





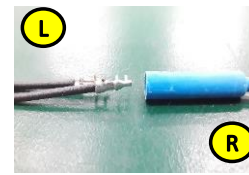



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	May 20, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-020A		
Revision No.:	4	Page No.:	1 of 3

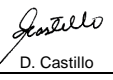
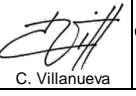
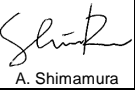
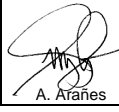
Process Name/Title: **TAPING ASSEMBLY PROCESS**

Product Name/Code: **550B /A 7L0083-7022** Customer: **TRQSS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts (Connector 6098-3802 (W) ; AVSSf 0.3 B wires L=799mm [2pcs] 2. Vinyl tube ø5 L=213±3mm			3. Black Corrugated tube ø5 L=394±3mm (no slit) 4. Sunprene tube ø5 L=130±3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS
1	P1	Wire Insertion to Vinyl tube ø5 L=213±3mm	<div><div>Hold the assy part using left hand then get the Vinyl tube ø5 L= 213±3mm using right hand and insert the Black wires.</div></div>			<div><div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div></div>		1. No wrong usage of parts. 2. No deformed terminal.
2		Wire Insertion to Corrugated tube ø5 L=394±3mm (no slit)	<div><div><div>2. Get the corrugated tube ø5, L=394±3 (no slit) using right hand and insert to wires.</div></div><div><div>1. Hold the wires using left hand, get the terminal cover jig using right hand and insert the wires.</div></div><div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div></div>			<div><div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div></div> <div><div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>		<div><div>Terminal cover jig</div></div> <div>1. No wrong usage of parts. 2. No deformed terminal.</div>
3		Wire Insertion to Sunprene tube ø5 L=130±3mm	<div><div>Hold the assy part using left hand then get the sunprene tube ø5 L= 130±3mm using right hand and insert the Black wires.</div></div>					1. No wrong usage of parts. 2. No deformed terminal.

Revision History

05/20/21	4	Change part number from 7L0083-7021 to 7L0083-7022 due to change Vinyl tube length from L=188mm to L=213mm. Transfer Connector setting, Wire insertion and Connector lock process to Kitting.	D.Castillo	C. Villanueva	A. Shimamura	A. Arañes	 D. Castillo	 C. Villanueva	 A. Shimamura	 A. Arañes
05/03/21	3	Change connector colors in accordance with color standardization for plastic parts refer to GL-COM-003. Remove validity date. Add tape quantity.	D.Castillo	C. Villanueva	A. Shimamura	A. Arañes				
07/09/19	n/a	Previously established Engineering Instruction(EI-ENG-PDE-099).Initial issue.	J. Loterte	A. Shimamura	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted				

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TAPING ASSEMBLY PROCESS

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Customer:

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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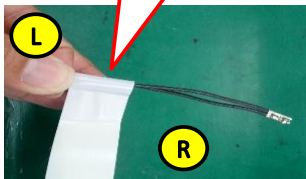
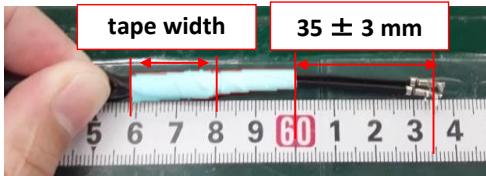

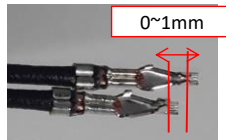
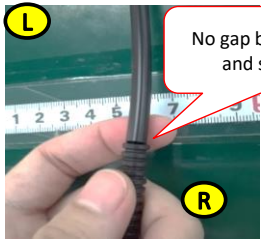
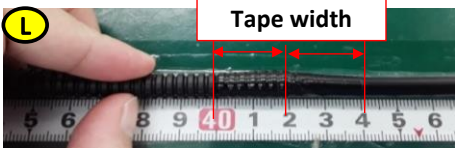

PARTS:

1. White tape [1pc]
2. Black tape [1pc]

3. . Assy parts

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Taping 1 Sunprene tube to wire near terminal	 <p>1. Hold the sunprene tube using left hand. Measure from sunprene tube up to terminal pointed tip 55±3mm.</p>  <p>2. Get White tape using right hand, hold the sunprene tube (ø5 L=130±3mm) using left hand then fold the sunprene tube and start taping using right hand. <i>Refer to WI-PRO-ASY-001 for taping procedure</i></p>  <p>3. After taping check the measurement, wire alignment and taping condition.</p>	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Measuring tape</p> 	<ol style="list-style-type: none">1. No loose tape2. No peel-off tape3. No flip-out tape4. No wrong dimension5. No wrong use of tape6. No missing tape  <p>Wire alignment tolerance 0~1mm</p>
5	Taping 2 COT to Sunprene tube	 <p>1. Fix the corrugated tube to Sunprene tube using left hand and start taping using right hand. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>2. Check the measurement and taping condition after taping.</p>	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Measuring tape</p> 	<ol style="list-style-type: none">1. No loose tape2. No peel-off tape3. No flip-out tape4. No wrong dimension5. No wrong use of tape6. No missing tape

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