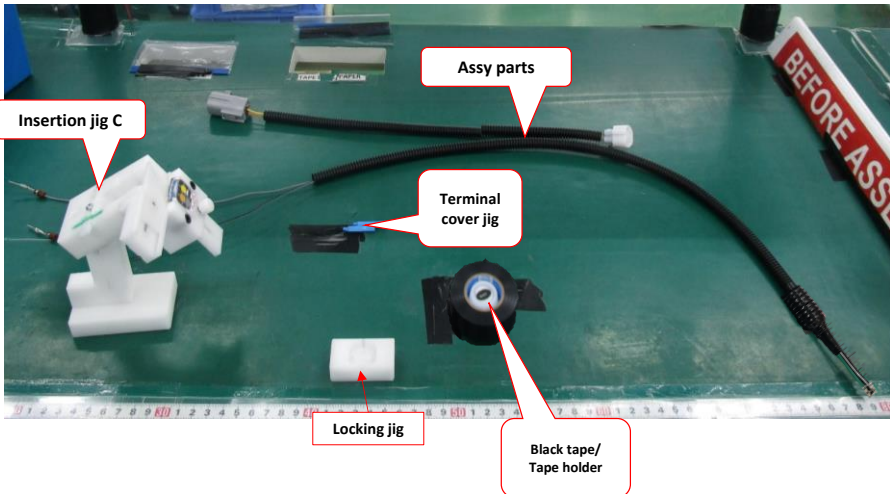
	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date:	<b>March 7, 2023</b>		
	Process Name/Title:				Validity Date:	n/a		
	Model Code/Part Number: <b>177D / 7L0128-7020A</b>		Customer: <b>TRQSS</b>		Document No.:	<b>WI-ENG-PDE-352B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	1 of 8

<b>PARTS:</b>		1. Assy parts; Black tape		<b>JIG:</b>		1. Insertion jig 2. Locking jig 3. Terminal cover 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;"> <b>Table Lay-out</b> </div> 		<div style="border: 1px dashed red; padding: 5px;"> <b>Safety Instruction</b>            Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>		1. No missing parts/tools 2. No excess parts/tools	

Revision History				Prepared by		Reviewed by		Approved by		Noted by	
03/07/23	2	Work instruction improvement. Improve work procedure/ Illustration and Quality pointers. Inclusion of Quality checkpoints (Page 8).				D. Castillo	J. Loterte	C. Villanueva	A. Arañes		
01/17/22	1	Change from Pre-launch to Masspro. Additional Table Lay-out; Change part number from 7L0128-7020 to 7L0128-7020A due to change in COT length from $\phi 5 L=517\pm 5\text{mm}$ to $\phi 5 L=512\pm 2\text{mm}$ due to removal of tolerance from COT to MR SW.				K. Doria	J. Loterte	C. Villanueva	A. Arañes		
10/13/21	0	Initial issue				K. Doria	J. Loterte	C. Villanueva	A. Arañes		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	October 13, 2021

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**WORK INSTRUCTION**

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Effectivity Date:

**March 7, 2023**

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**177D / 7L0128-7020A**

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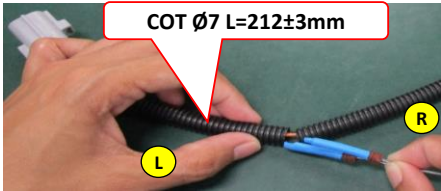
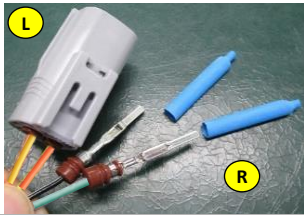

