
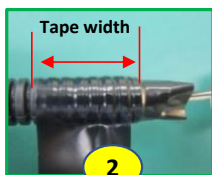
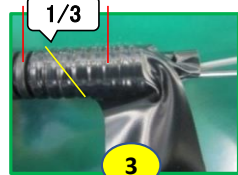


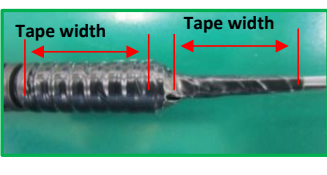
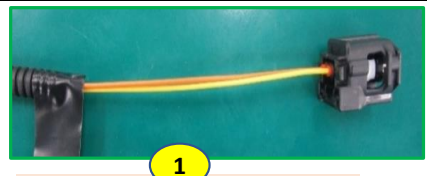
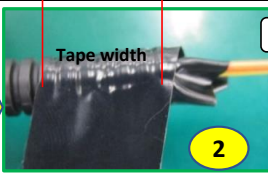






NBC	Process Name/ Title:		Document No:		WI-PRO-ASY-001A	
	SUB-ASSEMBLY TAPING PROCEDURE (COT to Wire)		Effective Date:		December 20, 2024	
	WORK INSTRUCTION		Rev. No.:		9	Page No.: 1 of 4
	Product Code/Name: COMMON		Customer Code: COMMON			

No.	Work Procedure/ Illustration					Records/Remarks/ Quality Pointers		
1	COT to wire near terminal (applicable to models with vinyl tube insertion)	 Pre-tape (middle) 2 winds	 1 wind before shifting	 1/3 shifting	 3 winds before end of tape	 Conduct 3x pressing at the end of Taping to prevent peel off and loose tape using left thumb. <i>refer to WI-PRO-COM-015</i>	 Appearance after Taping	
2	COT to wire (full taping)	 Pre-tape (middle) 2 winds	 2 winds before shifting	 1/3 shifting	 3 winds before end of tape	 Conduct 3x pressing at the end of Taping to prevent peel off and loose tape using left thumb. <i>refer to WI-PRO-COM-015</i>	 Appearance after Taping	<p>⚠</p> <ol style="list-style-type: none">1. No insufficient taping2. No loose tape3. No tape peeling4.No flip-out tape

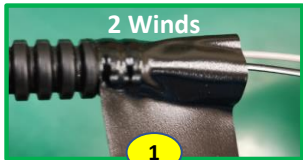
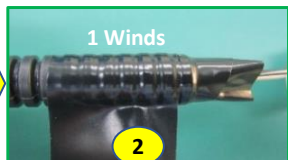
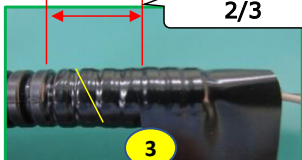
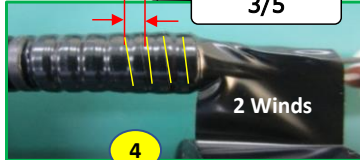

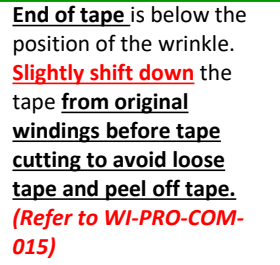
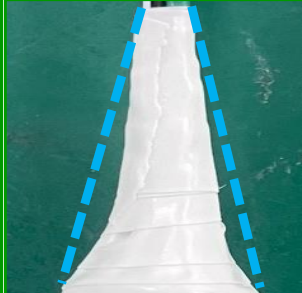

