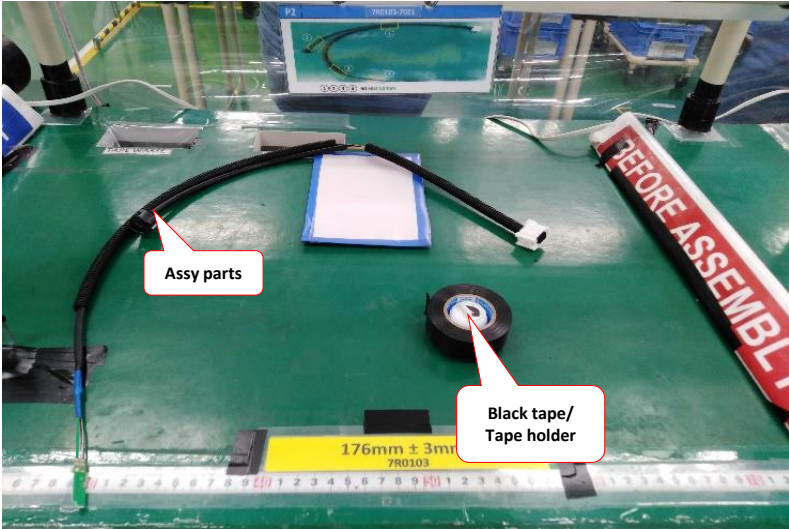



	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:	April 24, 2023		
	Process Name/Title:				Validity Date:	n/a		
	Model Code/Part Number: 780B / 7R0103-7023A		Customer: TRMX		Document No.:	WI-ENG-PDE-542B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	1 of 4

PARTS:	1. Assy parts: Black tape [1pc.]			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 5px; display: inline-block;">Table Lay-out</div>  </div>	<div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Housekeeping</p> <ol style="list-style-type: none"> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Alert level</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"> 1. No missing parts/tools 2. No excess parts/tools

Revision History								Prepared by	Reviewed by	Approved by	Noted by
04/24/2023	3	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a	 J. Loterte	 C. Villanueva	 A. Arañes	n/a	
10/07/2022	2	Improve quality pointers in process no.2,3, and 4 due to document improvement.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
07/27/2022	1	Change document status from pre-launch to masspro.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
07/26/2022	0	Initial issue QR code label 7V4020-0020 direction	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change		Reviewed	Reviewed	Approved	Noted	Est. Date:	July 26, 2022		

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**WORK INSTRUCTION**

Effectivity Date:

April 24, 2023

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TAPING ASSEMBLY PROCESS

Validity Date:

n/aModel Code/Part Number: **780B / 7R0103-7023A**

Customer:

TRMX

Document No.:

WI-ENG-PDE-542B

Purpose:

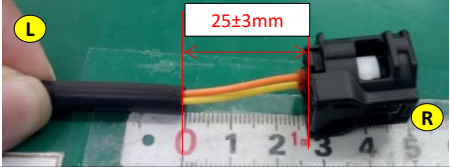
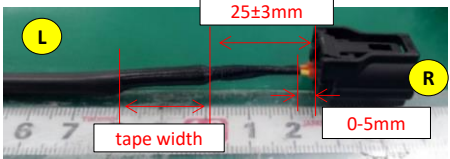


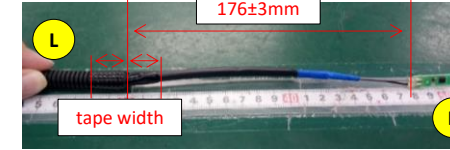

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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	 1. Hold the Vinyl tube using left hand. Measure the end of Vinyl up to the connector 25±3mm using right hand.  2. Hold the Vinyl tube using left hand. Get the Black tape using right hand and start taping using both hands. 3. After taping, check the measurement and taping condition.		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.
3	P2 Taping 2 COT to Sunprene tube near to PCB	 1. Hold the COT using left hand. Measure the end of COT up to the edge of hotmelted wire 176±3mm using right hand.  2. Hold the COT using left hand. Get the Black tape using right hand and start taping using both hands. 3. After taping, check the measurement and taping condition.		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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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

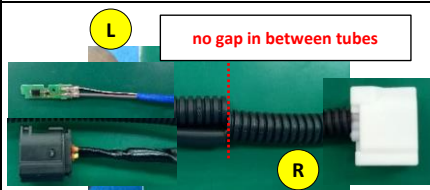
TOOLS/PPE

QUALITY POINTERS

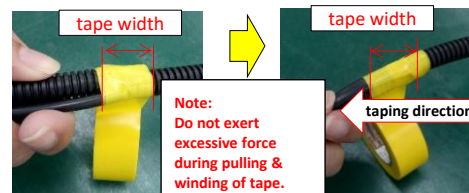
4

P2

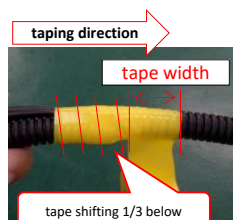
Y-taping



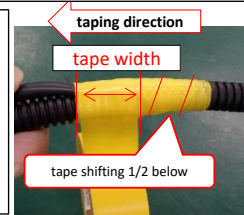
1. Fix the corrugated and Vinyl tube using both hands.
See illustration for correct facing of connector.



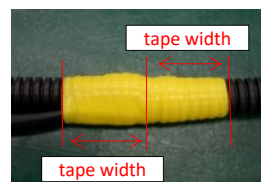
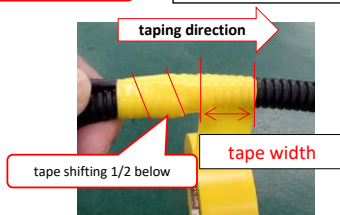
2. Start taping at the middle of combined Corrugated tubes and vinyl tube, make 1 winding pre-tape before shifting then winding the tape going to corrugated tube and vinyl tube (2 windings). (must be tape width)



3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)



4. Winding the tape backward 1/2 shifting.



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.

MEASURING TAPE



Important reminders/Note/s:

1. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK 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
7. No wide interval between the COT



Connector Orientation

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WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number: **780B / 7R0103-7023A**

Customer: **TRMX**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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PARTS:

1. Assy parts

JIG

n/a

3 QUALITY CHECKPOINTS

P2

7R0103-7023A



1 2 3 4 NO MISSING TAPE

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