





Revision History								Prepared by	Reviewed by	Approved by	Noted by
02/10/22	0	Initial issue. Wire color from Gray (GR) to Green (G) (MRSW CP TVSSf 0.3 from GR-B/W to MRSW CP TVSSf 0.3 G-B/W); Refer to CL-ENG-PDE-254A; WI-ENG-PDE-397A	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Prepared	Reviewed	Approved	Noted	Est. Date:	December 07, 2020			

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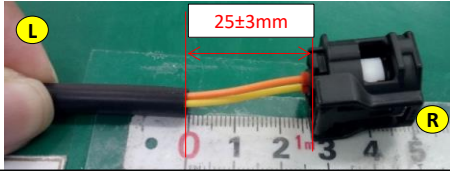
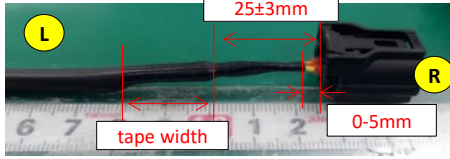
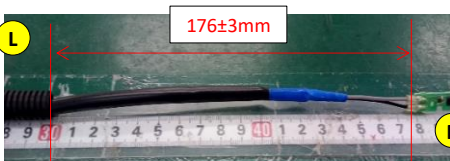


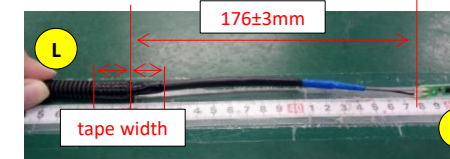




# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:	February 10, 2022		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-397B		
Revision No.:	0	Page No.:	2 of 3

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model Code/Part Number:	780B / 7R0103-7022	Customer:	TRMX
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Black tape 2. Assy parts		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 Vinyl tube to wire near connector	 <p>1. Hold the Vinyl tube using left hand. Measure the end of Vinyl up to the connector <b>25±3mm</b> using right hand.</p>  <p>2. Hold the Vinyl tube using left hand. Get the <b>Black tape</b> using right hand and start taping 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>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</p> <p><b>Note:</b> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p>
3	P2 Taping 2 COT to Sunprene tube near to PCB	 <p>1. Hold the COT using left hand. Measure the end of COT up to the edge of hotmelted wire <b>176±3mm</b> using right hand.</p>  <p>2. Hold the COT using left hand. Get the <b>Black tape</b> using right hand and start taping 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>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</p> <p><b>Note:</b> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p>

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## TAPING ASSEMBLY PROCESS

Effectivity Date:

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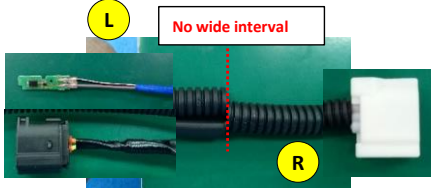
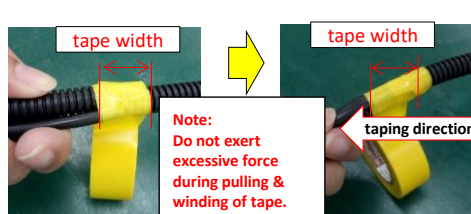
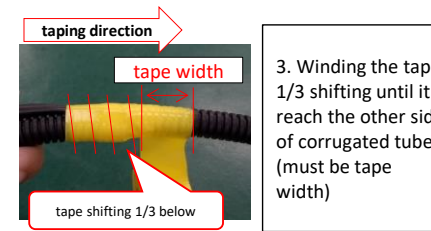
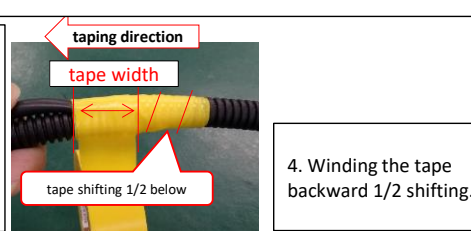
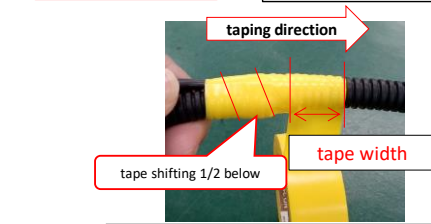
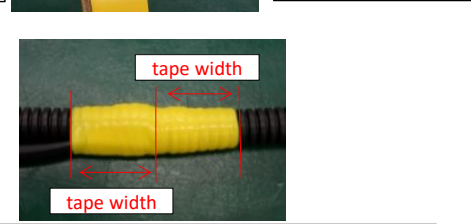


Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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0

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PARTS:		1. Black tape 2. Assy parts		JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Y-taping	<div><div></div><div><p>1. Fix the corrugated and Vinyl tube using both hands. <i>See illustration for correct facing of connector.</i></p></div><div></div><div><p>2. Start taping at the middle of combined Corrugated tubes and vinyl tube, make 1 winding pre-tape before shifting then winding the tape going to corrugated tube and vinyl tube (2 windings). (must be tape width)</p></div><div></div><div><p>3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)</p></div><div></div><div><p>4. Winding the tape backward 1/2 shifting.</p></div><div></div><div></div><div><p>5. Winding the tape 1/2 shifting going to other side of corrugated tube then 3 windings before cut the tape. After taping, check the condition of tape.</p></div></div> <div><div>MEASURING TAPE</div></div> <div><p><b>NOTE:</b> <b>USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</b></p><ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong use of tape</li><li>6. No wrong dimension</li><li>7. No wide interval between the COT</li></ol><p><b>Connector Orientation</b></p></div>		

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