



WORK INSTRUCTION

Process Name/Title: TAPING ASSEMBLY PROCESS

Model code/Part number: 435B / 75N735-0011

Customer: TRJ

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

September 23, 2022

Validity Date:

n/a

Document No.:

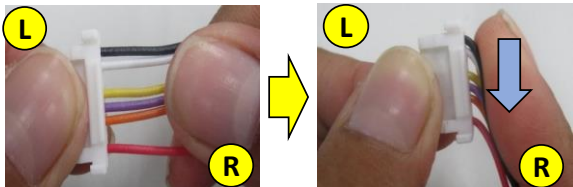
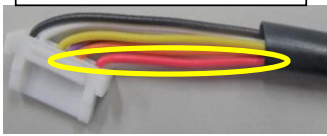

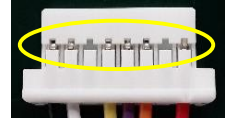
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PARTS:		1. Assy parts				JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P2	<p>1. Hold the connector using left hand. Hold the wires using right hand. Fold the wires downward. <i>Note: Follow folding procedure illustration stated on the right side.</i></p>  <p>RED WIRE MUST BE STRAIGHT AND NOT FOLDED.</p>  <p>BEFORE FOLDING</p>  <p>AFTER FOLDING</p>				<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>		 <p>Terminal tip must be visible</p> <p>Document References: 1. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</p> <p>1. Wires must be fold carefully 2. No damaged/scratch wires 3. No terminal backing out if pulled-out full force. 4. No tangled wires</p>	
Revision History						Prepared by:	Reviewed by:	Approved by:	Noted by:
09/23/22	5	Remove Marking process due to improvement. Include WI-ENG-PDE-431 for Steering Electrical Test after assembly.				D.Castillo	J.Loterte	C. Villanueva	A. Arañes
02/09/21	4	Removal of cycle time; Conduct semi-annual review of documents; Put measuring tape instruction and illustration on pg.5 measurement process				J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
07/28F/2023		Changed effectivity and validity date. Added new photo and details on Process 2. Update cycle time in all process and changed total cycle time from 105.31 sec's to 74.3 sec's				M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted
						Est. Date:	October 28, 2019		

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PARTS:

1. Black tape [1pc]
2. Assy parts

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 Black Sunprene tube to wire near connector and folding	<div>1. Fix the two (2) vinyl tube.</div> <div>Two (2) Vinyl tube must be aligned.</div> <div>0~10mm</div> <div>Start of taping</div> <div>3. Hold the black sunprene tube then get the black tape and begin taping using right hand.</div> <div>4. Hold the connector using left hand and slowly fold the wires using right hand.</div> <div>5. After folding, check the measurement and taping condition.</div> <div>BEFORE FOLDING</div> <div>AFTER FOLDING</div>	<div>MEASURING TAPE</div>	<div>Red wire must be straight</div> <div>1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. Wires must be folded carefully 7. No damaged/scratch wires 8. No terminal backing out if pulled-out full force. 9. No tangled wires</div> <div>Important Reminder/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div>

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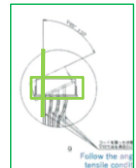
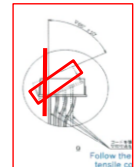
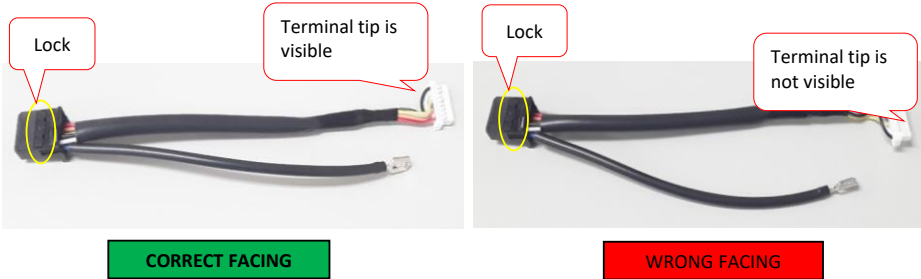
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts				JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
3	P2	Wire Facing Arrangement	 <div>1. Check the wire facing arrangement using both hands.</div>	n/a	<div>1. No wrong facing 2. No tangled wires</div> <div>NOTE: CONNECTOR AND WIRE MUST BE IN LINE AS SHOWN IN THE DRAWING</div> <div> GOOD Connector Orientation</div> <div> NG Connector Orientation</div>	
						

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PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P2

Visual/By two's inspection

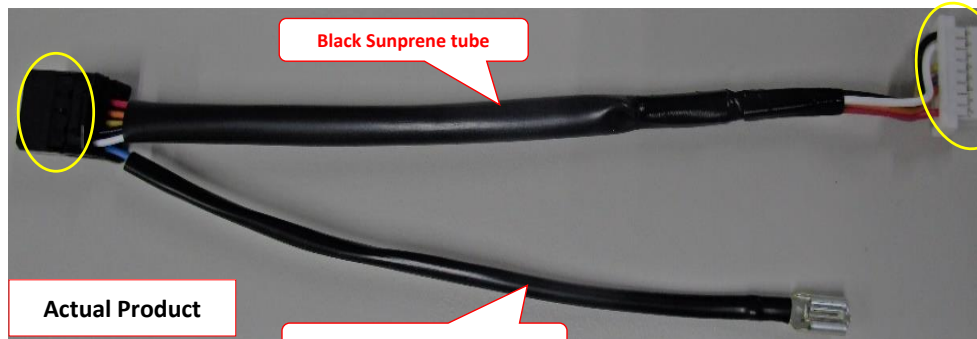
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1. Check the connector lock, locking of connector is included in Steering electrical test.

2. Check the wire alignment. Make sure no tangled wires.

3. Check the terminal if with backing out (not fully inserted) or deformed terminal.

4. Check the orientation of harness.



Actual Product

Black Sunprene tube

5

5. Compare to Master Sample by tapping.



Master Sample

Assembly product

5

Document References:

1. Refer to WI-ENG-PDE-431 for Steering Electrical Test after assembly.

MASTER SAMPLE



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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	Measurement		MEASURING TAPE	<p>1. No wrong dimension</p> <p>Important Reminder/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumuno and Owarimono</p>	
	P2				

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