



WORK INSTRUCTION

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

Model Code/Part Number: **TP1 / 7L0088-7022**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

October 7, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-057B

Revision No.:

6

Page No.:

1 of 6

PARTS:

1. Assy parts
2. Gray tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

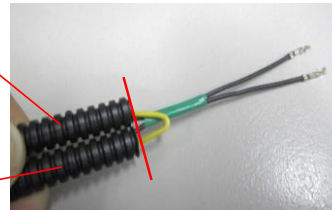
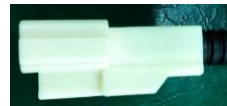
TOOLS/PPE

QUALITY POINTERS

1

P2

Y-Taping



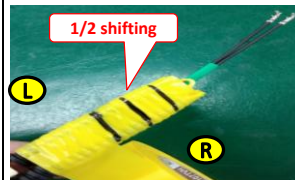
1. Fix the two (2) COT.



Start of taping



2. Get the **Gray tape** using right hand then make **2 winds pre-taping** before shifting.



1/2 shifting



43±3mm

3. Make **1/2 shifting** going left side then measure from connector up to tape **43±3mm** then make **2 winds** before shifting using both hands.

Safety Instruction

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

MEASURING TAPE



1. No peel-off tape
2. No flip-out tape
3. No wide interval between the 2 COT
4. No exposed wire
5. No wrong dimension

Important reminders/Note/s:

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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
10/07/22	6	Change tolerance from 35+/-3mm to 35+3/-1mm as countermeasure of encountered NG dimension from end of tape up to terminal tip on process no.1. Improve quality pointers: Reminders/notes and references in page no.1 to 6 due to document improvement. Work procedure/illustration on process no.4- Visual/by two's inspection.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
02/15/21	5	Change in tape color on Y-taping from Black tape to Gray tape. Update pictures on process number 3, 4 & 5.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
02/03/21	4	Apply some improvements. Remove cycle time in every process. Conduct semi-annual review of documents.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	December 16, 2019		

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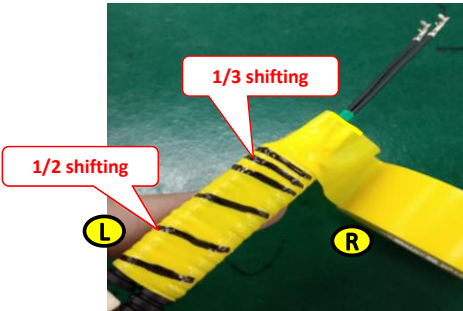
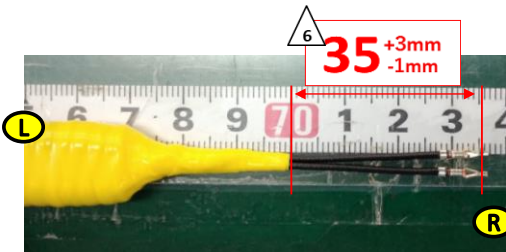

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Gray tape		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2 Y-Taping (Continuation)	 <p>4. Make 1/2 shifting going right side and another 1/3 shifting until it reach the 35+3/-1mm measurement from end of tape up to terminal pointed tip.</p>  <p>5. After taping, check the measurement, taping condition and terminal appearance.</p>			<p>1. No peel-off tape 2. No flip-out tape 3. No wide interval between the 2 COT 4. No exposed wire 5. No wrong dimension</p> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Used YELLOW TAPE for easy visualization of shifting lines, but actual should be GRAY TAPE</p>

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PARTS:

1. Urethane foam t=4; 75mm X 30mm

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

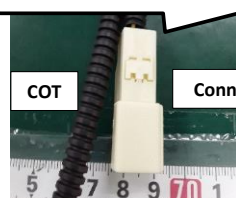
QUALITY POINTERS

2

P2

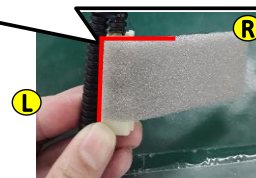
Urethane foam attachment

Step 1: Identify the right facing to attached the foam

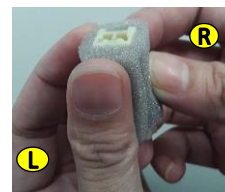
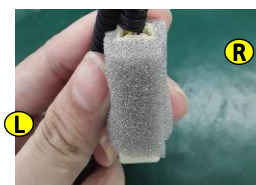
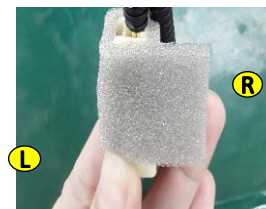
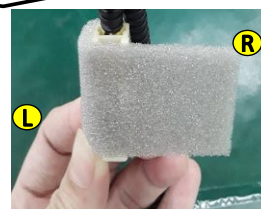


Connector

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

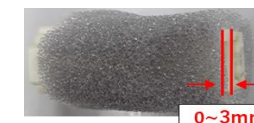
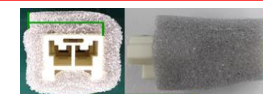
1. No damaged Urethane foam
2. No missing Urethane foam
3. No stretched Urethane foam



Important reminders/Note/s:

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

URETHANE FOAM CONDITION



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☐ PROTOTYPE

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PARTS:

1. Assy parts

JIG

1. Tester jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

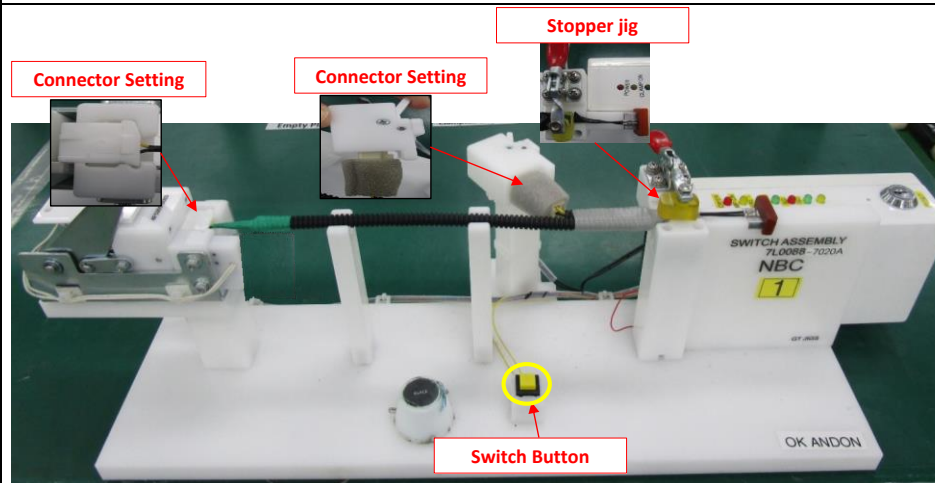
TOOLS/PPE

QUALITY POINTERS

3

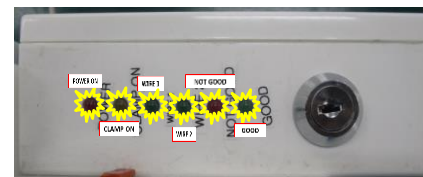
P2

Continuity test



1. Get the assy parts and set to tester jig using both hands. *(See above picture for correct setting)*. First set the connector **4F5260-0000 (W)** to **Receiver base 1** then pull the checker fixture for continuity checking. Second, set the connector **7282-1028 (W)** to **Clip checker** then lock. Last, set the **B-B wires** to together within the stopper jig then press by toggle clamp.

2. Check if all **LED** light for **Power ON, Wire1 & Wire2** was **ON**. If encounter abnormality or hearing **NG** buzzer, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process.



