

**WORK INSTRUCTION**

Effectivity Date:

February 18, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number: **587B / 7M0533-7021**

Customer:

TRJ

Document No.:

WI-ENG-PDE-412A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

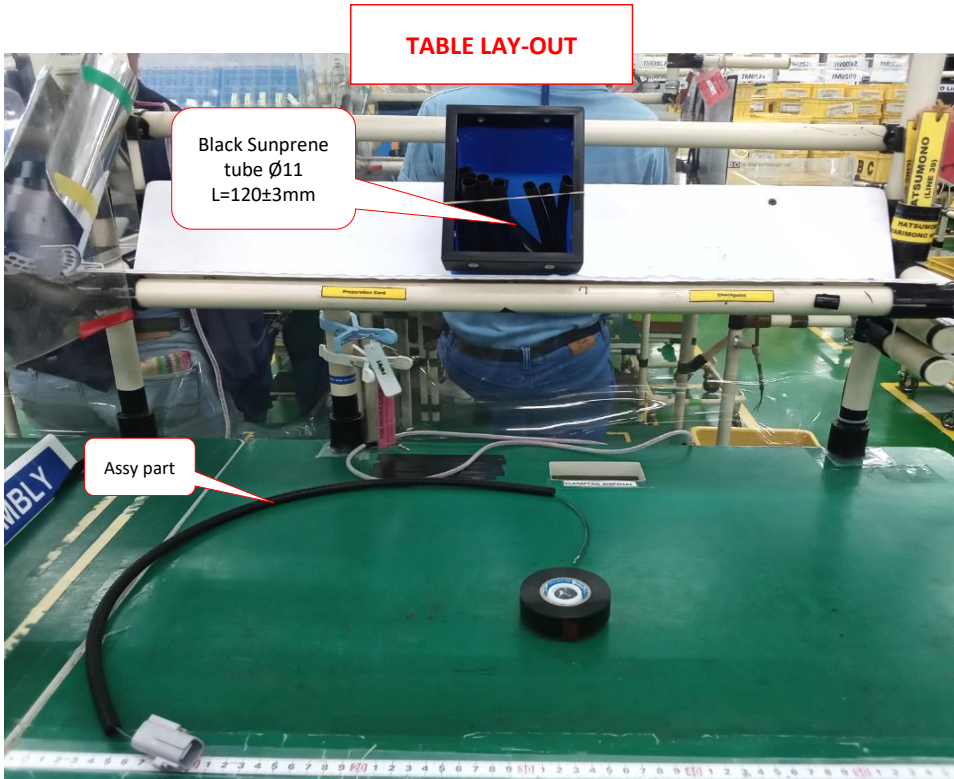
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PARTS:

All parts; Pre-assy parts from Kitting; Black tape [1pc]; Black Sunprene tube Ø11 L=120±3mm

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<p>TABLE LAY-OUT</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>Note: Please refer to WI-PRO-CNC-017 for Wire and Strip Length tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by:	Reviewed by:	Approved by:	Noted by:
02/18/22	0	Initial Issue.					M. Ariola	J. Loterte	C. Villanueva	A. Arañes
							M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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☐ PROTOTYPE

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Page No.:

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PARTS:

1. Pre-assy parts from Kitting.
2. Black tape [1pc]

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

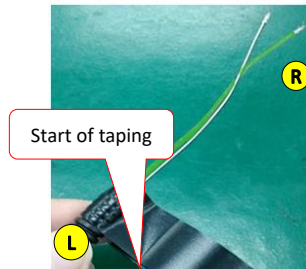
TOOLS/PPE

QUALITY POINTERS

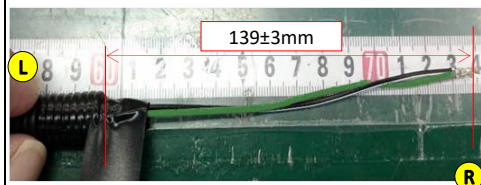
2

P1

Taping
COT to wire near
terminal

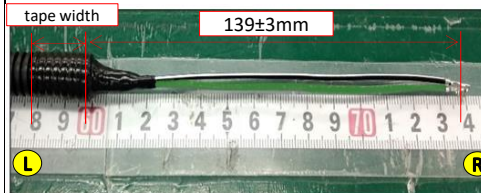


1. Hold the corrugated tube using left hand, get the Black tape then start taping using both hands.



2. Measure from end of corrugated tube up to terminal pointed tip **139±3mm** then continue the taping process.

Refer to WI-PRO-ASY-001 for taping procedure.

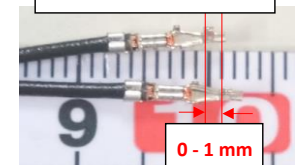


3. After taping, check the measurement, wire alignment and taping condition.

MEASURING TAPE



Wire alignment tolerance



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

Note:

Please use calibrated/verified measuring tape when getting the measurement.

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PARTS:

1. Black Sunprene tube $\varnothing 11$ L=120 \pm 3mm
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

Wire insertion to
Sunprene tube
 $\varnothing 11$ L=120 \pm 3mm



1. Get the sunprene tube $\varnothing 11$ L=120 \pm 3mm using right hand and then insert the B/W-G wires using left hand.

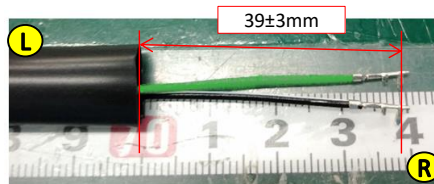
n/a

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

4

P1

Taping
COT to Sunprene tube



1. Measure from end of sunprene tube up to terminal pointed tip 39 \pm 3mm.

Start of taping



2. Hold the sunprene tube using left hand, get the Black tape then start taping process using both hands.
Refer to WI-PRO-ASY-001 for taping procedure.

MEASURING TAPE



*Note:
Please use calibrated/verified
measuring tape when getting the
measurement.*

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



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

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