
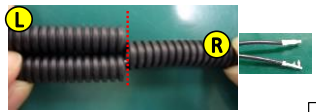
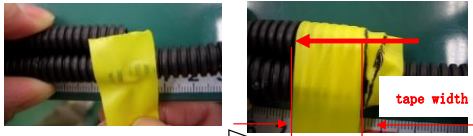
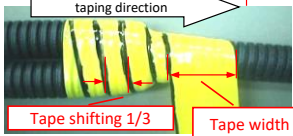
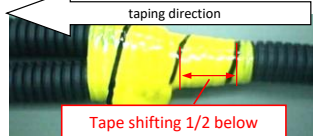
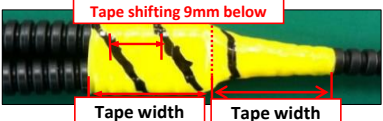





	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:	September 30, 2022		
	Process Name/Title:				Validity Date:	n/a		
	Model Code/Product Number: TP1 / 7L0087-7021		Customer: TRQSS		Document No.:	WI-ENG-PDE-049B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	5	Page No.:	1 of 6

PARTS:	1. Assy parts; Clamp 82711-34490 (B); Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	P2	Y-taping	<div>  <p>No gap between Corrugated tubes</p>  <p>1. Fix the corrugated tube.</p>  <p>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side, measurement from end of connector up to end of tape must be 43mm.</p>  <p>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)</p>  <p>4. Wind the tape backward 1/2 shifting.</p>  <p>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.</p> </div>	<div> <p>Safety Instruction Be sure to wear required 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>	<p>1.No flip out tape 2.No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wide interval between COT 6. No exposed wire</p> <p>Important reminders/Note/s:</p> <p>1. Used YELLOW TAPE for easy visualization of shifting lines, but actual should be GRAY TAPE.</p> <p>2. Do not exert excessive force during pulling & winding of tape.</p>

Revision History								Prepared by	Reviewed by	Approved by	Noted by
09/30/22	5	Change of tolerance from 35+/-3mm to 35+3/-1mm as countermeasure of encountered NG dimension from end of tape to terminal pointed tip. Improve quality pointers: Reminders/notes and references in process no.1, 2, 3, 5 and 6 due to document improvement. Work procedure/illustration in process no.5-Visual/by two's inspection.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	 M. Ariola	 J. Loterte	 C. Villanueva	 A. Arañes	
02/22/21	4	Change part number due to changes of Tape color from Black to Gray on Y-taping process. Update illustration of Urethane foam attachment; Continuity test; Visual/By two's inspection, measurement and master sample.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes					
01/30/21	3	Removal of cycle time; Put assy parts on parts section of Pg. 1-4; Conduct semi-annual review of doc's. Put additional illustration/picture on Y-taping procedure 1	M. Ariola	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	July 04, 2022

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PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

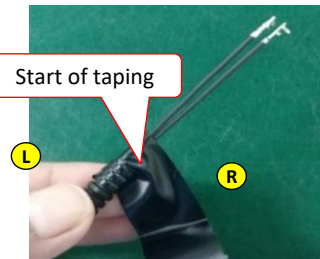
TOOLS/PPE

QUALITY POINTERS

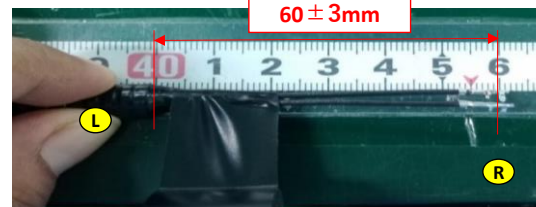
2

P2

Taping 1
Corrugated tube to wire
near terminal



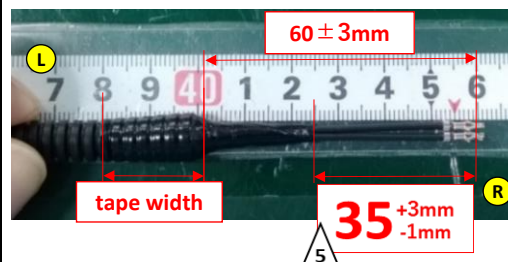
1. Hold the COT using left hand, get the **Black tape** using right hand then start pre-taping using both hands.



