

	<b>WORK INSTRUCTION</b>						Effectivity Date:		<b>December 22, 2022</b>		
	<b>TAPING ASSEMBLY PROCESS</b>						Validity Date:		n/a		
	Process Name/Title:			Model Code/Part Number: <b>370B / 7L0047-7024</b>			Customer: <b>TRQSS</b>			Document No.: <b>WI-ENG-PDE-421B</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		1		Page No.: 1 of 7

<b>PARTS:</b>	1. Assy parts 2. Black tape [1pc.]						<b>JIG:</b>		1. Insertion jig 2. Terminal cover jig 3. Locking jig		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>						<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
1	P2	<div style="text-align: center;"> </div>						<div style="border: 1px dashed red; padding: 5px;"> <p style="color: red; margin: 0;"><b>Safety Instruction</b></p> <p style="margin: 0;">Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p style="color: red; margin: 0;"><b>Housekeeping</b></p> <p style="margin: 0;">1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p style="color: red; margin: 0;"><b>Alert level</b></p> <p style="margin: 0;">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	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
12/22/22	1	Improve quality pointers: Reminders/notes and references. Inclusion of Quality checkpoints						M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
02/22/22	0	Initial issue						M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:	February 22, 2022		

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

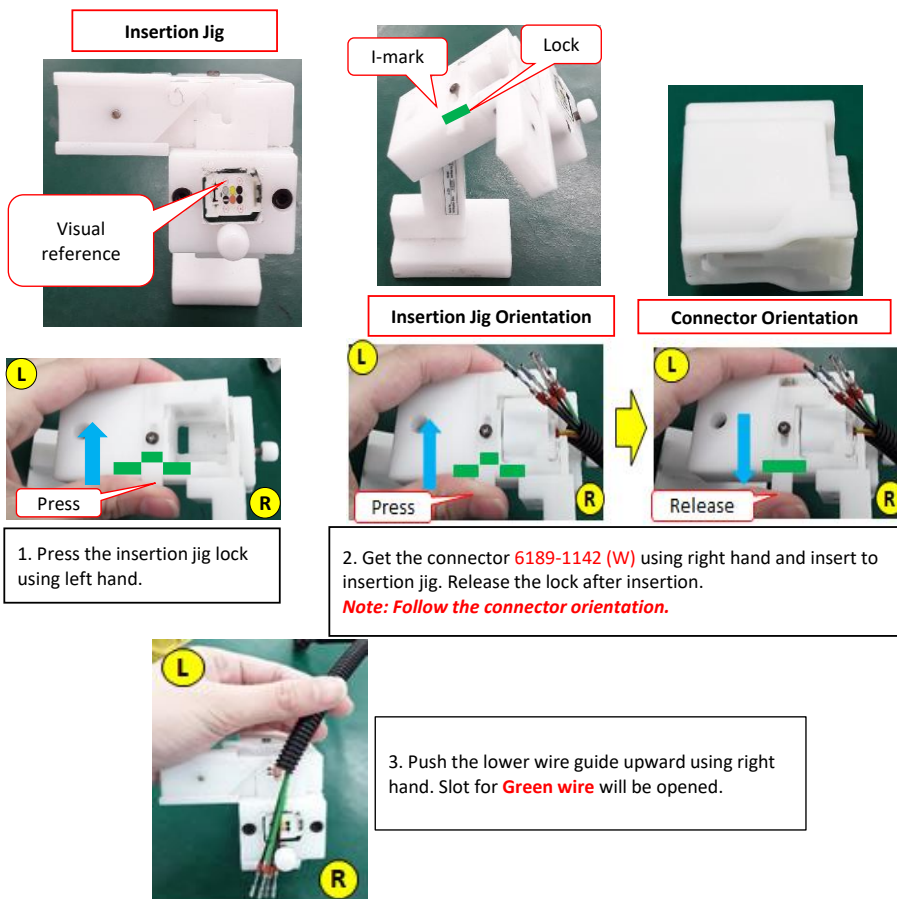
TOOLS/PPE

QUALITY POINTERS

2

P2

Connector setting to  
insertion jig  
6189-1142 (W)  
(Assy parts)



n/a

### CONNECTOR ORIENTATION ILLUSTRATION



1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

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### PARTS:

1. Assy parts

### JIG

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

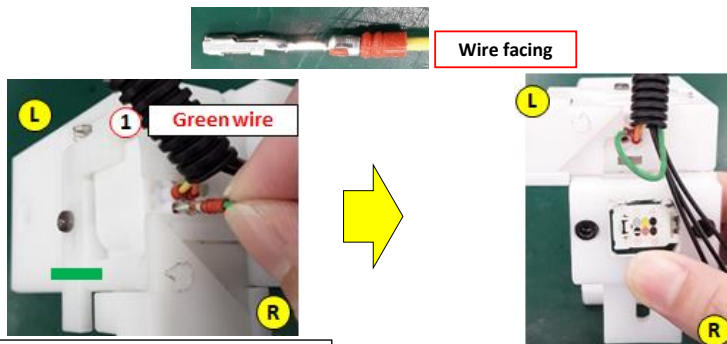
### TOOLS/PPE

### 1 QUALITY POINTERS

3

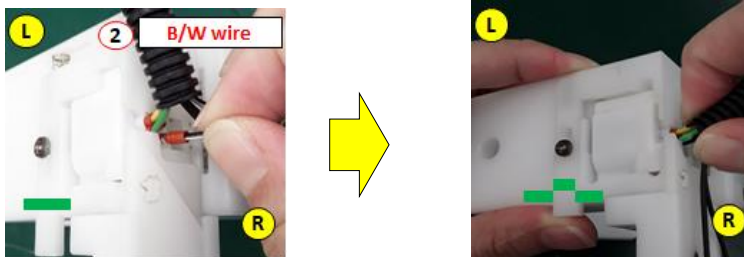
P2

Wire insertion to  
connector  
6189-1142 (W)



1. Hold the insertion jig using left hand.  
Get the **Green wire** then insert to terminal  
slot **1** using right hand.

2. Press the button using right thumb. slot for  
**Black/white wire** will be opened.

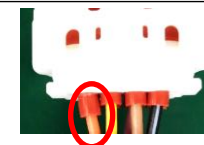


3. Get the **Black white wire** then insert to  
terminal slot **2** using right hand.

4. After insertion, push the lock using left thumb  
then hold the wires and gently pull out the  
connector from jig using right hand.

n/a

Note: During insertion, hold the  
wire not rubber seal to prevent  
sagging.



1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

#### Important reminders/Note/s:

1. Please hold the wire near terminal.
  2. Make sure wires are properly inserted.
- Conduct **Pull-Push-Pull-Push**  
after insertion.  
Do not exert extra force.

#### Document references:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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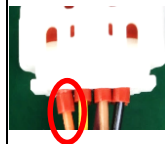

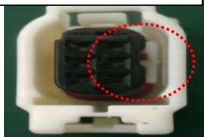


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
4	P2	Wire insertion to connector 6189-1142 (W) (continuation)	<div><p><b>Connector Orientation</b></p><p>5. Hold the connector using left hand and insert first <b>Black wire</b> to connector using right hand. <i>Note: Insertion starts from left to right</i></p></div> <div><p><b>Wire facing</b></p><p>6. Hold the connector using left hand and insert second <b>Black wire</b> to connector using right hand.</p></div>	n/a	 <p><i>Note: During insertion, hold the wire not rubber seal to prevent sagging.</i></p> <ol style="list-style-type: none"><li>1. No loose insertion</li><li>2. No wrong insertion</li><li>3. One by one insertion</li><li>4. No deformed terminal</li><li>5. No wrong wire facing</li></ol> <p><b>Important reminders/Note/s:</b></p> <ul style="list-style-type: none"><li>1. <b>Please hold the wire near terminal.</b></li><li>2. <b>Make sure wires are properly inserted.</b></li></ul> <p><b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></p> <p><b>Document references:</b></p> <ul style="list-style-type: none"><li>1. <b>Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></li></ul>
5		Connector lock	 <p>1. Put the connector into locking jig using right hand then press <b>2x</b>. Touch the connector lock to confirm if properly locked.</p> <div><p><b>BEFORE PRESSING</b></p><p><b>AFTER PRESSING</b></p></div>	<b>LOCKING JIG</b> 	<p><b>Important reminders/Note/s:</b></p> <ul style="list-style-type: none"><li>1. <b>MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></li></ul> <ol style="list-style-type: none"><li>1. No unlock/Half-locked connector</li><li>2. No damaged lock</li></ol>

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### PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

1 QUALITY POINTERS

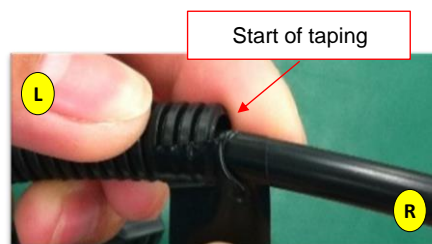
6

P2

Taping 1  
Corrugated tube to  
Sunprene tube



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



2. Hold corrugated tube using left hand then start taping using right hand.



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

MEASURING TAPE



**Important reminders/Note/s:**  
**1. Please use calibrated/verified measuring tape when getting the measurement.**

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

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### PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