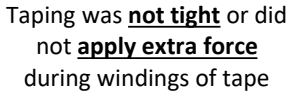

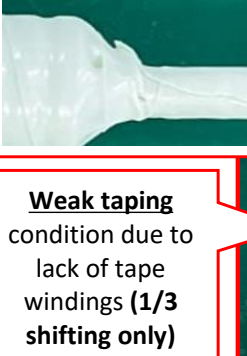


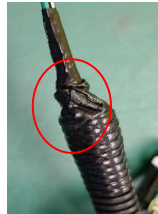
12/20/2024	9	Change Call out of No incomplete taping to No insufficient taping on Quality pointers	J. Jarito	A. Ayop	W.Carbillon	Prepare	Check	Approve
10/17/2024	8	Correction in page 3 picture 1,2 and 4	J.Reyes	C.Calayan	W.Carbillon			
10/03/2024	7	Taping of COT TO WIRE Back to normal procedure and additional page to Separate taping procedure of COT-WIRE Ø5 and Ø7	J.Reyes	C.Calayan	W.Carbillon			
07/10/2024	6	Specify criticality on taping of COT to wire, then update good and no good taping appearance. Separate VT to wire and COT to VT and special Taping process to WI-PRO-ASY-001B and WI-PRO-ASY-001C.	C.Recto	C.Calayan	W.Carbillon			
06/18/2024	5	Additional pointers of pressing of end tape (refer to WI-PRO-COM-015)	A.Porcalla	C.Calayan	W.Carbillon			
28/05/2024	4	Change Taping Method for COT to Wire, Change reference picture for end tape condition & change picture of pressing of tape from right to left thumb & Additional half wrap taping procedure	J.Reyes	C.Calayan	W.Carbillon			
Eff/Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	July 6, 2017	

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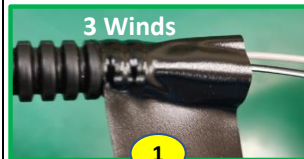
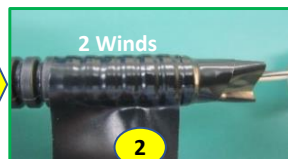
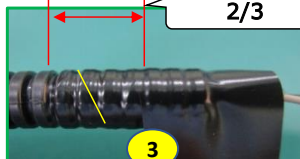
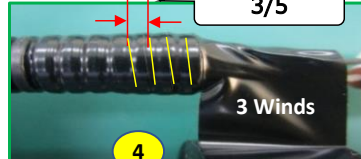


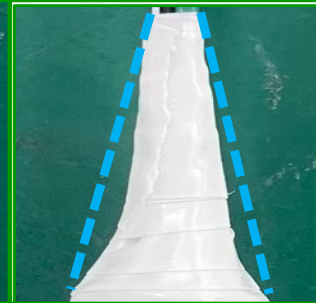




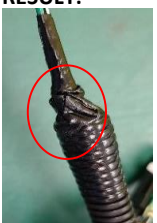


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No.	Work Procedure / Illustration	Records/Remarks/ Quality Pointers
3	<div><p>2 Winds 1</p><p>2 winds Pre-tape between COT and Wire</p></div> <div><p>1 Winds 2</p><p>Shift the tape 1x going to COT and conduct 1x tape windings</p></div> <div><p>2/3 3</p><p>Conduct shifting 1st shifting - 2/3 2nd Shifting - 3/5</p></div> <div><p>3/5 4</p><p>2 Winds conduct 1/2 shifting upward then conduct 2 tape windings before end of tape</p></div> <div><p>5</p><p>Conduct 3x pressing at the end of taping to prevent peel off and loose tape using left thumb. <i>Refer to WI-PRO-COM-015</i></p></div>	
	<p>COT to wire near connector/ terminal</p> <ul style="list-style-type: none">•WIRE - 2 WIRES•COT Ø - 5mm•TAPE WIDTH - 20mm & 25mm	
	<div><p>GOOD</p><p>End of tape is below the position of the wrinkle. <u>Slightly shift down</u> the tape <u>from original windings before tape cutting to avoid loose tape and peel off tape.</u> <i>(Refer to WI-PRO-COM-015)</i></p><p>Observe 5mm tolerance from rubber seal up to end of tape to avoid wrinkle (for COT to connector only)</p><p>Strong taping condition due to sufficient tape winding (2/3,3/5 shifting) it must be within the cot.</p><p>Taping was <u>not tight</u> or did not <u>apply extra force</u> during windings of tape</p></div> <div><p>NO GOOD</p><p>End tape is more slanted and attached on cot that can cause of PEELED OFF TAPE</p><p>Weak taping condition due to lack of tape windings (1/3 shifting only)</p><p>Taping was too tight or applied extra force during windings of tape</p><p>RESULT:</p></div>	

