



## WORK INSTRUCTION

### TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: **840B / 7N0121-7021**

Customer:

**TRJ**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

**November 4, 2024**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-624**

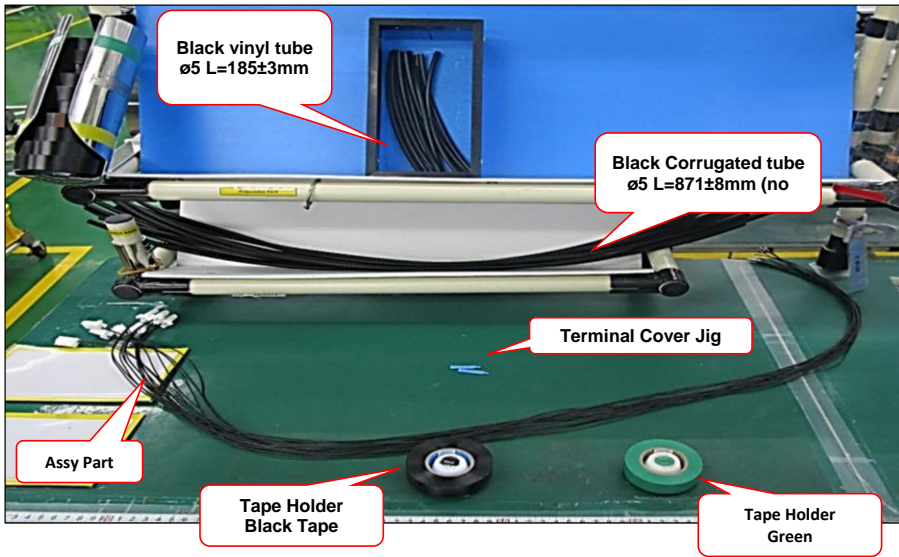
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PARTS:	1. Assy parts	3. Black SV tube (Vinyl) $\phi 5$ L=185 $\pm$ 3mm;	5.	JIG:	1. Terminal cover jig
	Green tape [19mm]	4. Black tape [19mm];			

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out 	<b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)  <b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.  <b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No missing parts/tools 2. No excess parts/tools

Revision History								Prepared by	Reviewed by	Approved by	Noted by
11/04/24	2	Improve measurement and visual inspection. Removal of by two's inspection.	A. Hernandez	C. Villanueva	A. Arañes	n/a					
02/08/23	1	Change document purpose from pre-launch to masspro	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
01/19/23	0	Initial issue Clamp 82711-12A60 (W) quantity from 5pcs. to 4pcs. Clamp 82711-52070 (W)	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	January 19, 2023			

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**PARTS:**

1. Assy parts
2. Black Corrugated tube  $\phi 5$  L=871 $\pm$ 8mm (No slit)

**JIG**

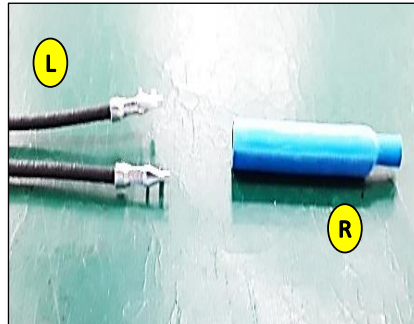
1. Terminal cover jig

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

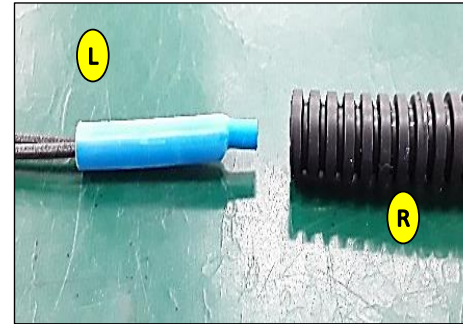
2

P1

Wire insertion to Black  
Corrugated tube  
 $\phi 5$  L=871 $\pm$ 8mm  
(no slit)



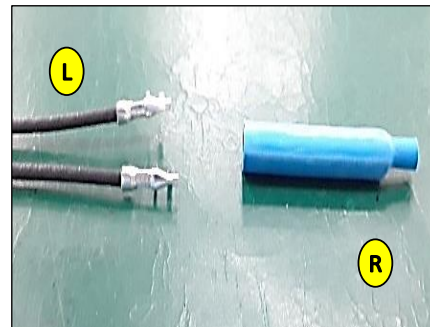
1. Get the terminal cover jig using right hand then insert to **B-B wires**.