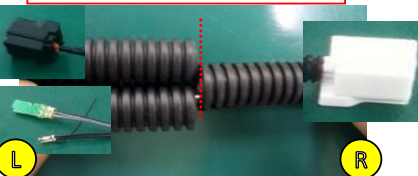
1 QUALITY POINTERS

7

P2

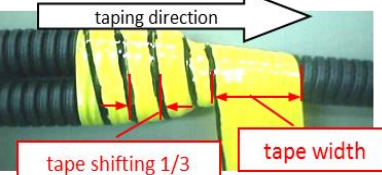
Y-Taping

**No gap between tubes**



1. Fix the corrugated tube .

**taping direction**



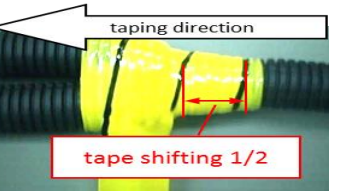
tape shifting 1/3 below

**tape width**

2. Start taping at the middle of combined Corrugated tubes, then wind the tape going to 2 corrugated tubes , width must be same with tape (19mm)

3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)

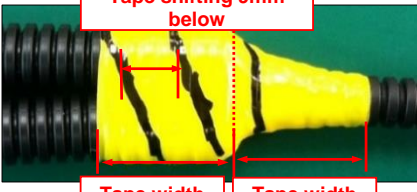
**taping direction**



tape shifting 1/2

4. Wind the tape backward 1/2 shifting.

**Tape shifting 9mm below**



**Tape width** **Tape width**

5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.

**Note:** Do not exert excessive force during pulling & winding of tape

**tape width**

n/a

### Important reminders/Note/s:

1. Use **YELLOW TAPE** for easy visualization of shifting lines, but **actual should be BLACK TAPE.**
2. Please use calibrated/verified measuring tape when getting the measurement.

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



**Y-Taping Orientation**

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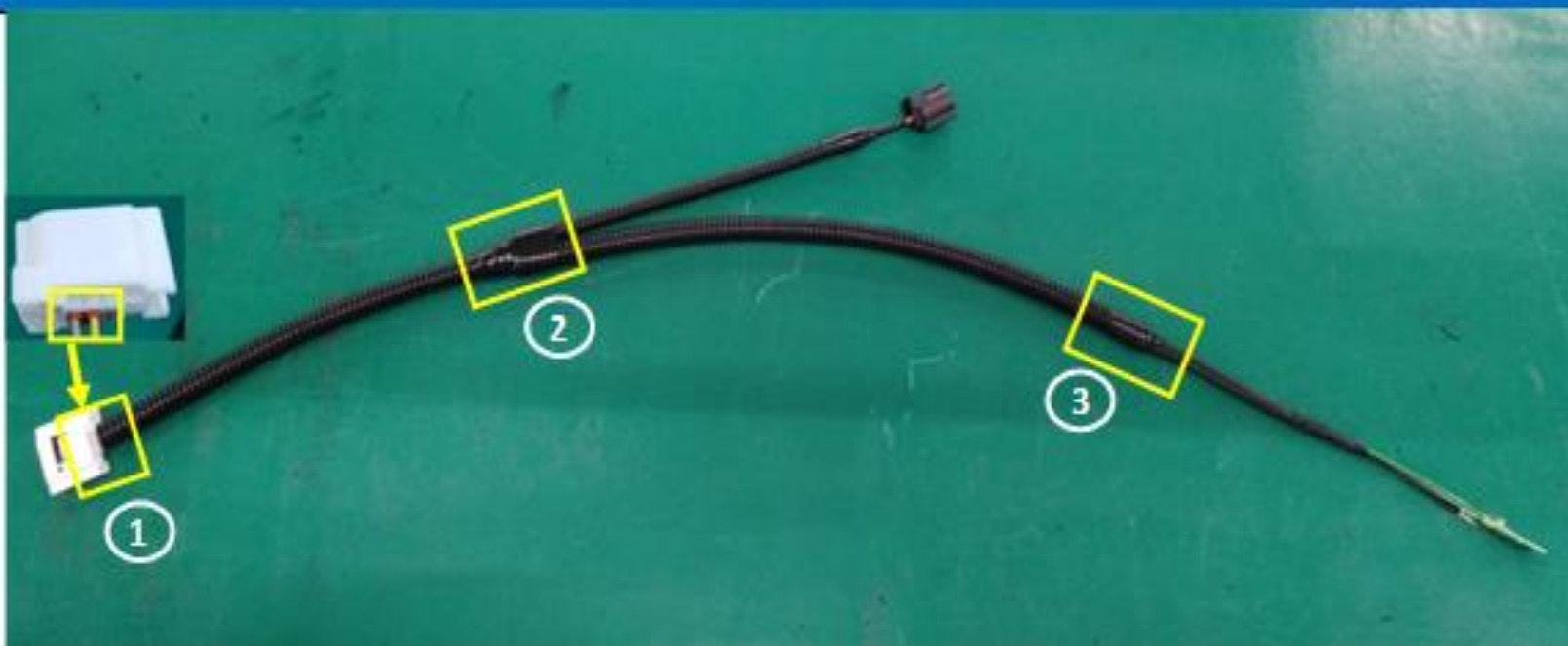
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**PARTS:**

1. Assy parts

**JIG**

n/a

**1 QUALITY CHECKPOINTS****P2****7L0047-7024****GOOD****NO GOOD****① No Wrong Insert ② ③ No Missing Tape**

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