2. Measure from end of COT up to terminal pointed tip **60±3mm** then continue the taping process using both hands.



3. Confirm measurement of **35+3/-1mm** from end of tape up to terminal pointed tip then continue the taping process using both hands.

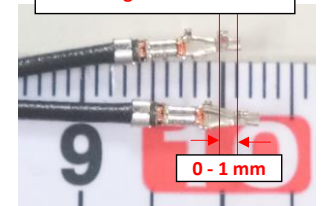


4. After taping, check the measurement, taping condition and terminal appearance.

MEASURING TAPE



Wire alignment tolerance



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

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

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PARTS:

1. Gray Urethane foam t=4; 75mm X 30mm
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

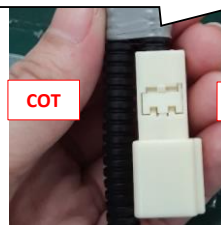
QUALITY POINTERS

3

P2

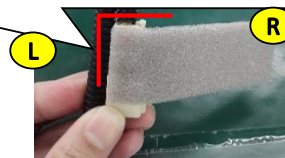
Urethane foam manual attachment to connector

Step 1: Identify the right facing to attached the foam

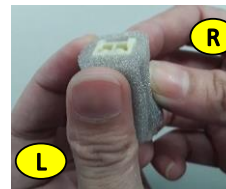
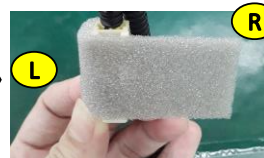


Connector

Step 2: Get the Urethane foam and begin the attachment.



Step 3: Attached the foam in all sides of the connector.



Step 4: Press the Urethane foam side by side after attachment.

n/a

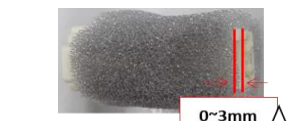
5

Important reminders/Note/s:

1. Do not stretch the urethane foam.
2. Foam and Urethane foam must be align.
3. Follow the attachment sequence based on the illustration.
4. Tolerance from Urethane foam to connector must be 0~3mm

5

URETHANE FOAM CONDITION



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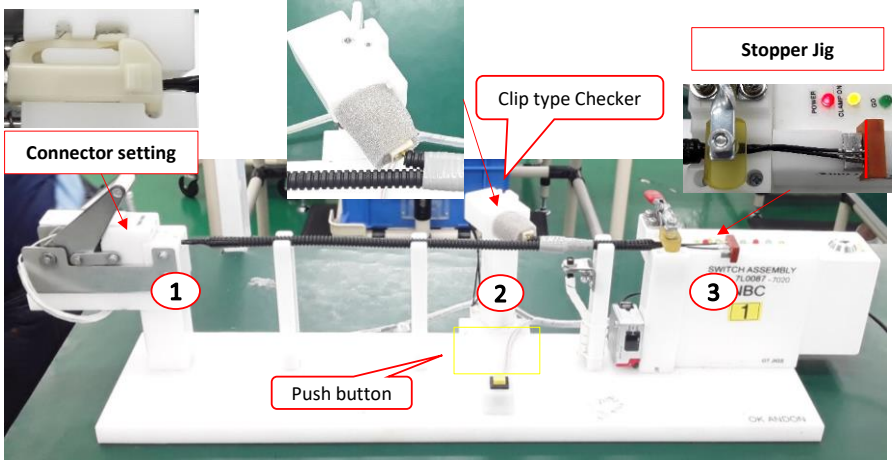
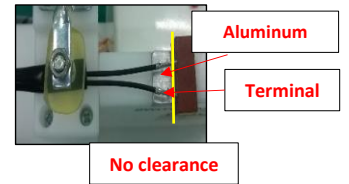
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PARTS:		1. Assy parts		JIG	1. Continuity test jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	<div><p>1. Get the assy parts and set to tester jig using both hands. First put the connector into CHECKER 1 and pull down to lock. Second, put the connector with foam to CHECKER 2. And last, put the wires into stopper jig and pull down the toggle clamp. <i>Refer to above illustration for proper setting.</i></p><p>2. Check if all LED light for Power ON, Clamp on was ON. If encounter abnormality or hearing NG buzzer, STOP and immediately CALL the attention of the leader. WAIT for further instruction before proceed to process.</p><p>3. Press the SW button using right finger. Conduct POINT CHECKING before removing from jig.</p></div>		n/a	<div><p>1. No wrong insert 2. Make sure no gap between terminal and stopper jig</p></div>

