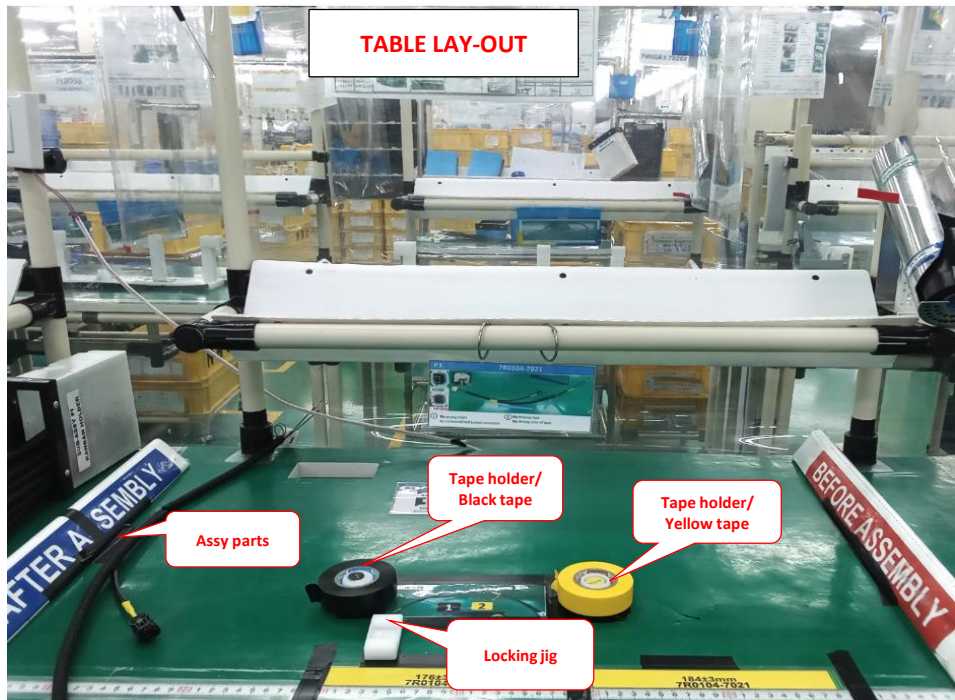
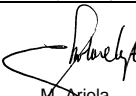

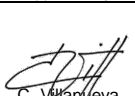
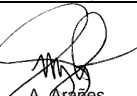

	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effect: January 28, 2022		February 14, 2022	
	Process Name/Title:				Valid: -		n/a	
	Model Code/ Part Number: 780B / 7R0104-7022		Customer: TRMX		Document No.:		WI-ENG-PDE-391C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH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

PARTS:		1. Assy Parts 2. Black tape 3. Yellow tape			JIG:		Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS
1	P3	<div>  </div>				<div> <p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>		1.No missing parts/tools 2. No excess parts/tools

				Prepared by		Reviewed by		Approved by		Noted by	
				 M. Ariola		 J. Loterte		 C. Villanueva		 A. Arañes	
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**

Effectivity Date:

February 14, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

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Customer:

TRMX

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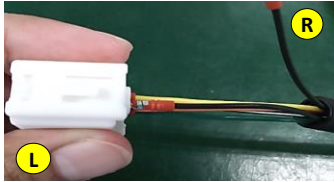
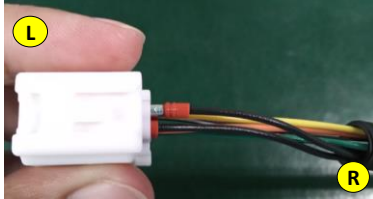
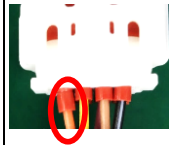

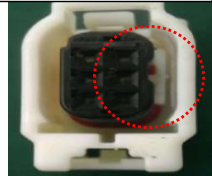


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts			JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3	<div>WIRE FACING</div> <div>Connector Orientation</div> <div>1. Hold the connector using left hand and insert first B wire to connector using right hand. <i>Note: Insertion starts from left to right</i></div> <div><div>2. Hold the connector using left hand and insert second B wire to connector using right hand.</div></div>		n/a	<div><i>Note: During insertion, hold the wire not <u>rubber seal</u> to prevent sagging.</i></div> <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div><i>Note: Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i></div>
3		<div><div>1. Put the connector into locking jig using right hand and then press 2x using both hands. Check the connector lock if properly locked.</div></div> <div>BEFORE PRESSING</div> <div>AFTER PRESSING</div>		<div>LOCKING JIG</div>	<div><i>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED CONNECTOR LOCK</i></div> <div>1. Use the provided jig tool per model 2. No unlock/half-locked connector 3. No damaged lock</div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