3. Press the **SW** button using right index finger for continuity checking.

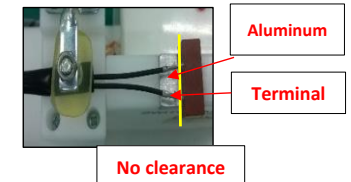
4. Conduct **POINT CHECKING** before removing the harness from jig.

n/a

6 Important reminders/Note/s:

1. **Terminals should touch the aluminum to check the continuity of wires.**

1. No wrong insert
2. Make sure no gap between terminal and stopper jig
3. No wrong use of tape



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☐ PROTOTYPE

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PARTS:

1. Assembled parts
2. Master sample

JIG

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

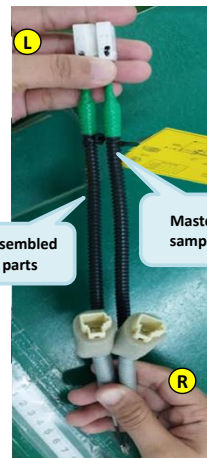
QUALITY POINTERS

4

P2

Visual/By Two's Inspection

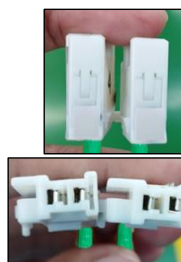
ACTUAL PRODUCT



Assembled parts

Master sample

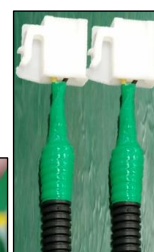
1. Conduct alignment of harness (Master sample vs. Assembled parts) using both hands.



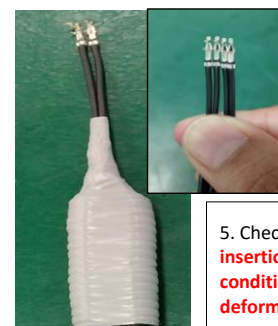
2. Check the connector lock, terminal taping condition and color of tape.



4. Check the Y-Taping condition.

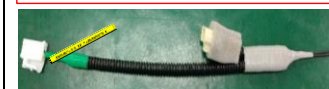


3. Check the terminal, insertion and presence of urethane foam.



5. Check the terminal, insertion and taping condition. Must no deformed terminal.

MASTER SAMPLE



1. No skip checking during inspection.

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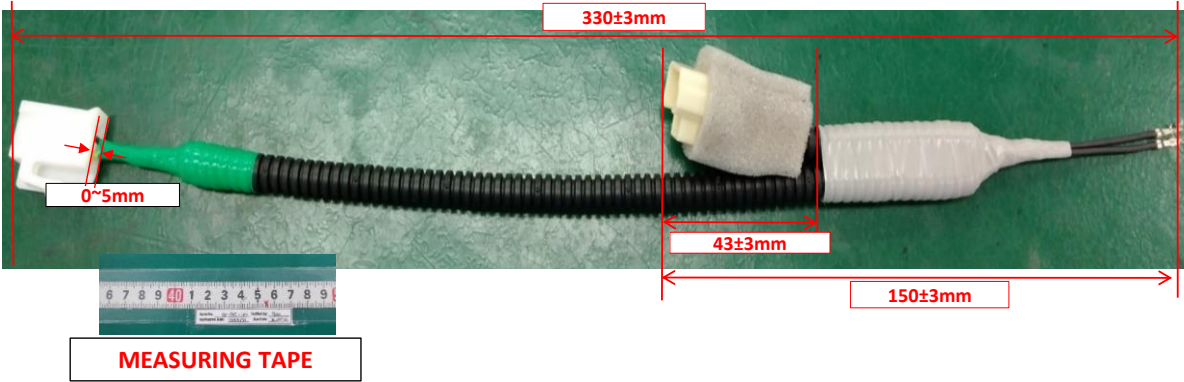
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PARTS:		n/a	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Measurement	 <p>MEASURING TAPE</p>		<p>1.No wrong dimension.</p> <p>6 Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono and Owarimono only.</p>
	P2			

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