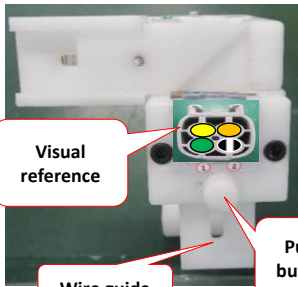
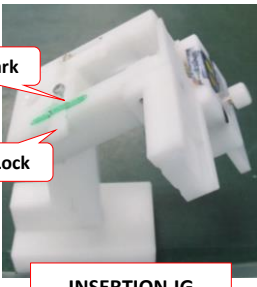
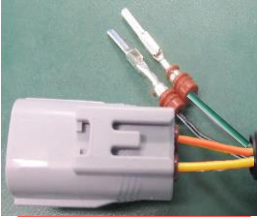
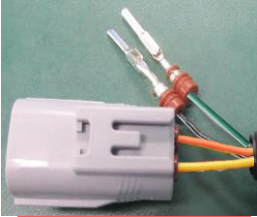
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PARTS:		1. Assy parts			JIG	1. Terminal cover jig 2. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P2 Wire insertion to assy parts	 <p>1. Get the <b>TVSSf G-B/W wires L=822±3mm</b> using both hands then insert the terminal cover jig using right hand.</p>  <p><b>COT Ø7 L=212±3mm</b></p> <p>2. Get the assy parts then hold the COT (no slit) <b>Ø7 L=212±3mm</b> using left hand then insert the <b>TVSSf G-B/W wires L=822±3mm</b> using right hand.</p>  <p>3. After insertion, remove the cover jig using right hand.</p>			 <p><b>TERMINAL COVER JIG</b></p>	1. No wrong usage of parts 2. No damaged rubber seal 3. No exposed rubber seal during insertion
3	Connector setting to insertion jig 6188-0066 (GR) (Assy parts)	 <p><b>Visual reference</b></p> <p><b>Wire guide</b></p> <p><b>Push button</b></p>  <p><b>I-mark</b></p> <p><b>Lock</b></p>  <p><b>INSERTION JG ORIENTATION</b></p>  <p><b>CONNECTOR ORIENTATION</b></p>			n/a	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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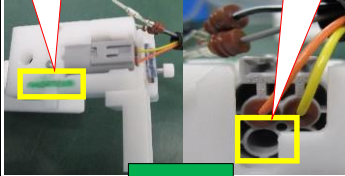
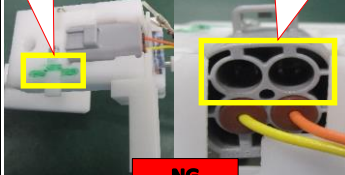
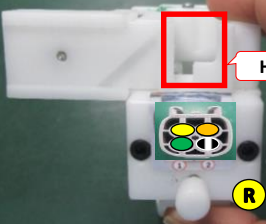
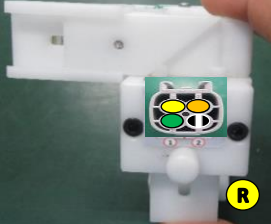
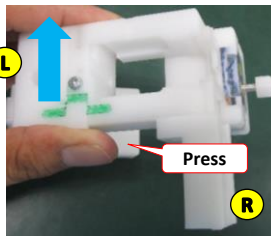
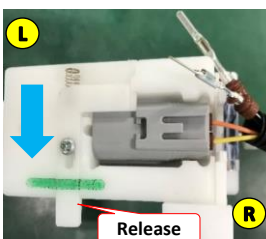
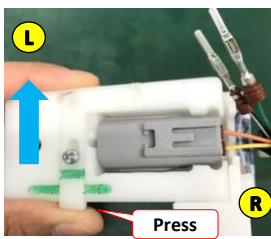
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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Connector setting to insertion jig 6188-0066 (GR) (Assy parts) (Continuation)		n/a	<div>CONNECTOR ORIENTATION ILLUSTRATION</div> <div><div>I-mark is align</div><div>1 hole is open</div><div></div><div>GOOD</div></div> <div><div>I-mark is not align</div><div>2 holes are open</div><div></div><div>NG</div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>
		<div><div>Hole</div><div>1. Push the lower wire guide upward using right thumb. Slot for <b>Green wire</b> will be opened.</div></div> <div><div>Press</div><div>2. Press the lock using left thumb.</div></div> <div><div>Press</div><div>Release</div><div>3. Get the connector <b>6188-0066 (GR)</b> using right hand and insert to insertion jig. Release the lock after insertion. <b>Note: Follow the connector orientation.</b></div></div>			

