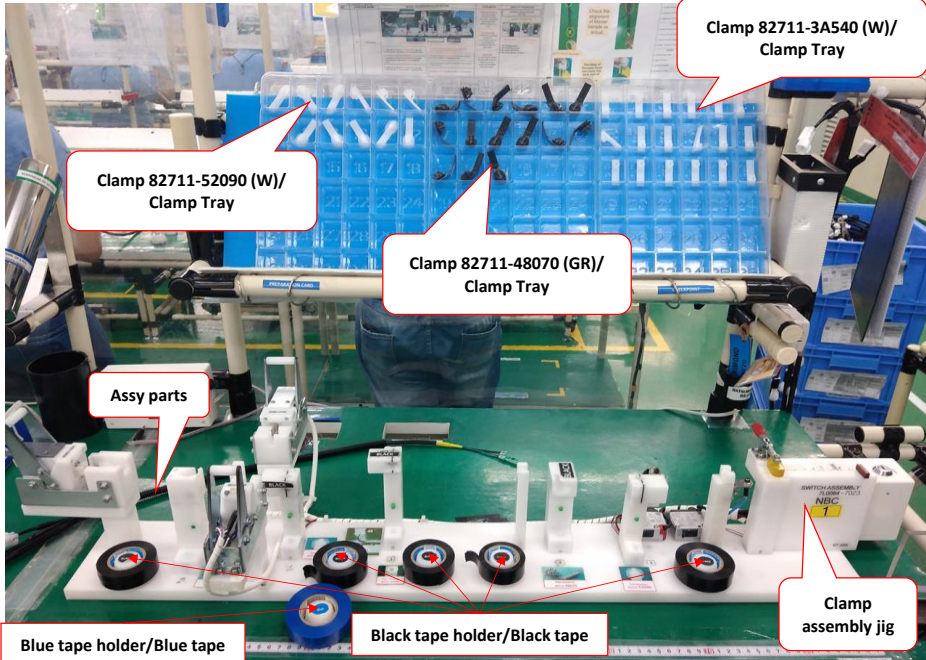
	<b>WORK INSTRUCTION</b>			Effectivity Date:	April 26, 2023		
	<b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Process Name/Title:			Model code/Part number:	<b>500B / 7L0084-7023</b>	Customer:	<b>TRQSS</b>
	Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Document No.:	WI-ENG-PDE-426C	
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<b>PARTS:</b>	1. Assy parts 2. Clamp 82711-52090 (W) 3. Clamp 82711-48070 (GR) 4. Clamp 82711-3A540 (W) 5. Black tape [5pcs.] 6. Blue tape [1pc.]	JIG:	1. Insertion jig 2. Locking jig 3. Terminal cover jig
---------------	--	------	---

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3	Table Lay-out	<div> <p><b>TABLE LAY-OUT</b></p>  </div> <div> <p><b>Safety Instruction</b></p> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b></p> <ol style="list-style-type: none"> <li>1. Maintain and always practice 5's.</li> <li>2. Personal things on the workplace is prohibited. Keep it in your locker.</li> </ol> <p><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<ol style="list-style-type: none"> <li>1. No missing parts/tools</li> <li>2. No excess parts/tools</li> <li>3. No wrong position of parts/tools</li> </ol>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
04/26/23	3	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a	
11/12/22	2	Improve quality pointers, notes reference in process no.2,3,4,5 and 6 as document improvement. Work procedure and illustration in process no.5 - visual/by two's inspection	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	
03/23/22	1	Change document purpose from Pre-launch to masspro	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	
03/21/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:
							March 21, 2022

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

April 26, 2023

Process Name/Title:

Model code/Part number:

500B / 7L0084-7023

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### PARTS:

1. Assy parts
2. Clamp 82711-52090 (W) [2pcs.]
3. Clamp 82711-48070 (GR) [2pcs.]

4. Clamp 82711-3A540 (W)
5. Black tape [5pcs.]

### JIG

1. Clamp Assembly jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

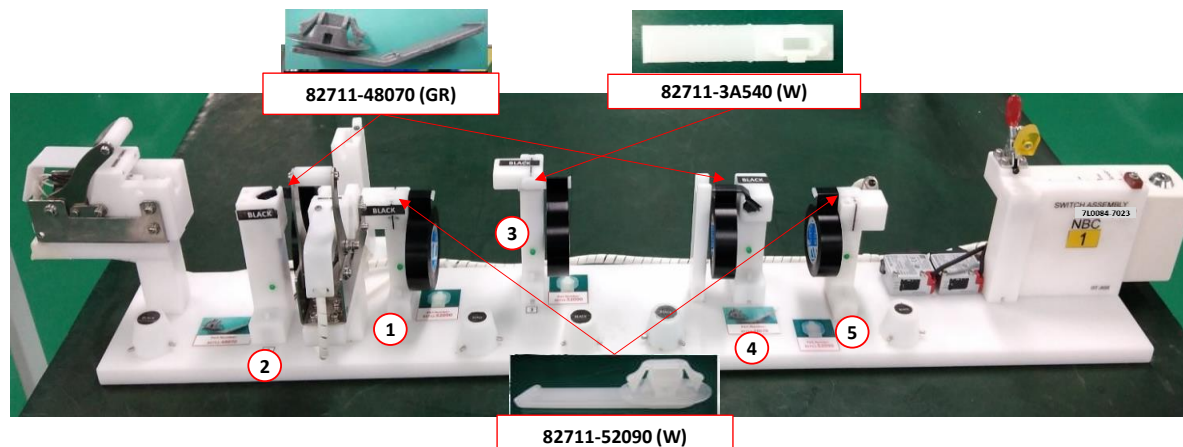
### TOOLS/PPE

### QUALITY POINTERS

2

P3

Clamp setting



#### STANDARD TAPING FOR CLAMP

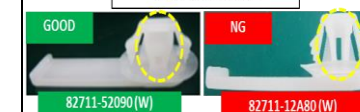
One side tape under clamp

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

#### Important reminders/Note/s:

1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.

#### CLAMP ILLUSTRATION



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## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: **500B / 7L0084-7023**Customer: **TRQSS**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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## PARTS:

1. Assy parts
2. Blue tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

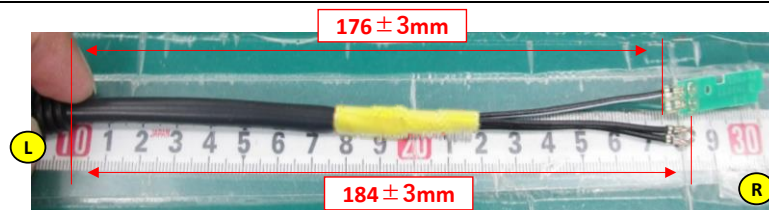
TOOLS/PPE

QUALITY POINTERS

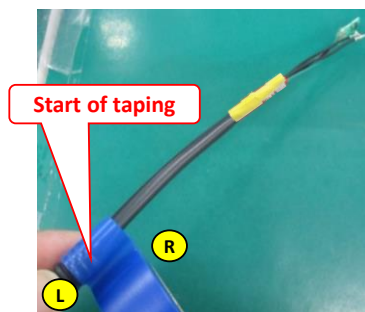
3

P3

Taping 1  
Black corrugated tube to  
Black sunprene tube



1. Measure from end of sunprene tube up to edge of hotmelted wire  $176 \pm 3\text{mm}$  and up to terminal pointed tip  $184 \pm 3\text{mm}$  using both hands.