2. Get the Black Corrugated tube (no slit)  $\phi 5$  L=871 $\pm$ 8mm using right hand and insert to **B-B wires**.

**TERMINAL COVER JIG**

1. No wrong use of parts
2. No deformed terminal



3. After insertion, remove the terminal cover jig using right hand.

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**PARTS:**

1. Assy parts
2. Black tape (19mm)

**JIG**

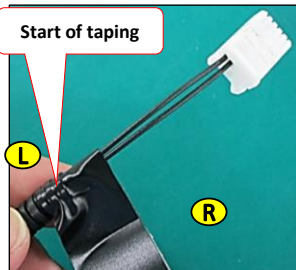
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**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

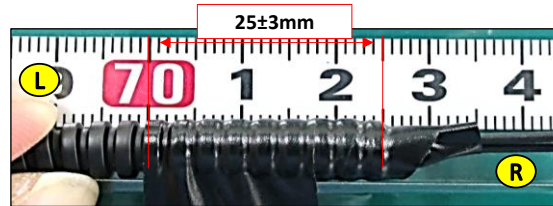
3

P1

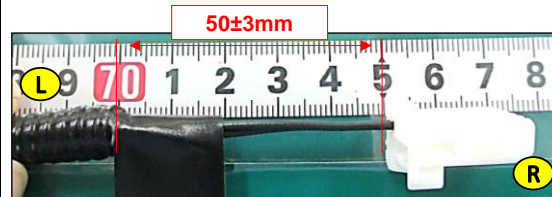
Taping 1  
Black COT to Wire near  
connector



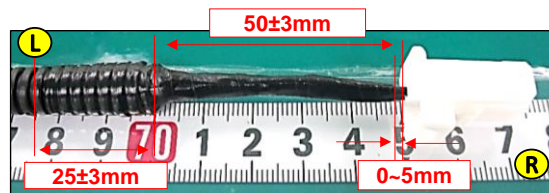
1. Hold the assy parts, get the **Black tape** using right hand then start taping process using both hands.



2. Confirm measurement of **25±3mm** from end of tape up to end of Black COT then continue the taping process using both hands.



3. Measure from end of COT up to edge of connector **50±3mm** then continue the taping process using both hands.



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

**MEASURING TAPE**

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

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

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**PARTS:**

1. Assy part
2. Black SV tube (Vinyl)  $\phi 5$  L=185 $\pm$ 3mm

3. Black tape (19mm)

**JIG**

1. Measuring tape

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

4

Wire insertion to Black SV tube (Vinyl)  
 $\phi 5$  L=185 $\pm$ 3mm



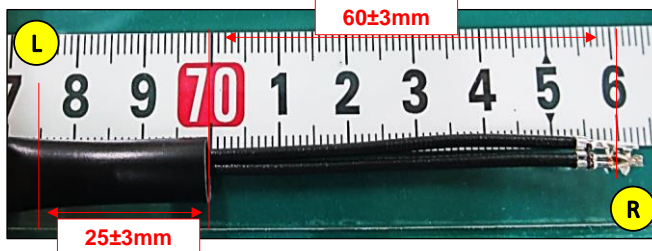
1. Get the **Black SV tube (Vinyl)  $\phi 5$  L=185 $\pm$ 3mm** using right hand then insert the **B-B wires**.