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☐ PRE-LAUNCH

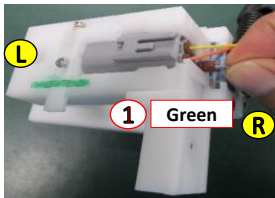

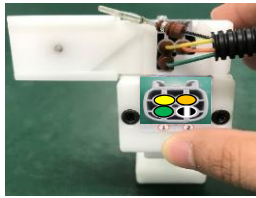


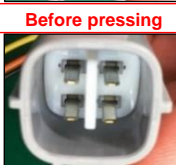
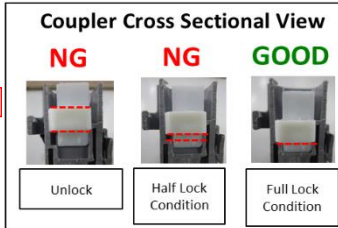

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PARTS:		1. Assy parts			JIG	1. Insertion jig 2. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
4	P2	<div><p>1 Hold the <b>G wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p>WIRE FACING</p></div> <div><p>2. Press the button using right thumb. The slot for <b>B/W wire</b> will be opened.</p></div>			n/a	2 <b>Important reminders/Note/s:</b> 1. <b>Please hold the wire near terminal.</b> 2. <b>Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b>  <b>Document references:</b> 1. <b>Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> 2. <b>Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b>	
5		<div><p>1. Put the connector into locking jig using both hands and then conduct <b>2x</b> pressing. Check the connector if properly locked.</p></div> <div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><p>Coupler Cross Sectional View</p><p>NG NG GOOD</p><p>Unlock Half Lock Condition Full Lock Condition</p></div>			LOCKING JIG 	2 <b>Important reminders/Note/s:</b> 1. <b>MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b>  1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damaged lock	

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## TAPING ASSEMBLY PROCESS

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☐ PRE-LAUNCH

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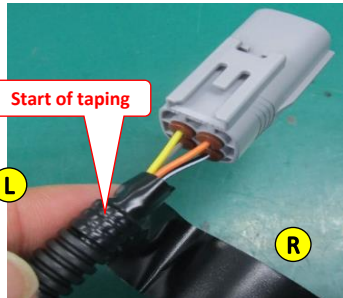
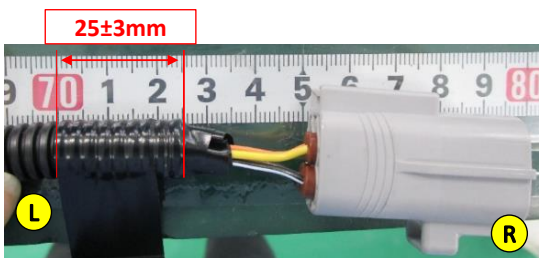
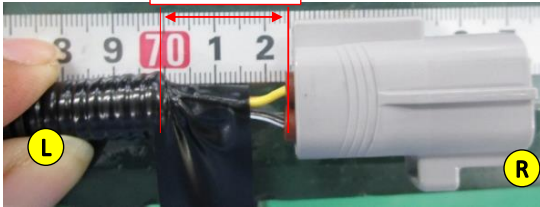
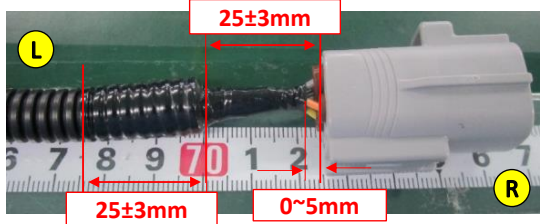

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### PARTS:

1. Assy parts
2. Black tape

### JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2 Taping 2 Black corrugated tube to wire near connector	<div><p>1. Hold the corrugated tube using left hand then start taping using right hand.</p></div> <div><p>2. Confirm <b>25±3mm</b> measurement from end of tape up to end of corrugated tube then continue the taping process using both hands.</p></div> <div><p>3. Measure from end corrugated tube up to edge of connector <b>25±3mm</b> then continue the taping process using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<div></div>	<ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ol> <div><p><b>Important reminders/Note/s:</b></p><p><b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p><p><b>Document reference/s:</b></p><p><b>1. Please refer to WI-PRO-ASY-001 for taping procedure.</b></p></div>

