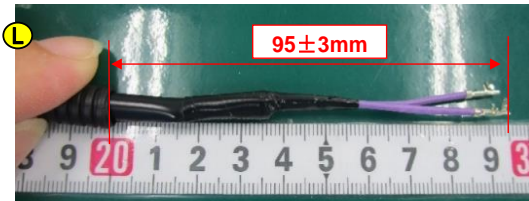
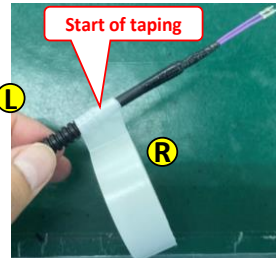
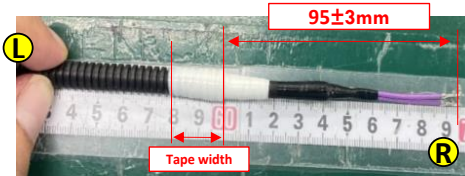

3 of 5

**PARTS:**

1. Assy parts
2. White tape

**JIG**

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 2 Black corrugated tube to Black vinyl tube	<div><p>1. Measure from end of corrugated tube up to terminal pointed tip <b>95±3mm.</b></p></div> <div><p>2. Hold the corrugated tube using left hand, get the <b>White tape</b> using right hand then begin taping process. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p></div> <div><p>3. After taping, check the measurement, terminal appearance and taping condition.</p></div>	<div><p><b>MEASURING TAPE</b></p></div>	<div><p><b>NOTE:</b> <b>USE WHITE TAPE ONLY.</b></p></div> <div><p><i>Note:</i> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p></div> <div><ol style="list-style-type: none"><li>1. No loose tape</li><li>2. No peel-off tape</li><li>3. No flip out tape</li><li>4. No wrong dimension</li><li>5. No wrong use of tape</li></ol></div>

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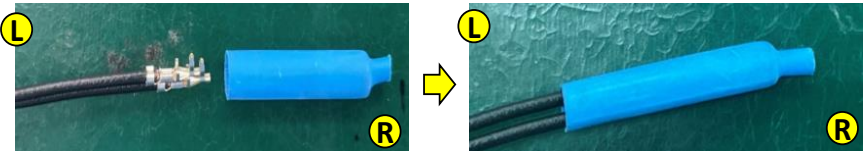




Page No.:

**4 of 5****PARTS:**

1. Assy parts
2. Black Corrugated tube (no slit)  $\phi 5$  L=133 $\pm$ 3mm

**JIG**

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1  Wire insertion to Black Corrugated tube (no slit) $\phi 5$ L=133 $\pm$ 3mm	 <div>1. Get the terminal cover jig using right hand and then insert the <b>B/B wires</b> using left hand.</div>  <div>2. Get the Black corrugated tube <b><math>\phi 5</math> L=133<math>\pm</math>3mm</b> using right hand and insert <b>B/B wires</b> using left hand.</div>  <div>3. After insertion, remove the terminal cover jig using right hand.</div> 	<div>TERMINAL COVER JIG</div> 	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No deformed terminal</li></ol>

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Page No.:

5 of 5

### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

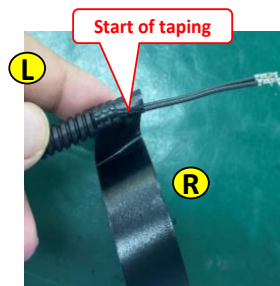
TOOLS/PPE

QUALITY POINTERS

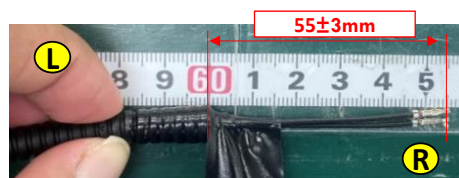
6

P1

Taping 3  
Black corrugated tube to  
wire near terminal

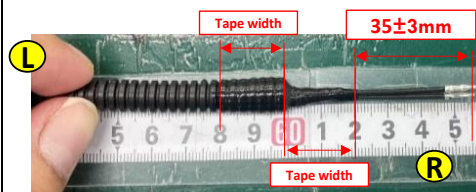


1. Hold the corrugated tube using left hand, get the **Black tape** then start taping using right hand.



2. Measure from end of corrugated tube up to terminal tip **55±3mm** then continue taping process.

**Note: Refer to WI-PRO-ASY-001 for taping procedure.**



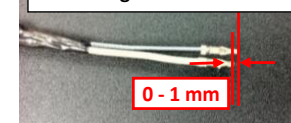
3. After taping, check the measurement, terminal appearance and taping condition.

### MEASURING TAPE



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

### Wire alignment tolerance



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