1. No wrong usage of parts
2. No deformed terminal

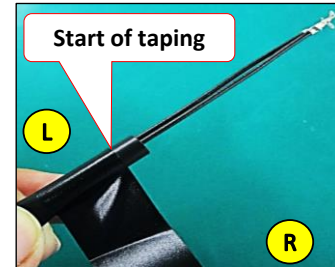
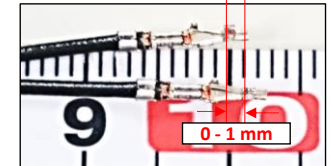
5

P1

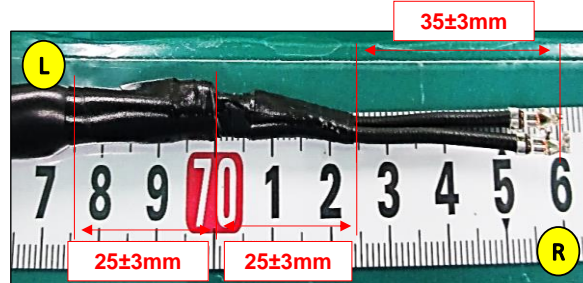
Taping 2  
Black SV tube (Vinyl) to  
Wire near terminal



1. Hold the **Black SV tube (Vinyl)** using left hand, measure from end of **Black SV tube (Vinyl)** up to terminal tip **60 $\pm$ 3mm**.

**Measuring tape****Wire alignment tolerance**

2. Hold the assy part using left hand, get the **Black tape (19mm)** using right hand then start taping process using both hands.



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

**Important reminders/Note/s:**

1. Please use **calibrated/verified measuring tape** when getting the measurement.

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☐ PROTOTYPE

☐ PRE-LAUNCH

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☒ MASSPRO

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#### PARTS:

1. Assy parts
2. Green tape (19mm)

#### JIG

1. Measuring Tape

#### NO.

#### PROCESS NAME

#### WORK PROCEDURE/ ILLUSTRATION

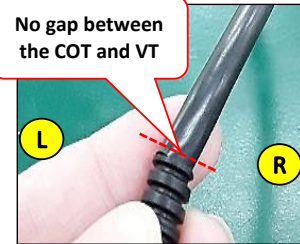
#### TOOLS/PPE

#### QUALITY POINTERS

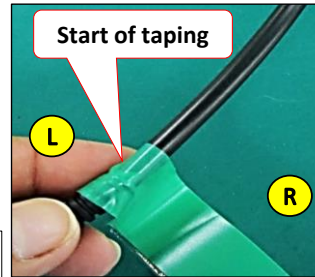
6

P1

Taping 3  
Black COT to  
Black SV tube (vinyl)



1. Fix the **Black Corrugated tube** and **Black SV tube (Vinyl)** using both hands.

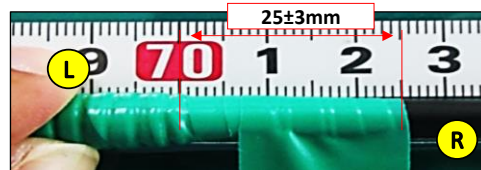


Start of taping

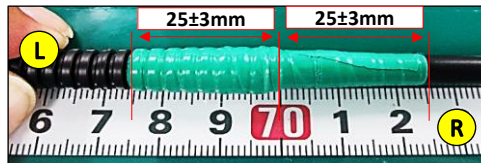
2. Hold the assy parts, get the **Green tape** using right hand then start taping process using both hands.



3. Confirm measurement of **25±3mm** from end of tape up to end of COT then continue the taping process using both hands.



4. Confirm measurement of **25±3mm** from end of COT up to end of tape using both hands.



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

#### MEASURING TAPE



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

#### Important reminders/Note/s:

1. Use **GREEN TAPE** only.
2. Please use **calibrated/verified measuring tape** when getting the measurement.

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☐ PRE-LAUNCH

MASSPRO

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**PARTS:**

## 1. Assy parts

**JIG**

## 1. Measuring Tape

NO.

PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

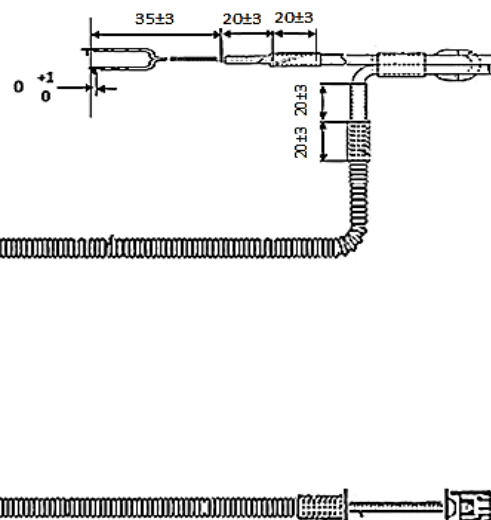
## TOOLS/PPE

## QUALITY POINTERS

7

P1

## Measurement



## MEASURING TAPE



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

**Important reminders/Note/s:**

1. Use GREEN TAPE only.
2. Please use calibrated/verified measuring tape when getting the measurement.

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PARTS:

n/a

JIG

n/a

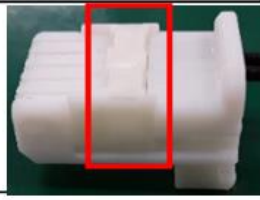
## VISUAL INSPECTION/QUALITY CHECKPOINTS

### TAPING

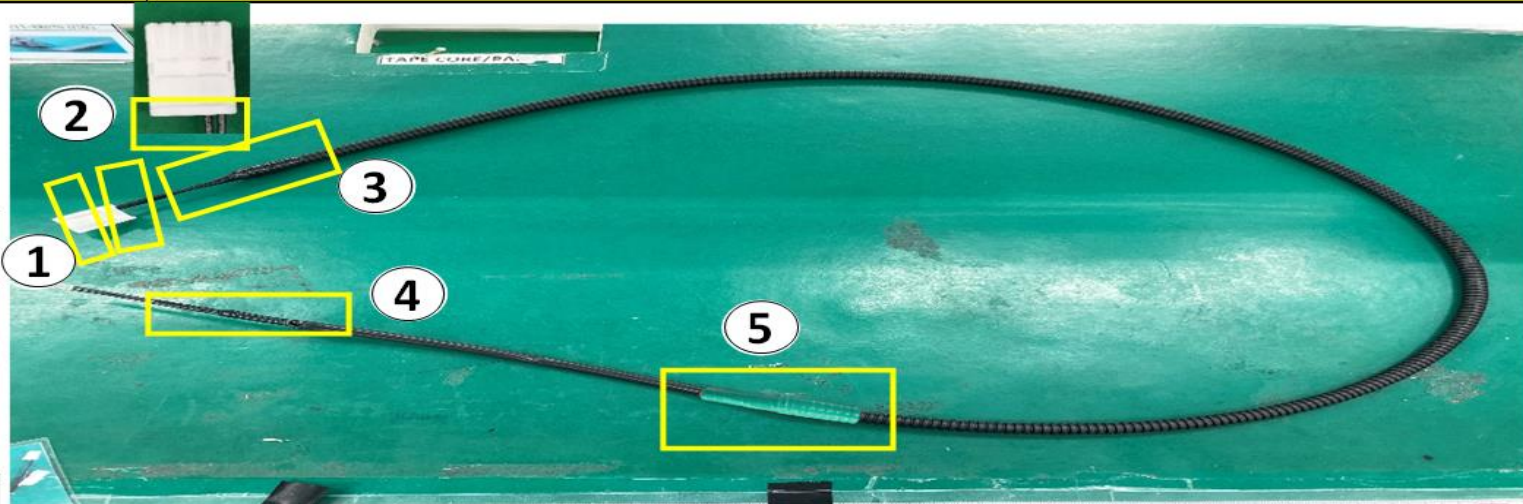
### 7N0121-7021



**GOOD**



**NO GOOD**



**GOOD**



**NO GOOD**

① No Unlock/ Half Lock Connector

⑤ No wrong use of tape (Green)

② No Wrong Insert

⑥ No Terminal Backing Out

③ ④ No Missing Tape

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