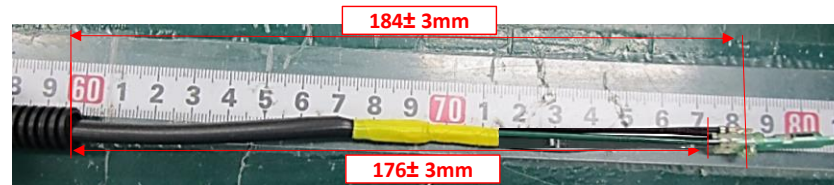
TOOLS/PPE

QUALITY POINTERS

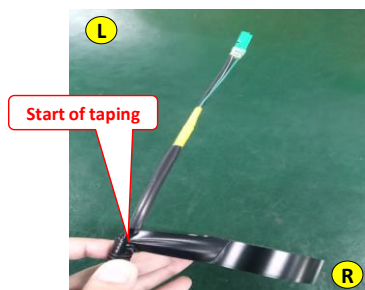
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P3

Taping 1
Black corrugated tube to
Black sunprene tube

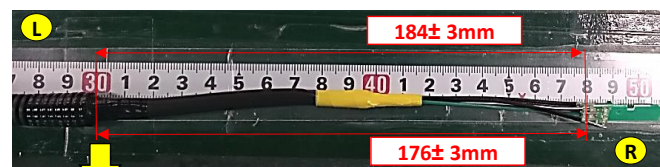


1. Measure the end of the corrugated tube up to the edge of hotmelt **176mm** and terminal pointed tip **184mm**.



Start of taping

2. Hold the corrugated tube using left hand. Get the Black tape using right hand and start taping process using both hands.
Refer to WI-PRO-ASY-001 for taping procedure.



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

MEASURING TAPE



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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PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts
2. Yellow tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

P3

Y-Taping



1. Fix the vinyl and corrugated tube using both hands.
See illustration for correct facing of connector.



2. Start taping at the middle of combined Corrugated tubes & vinyl tube, make **1 winding** pre-tape before shifting.

3. Make 1 wind going to Vinyl tube & corrugated tube , width must be same with tape (19mm).

n/a

NOTE:
Use YELLOW TAPE only.

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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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

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Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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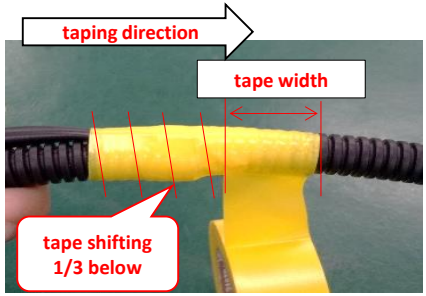
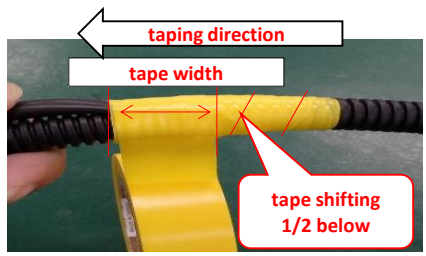
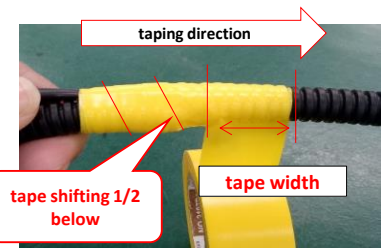
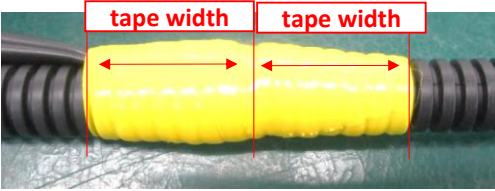

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PARTS:

1. Assy parts
2. Yellow tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P3 Y-Taping (Continuation)	<div><p>4. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width).</p></div> <div><p>5. Wind the tape backward 1/2 shifting.</p></div> <div><p>6. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape.</p></div> <div><p>7. After taping, check the measurement and taping condition.</p></div>	<div>MEASURING TAPE </div>	<div>NOTE: Use <u>YELLOW TAPE</u> only.</div> <div><ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wrong use of tape5. No wrong dimension</div> <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div>

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