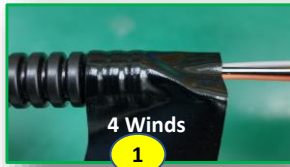

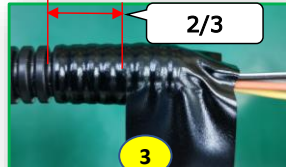
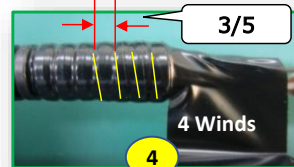
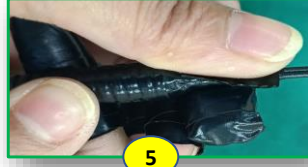


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No.	Work Procedure / Illustration		Records/Remarks/ Quality Pointers
4	<div>COT to wire near connector/ terminal</div> <div><ul style="list-style-type: none">•WIRE -2 WIRES•COT Ø - 7mm•TAPE WIDTH -20mm & 25mm</div>	<div><div><div><p>3 Winds 1</p><p>3 winds Pre-tape between COT and Wire</p></div><div><p>2 Winds 2</p><p>Shift the tape 1x going to COT and conduct 2x tape windings</p></div><div><p>2/3 3</p><p>Conduct shifting 1st shifting - 2/3 2nd Shifting - 3/5</p></div><div><p>3/5 4</p><p>conduct 1/2 shifting upward then conduct 3 tape windings before end of tape</p></div><div><p>3 Winds 5</p><p>Conduct 3x pressing at the end of taping to prevent peel off and loose tape using left thumb. <i>Refer to WI-PRO-COM-015</i></p></div></div><div><div>NOTE: CRITICAL PROCESS, ALWAYS FOLLOW SHIFTING REQUIREMENTS AND DO NOT APPLY EXTRA FORCE DURING SHIFTING OF TAPE</div></div></div>	
		<div><div><div>GOOD</div><div><div><p><u>End of tape</u> is below the position of the wrinkle. <u>Slightly shift down</u> the tape <u>from original windings before tape cutting to avoid loose tape and peel off tape.</u> (Refer to WI-PRO-COM-015)</p><p>Observe 5mm tolerance from rubber seal up to end of tape to avoid wrinkle (for COT to connector only)</p><p>Taping was <u>not tight</u> or did not <u>apply extra force</u> during windings of tape</p></div><div><p>Strong taping condition due to sufficient tape winding (2/3,3/5 shifting) it must be within the cot.</p></div></div><div><div>NO GOOD</div><div><div><p>End tape is more slanted and attached on cot that can cause of PEELED OFF TAPE</p><p>Weak taping condition due to lack of tape windings (1/3 shifting only)</p></div><div><p>Taping was too tight or applied extra force during windings of tape</p><p>RESULT:</p></div></div></div></div></div>	



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No.	Work Procedure / Illustration				Records/Remarks/ Quality Pointers		
5	<div><div><p>4 Winds 1</p></div><div><p>Tape width 2 Winds 2</p></div><div><p>2/3 3</p></div><div><p>3/5 4 Winds 4</p></div><div><p>5</p></div></div> <div><p>4 winds Pre-tape between COT and Wire</p><p>Shift the tape going to COT and conduct 2 tape windings</p><p>Conduct shifting 1st shifting - 2/3</p><p>2nd Shifting - 3/5 then conduct 4 tape windings before end of Tape</p><p>Conduct 3x pressing at the end of Taping to prevent peel off and loose tape using left thumb. <i>refer to WI-PRO-COM-015</i></p></div> <div><p>NOTE: CRITICAL PROCESS, ALWAYS FOLLOW SHIFTING REQUIREMENTS AND DO NOT APPLY EXTRA FORCE DURING SHIFTING OF TAPE</p></div>				COT to wire near connector/ terminal		
	<div><div><p>GOOD</p><p>End of tape is below the position of the wrinkle. <u>Slightly shift down</u> the tape <u>from original windings before tape cutting to avoid loose tape and peel off tape.</u> (Refer to WI-PRO-COM-015)</p><p>Observe 5mm tolerance from rubber seal up to end of tape to avoid wrinkle (for COT to connector only)</p><p>Strong taping condition due to sufficient tape winding (2/3,3/5 shifting) it must be within the cot.</p><p>Taping was not tight or did not apply extra force during windings of tape</p></div><div><p>NO GOOD</p><p>End tape is more slanted and attached on cot that can cause of PEELED OFF TAPE</p><p>Taping was too tight or applied extra force during windings of tape RESULT:</p><p>Weak taping condition due to lack of tape windings (1/3 shifting only)</p></div></div>						