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

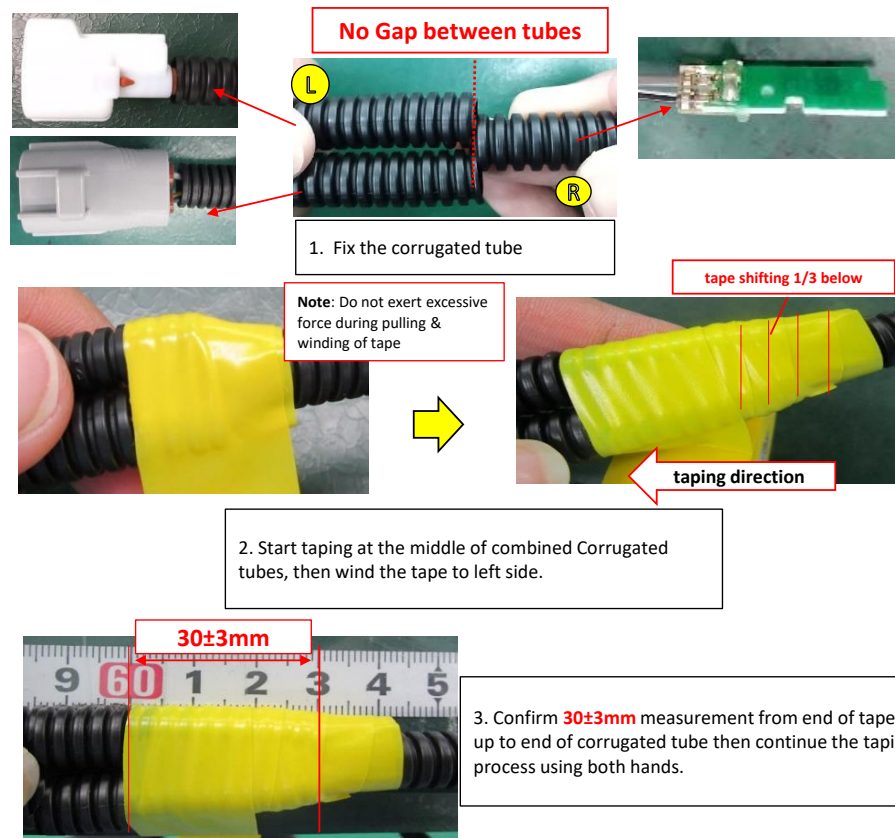
TOOLS/PPE

QUALITY POINTERS

7

P2

Y-Taping



MEASURING TAPE



2

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

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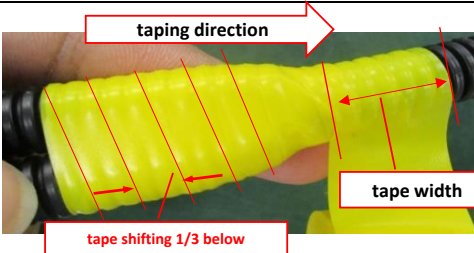
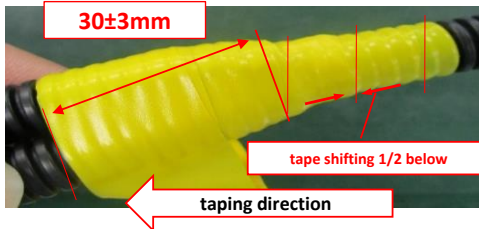
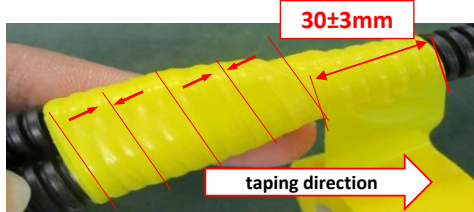
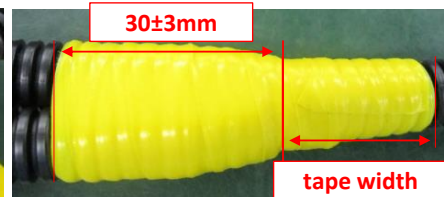