2. Get the **Blue tape** using right hand then start taping process using both hands.



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

## MEASURING TAPE



**Important reminders/Note/s:**  
**1. Use BLUE TAPE only**  
**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 use of tape
6. No wrong dimension

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## PARTS:

1. Assy parts
2. Black tape

## JIG

1. Clamp Assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

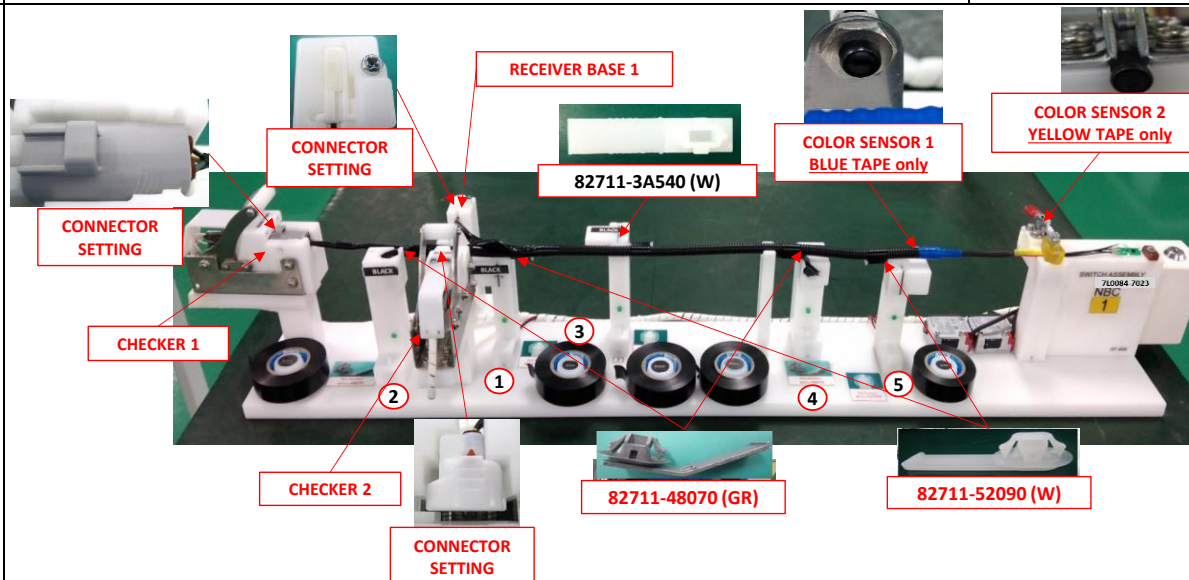
## TOOLS/PPE

## QUALITY POINTERS

4

P3

Clamp Assembly



1. Get the assy parts and set into jig. (*See above picture for correct setting of harness*). First, set the connector **6188-0066 (GR)** to **Checker 1** then pull the checker fixture for continuity checking. Second, set the connector **6189-0451 (W)** to **Checker 2** then pull the checker fixture for continuity checking. Third, set the connector **6098-3810 (W)** to **Receiver base 1** then lock. Continue to set the harness in jig. **Color sensor 1** will beep/buzz if sensor detects **Blue tape**. **Color sensor 2** will beep/buzz if sensor detects **Yellow tape**. Last, set the hotmelted wires and terminal end together within the stopper then press by **Toggle clamp**. Check if the sequence light of location **1** was **ON**.

2. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2, Color sensor 1 and Color sensor 2** was **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.



## Important reminders/Note/s:

1. Make sure no gap between stopper and PCB

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

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# WORK INSTRUCTION

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Model code/Part number: **500B / 7L0084-7023**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

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## PARTS:

1. Black tape
2. Assy parts

## JIG

1. Clamp Assembly jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

## QUALITY POINTERS

4

P3

Clamp Assembly  
(Continuation)



3. Hold the tape on clamp location **1**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **2** was **ON**.

4. Hold the tape on clamp location **2**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **3** was **ON**.



### Important reminders/Note/s:

1. Make sure no gap between stopper and PCB

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

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## PARTS:

1. Black tape
2. Assy parts

## JIG

1. Clamp Assembly jig

## NO.

## PROCESS NAME

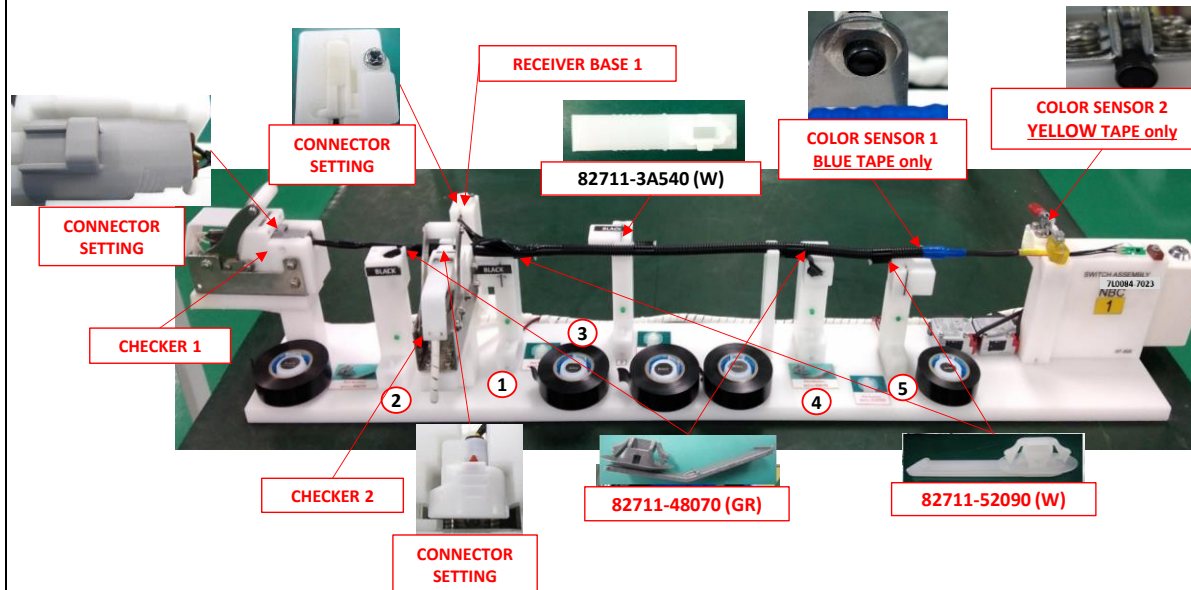
## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

## QUALITY POINTERS

4

P3

Clamp Assembly  
(Continuation)

5. Hold the tape on clamp location **3**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **4** was **ON**.

6. Hold the tape on clamp location **4**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light in clamp location **5** was **ON**.

7. Hold the tape on clamp location **5**. Make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. **Go** sound will be heard.

8. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.



## Important reminders/Note/s:

1. Make sure no gap between stopper and PCB

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

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## WORK INSTRUCTION

### TAPING ASSEMBLY PROCESS

Process Name/Title:

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Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

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#### PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

**2** WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

P3

Visual Inspection/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, insertion** and **taping condition**.

3. Check the **presence of clamp attachment** and **taping condition**.

4. Check the **connector lock, terminal, insertion** and **taping condition**.

**MASTER SAMPLE**



1. No skip checking during inspection

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# WORK INSTRUCTION

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Model code/Part number: 500B / 7L0084-7023

Customer: TRQSS

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

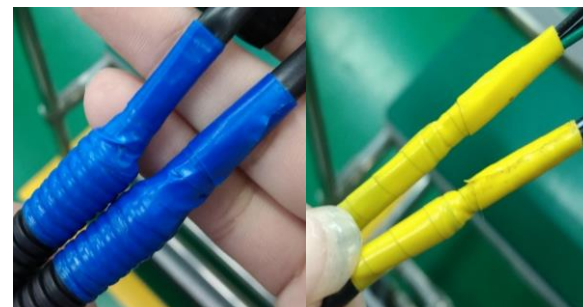
5

P3

Visual/By two's inspection  
(Continuation)



5. Check the **presence of clamp attachment** and **taping condition**.



6. Conduct **the presence** and **colored tape used** and **taping condition**.



7. Check the **terminal and PCB appearance**. Must be **no deformed terminal**.

MASTER SAMPLE



1. No skip checking during inspection

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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

