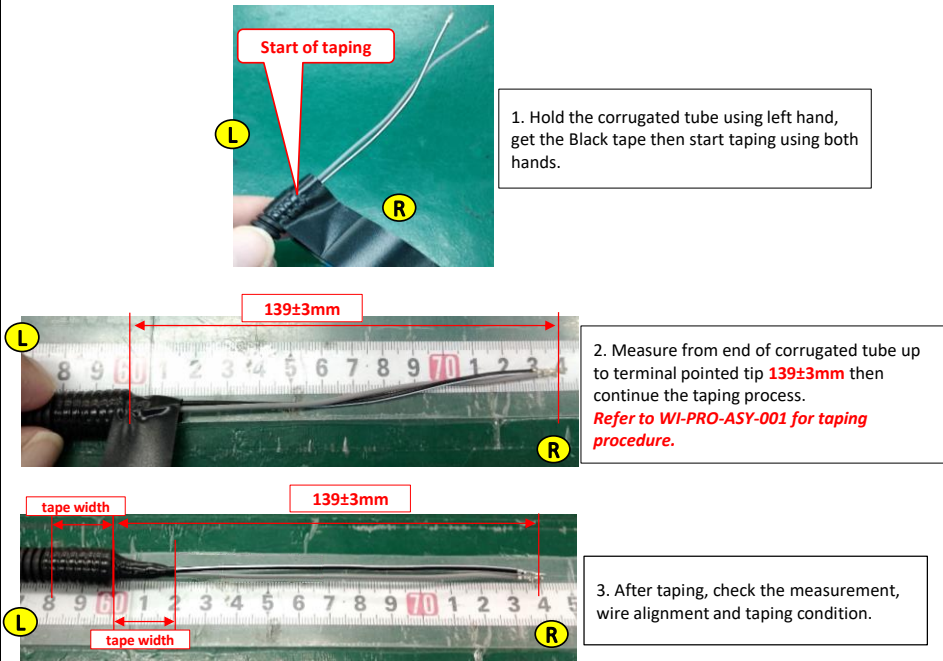
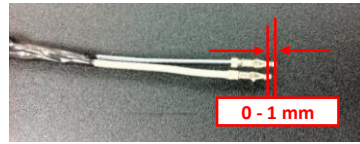




# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	July 07, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-209A		
Revision No.:	3	Page No.:	1 of 2

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Product Name/Code:	587B / 7M0532-7020	Customer:	TRJ
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1	<p>Taping 1 Black corrugated tube to wire near terminal</p>  <p>1. Hold the corrugated tube using left hand, get the Black tape then start taping using both hands.</p> <p>2. Measure from end of corrugated tube up to terminal pointed tip <b>139±3mm</b> then continue the taping process. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p> <p>3. After taping, check the measurement, wire alignment and taping condition.</p>		<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <p><b>MEASURING TAPE</b></p>	<p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension</p> <p><b>Wire alignment tolerance</b>  0 - 1 mm</p>

## Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
07/07/21	3	Removal of validity date.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
01/06/21	2	Transfer process owner from Production (WI-PRO-ASY-058) to Engineering (WI-ENG-PDE-209A). Apply some improvements/pictures.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes
11/03/17	0	Initial issue	J. Montealto/ L. Briones	O. Merin	T. Sugiyama	n/a
Est. Date:			M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
			Revised	Checked	Approved	Noted

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## WORK INSTRUCTION

### TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **587B / 7M0532-7020**Customer: **TRJ**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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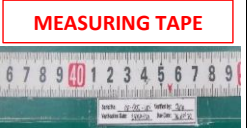
WI-ENG-PDE-209A

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PARTS:		1. Assy parts 2. Black sunprene tube Ø11 L=120±3mm 3. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black sunprene tube Ø11 L=120±3mm	 <p>1. Get the sunprene tube <b>Ø11 L=120±3mm</b> using right hand and then insert the <b>B/W-GR wires</b> using left hand.</p>	n/a	1. No wrong use of parts 2. No deformed terminal
3	P1 Taping 2 Black corrugated tube to Black sunprene tube	 <p>1. Measure from end of sunprene tube up to terminal pointed tip <b>39±3mm</b>.</p> <p>2. Hold the sunprene tube using left hand, get the <b>Black tape</b> then start taping process using both hands. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p> <p>3. After taping, check the measurement and taping condition.</p>	 <p>MEASURING TAPE</p>	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension</p>

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