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## PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P2 Y-Taping (Continuation)	<div><p>4. Wind the tape <b>1/3 shifting</b> until it reach the other side of corrugated tube (must be tape width).</p></div> <div><p>5. Make <b>2 windings</b> of tape then wind <b>1/2 shifting</b> going to other side.</p></div> <div><p>6. Make <b>2 windings</b> of tape then wind the tape <b>1/2 shifting</b> going to other side of corrugated tube then make <b>3 windings</b> of tape and cut.</p></div> <div><p>7. After taping, check the measurement and tape condition.</p></div>	<div>MEASURING TAPE</div> 	<div><p><b>Important reminders/Note/s:</b></p><ol style="list-style-type: none"><li>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</li><li>2. Please use calibrated/verified measuring tape when getting the measurement.</li></ol></div> <div><ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ol></div>

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PROTOTYPE



PRE-LAUNCH



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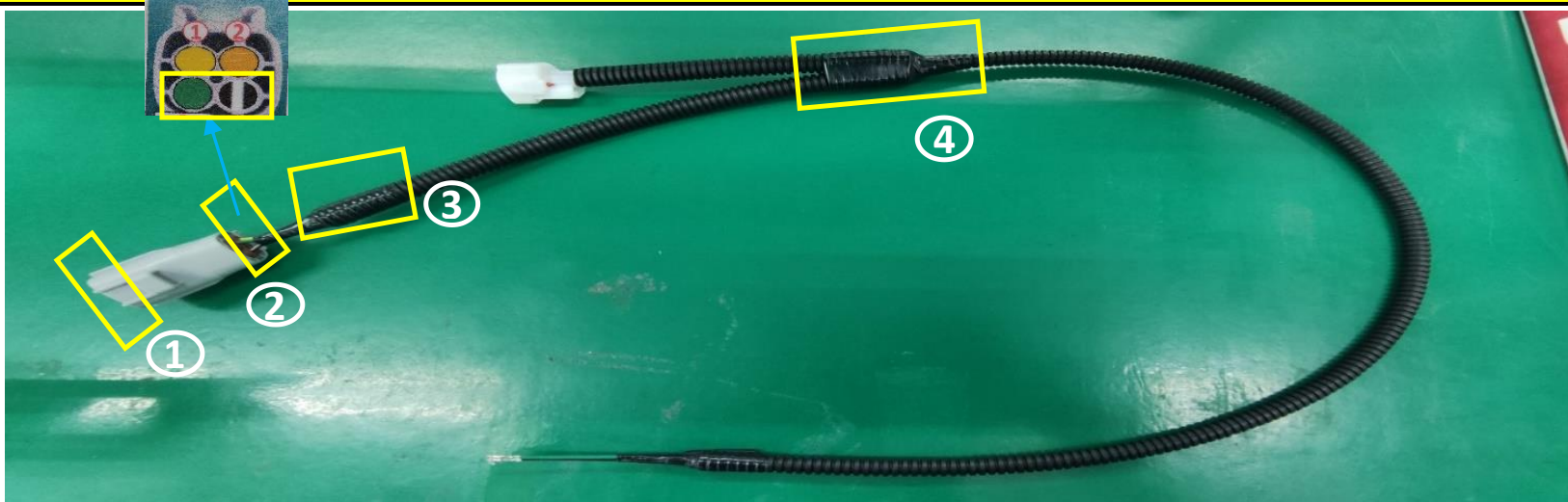
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**8 of 8****PARTS:**

n/a

**JIG**

n/a

**QUALITY CHECKPOINTS****P2****7L0128-7020A****NO GOOD****GOOD****1 No Unlock/ Half Lock Connector****3 No Missing Tape****2 No Wrong Insert****4 No Missing Y-Tape**

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