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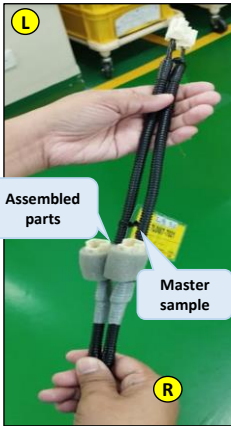
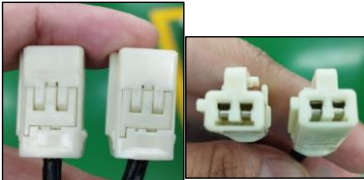




☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assembled parts 2. Master sample		JIG	n/a
NO.	PROCESS NAME		5 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	Visual/By Two's inspection	<div><p>ACTUAL PRODUCT</p></div>		<div>MASTER SAMPLE</div> <div></div> <div>5</div> <div>1. No skip checking during inspection.</div>
			<div><div><div><p>Assembled parts</p><p>Master sample</p></div><div>1. Conduct alignment of harness (Master sample vs. Assembled parts) using both hands.</div></div><div><div><p>2. Check the terminal, insertion and presence of urethane foam.</p></div><div><p>4. Check the Y-Taping condition.</p></div></div><div><div><p>3. Check the terminal, insertion and presence of urethane foam.</p></div><div><div><p>5. Check the terminal, insertion and taping condition. Must no deformed terminal.</p></div><div></div></div></div></div>		

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Purpose:



PROTOTYPE



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PARTS:

n/a

JIG

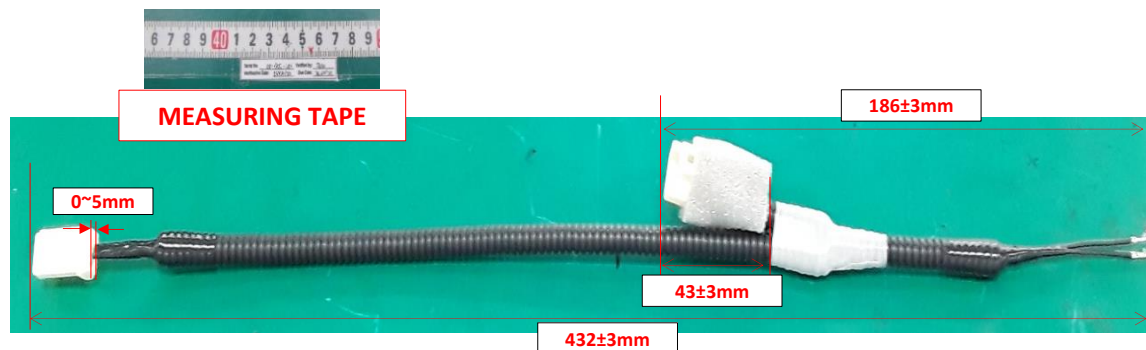
n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

6

P2

Measurement



1. No wrong dimension

Important reminders/Note/s:

1. For Hatsumono and Owarimono.
2. Please use calibrated/ verified measuring tape when getting the measurement.

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