Measurement

P3



**Important reminders/Note/s:**  
**1. FOR HATSUMONO AND OWARIMONO**

1. No wrong dimension

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**WORK INSTRUCTION**  
**TAPING ASSEMBLY PROCESS**

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Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Document No.:	WI-ENG-PDE-426C
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**PARTS:** 1. Assy parts

**JIG** n/a



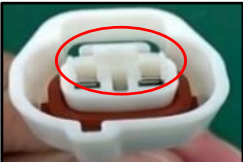
**QUALITY CHECKPOINTS**

**P3**

**7L0084-7023**



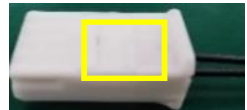
**GOOD**



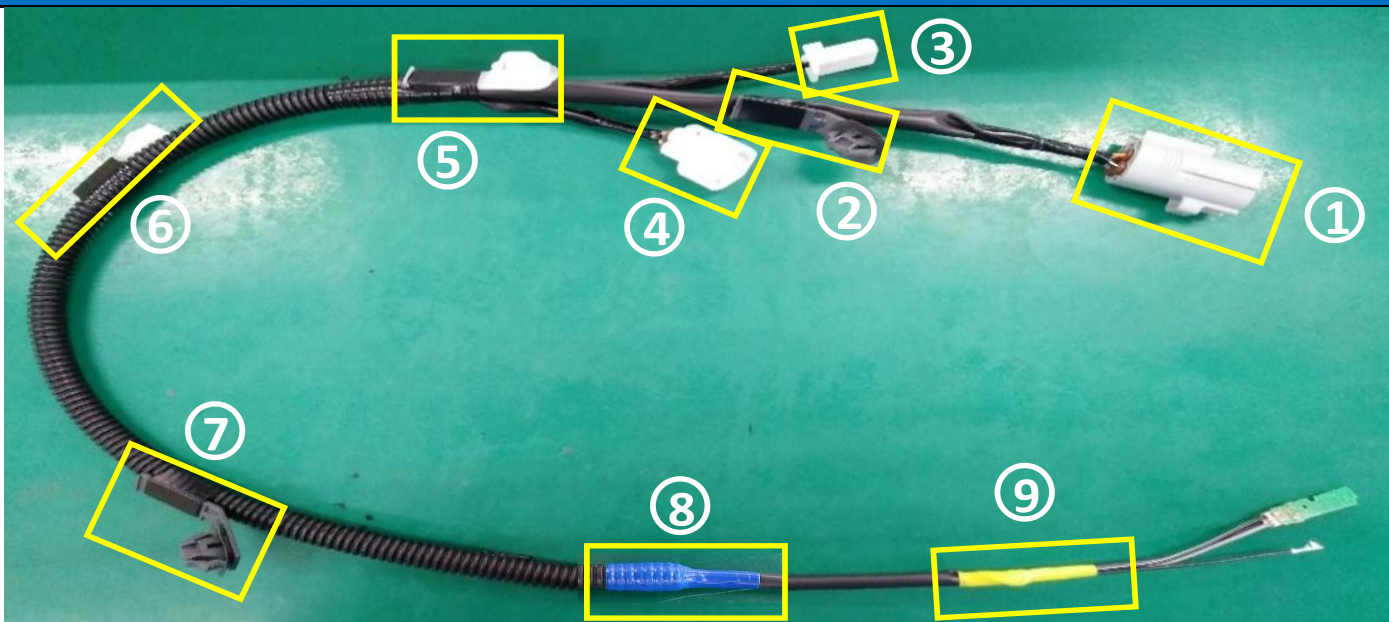
**NO GOOD**



**NO**



**GOOD**



① ③ ④ **NO UNLOCKED/ HALFLOCKED CONNECTOR**

② ⑤ ⑥ ⑦ **No Missing Clamp**

⑧ ⑨

**No WRONG USE of tape/**



**NO GOOD**



**GOOD**

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