

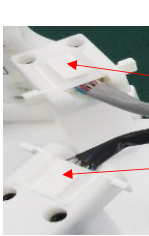
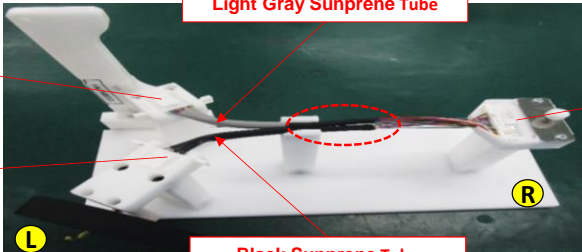

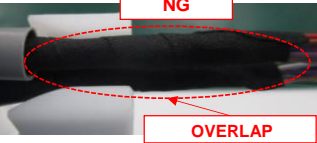
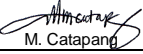


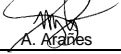
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date: May 04, 2022						
	Process Name/Title:				Validity Date:						
	Model Code/Part Number: 014B / 17J796-7051Y		Customer: NBS		Document No.: WI-ENG-PDE-492F						
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.: 1						
PARTS: 1. Assy parts 2. Black TESA Tape No 51036		JIG: 1. Taping jig									
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS				
1	P6 Taping 3 Wire taping (Tesa)	<div>   <p>1. Set the connector 1827842-1 (W) then push the guide lock using right index finger.</p> </div> <div>   <p>2. Continue to set the harness on Jig 2. (See picture for the correct setting).</p> </div> <div>   </div>				<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1. No wrong setting of harness 2. No wrong orientation of connector				
Revision History											
05/04/22	1	Change document purpose from pre-launch to masspro				M. Catapang	J. Loterte	C. Villanueva	A. Arañes		
04/29/22	0	Initial issue				M. Catapang	J. Loterte	C. Villanueva	A. Arañes		
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted		
Prepared by:  M. Catapang						Reviewed by:  J. Loterte		Approved by:  C. Villanueva		Noted by:  A. Arañes	
Est. Date: April 29, 2022											
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WORK INSTRUCTION

Effectivity Date:

May 04, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number: **014B / 17J796-7051Y**

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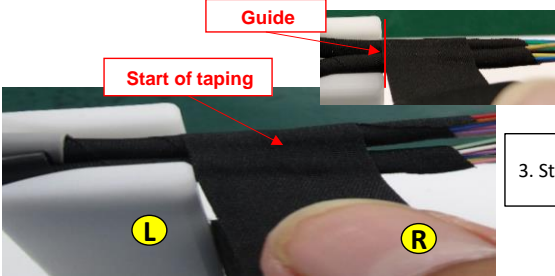
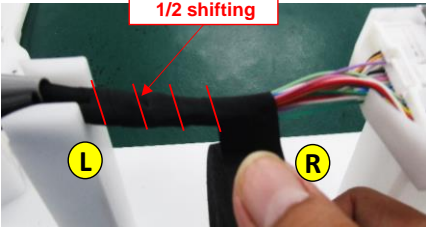
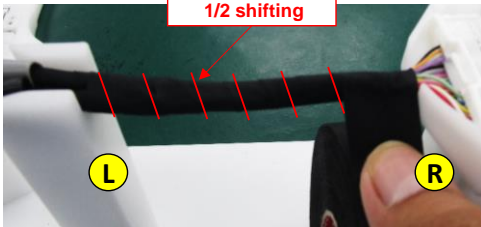
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PARTS:

1. Assy parts

JIG

1. Taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P6 Taping 3 Wire taping (Tesa) (Continuation)	   <p>3. Start taping using guide 1 1/2 winding.</p> <p>4. Make 1/2 shifting or 6-7 windings going to the right side until it reach the guide near connector.</p> <p>5. Make 2 windings of tape before cut.</p>	n/a	1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend wire 6. No NG of end tape

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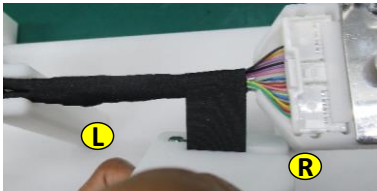
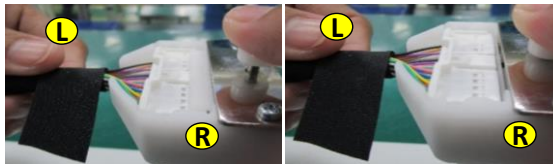
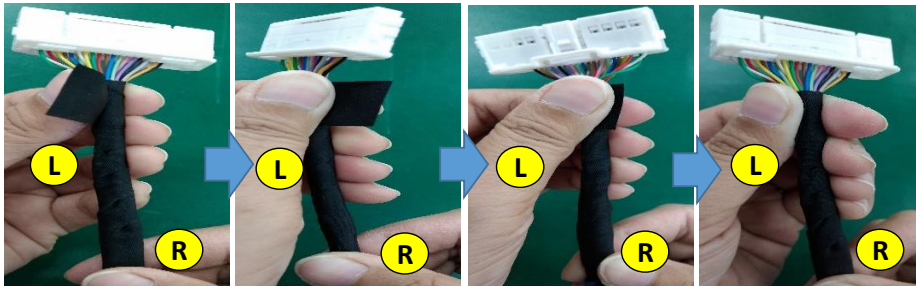

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PARTS:

1. Assy parts

JIG

1. Taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P6 Taping 3 Wire taping (Tesa) (Continuation)	 6. Cut the tape using provided cutter only using both hands.  BEFORE PRESSING AFTER PRESSING 7. Hold the assy parts then press the lock button using right thumb. Remove the harness from jig.  8. Press the end tape using left hand. Do not touch the adhesive	 Use only this cutter	1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend wire 6. No NG of end tape

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P6

Taping 3
Wire taping (Tesa)
(Continuation)



9. After taping, check the alignment and condition of tape.

10. Proceed to **Continuity checking**, refer to **WI-ENG-PDE-010** if encountered problem, refer to **Treatment on Levercon continuity checker NG WI-ENG-PDE-001**.

11. Refer to **WI-ENG-PDE-096 End Tape Pressing**.

12. Refer to **IS-ENG-PDE-004 17J796-7051Y Inspection Guide**.

n/a

1. No loose tape
2. No excessive tape winding
3. No damage on parts
4. No peel off tape
5. No bend Wire

Note:
Refer to Work instruction of
Continuity checking, End Tape
Pressing and Inspection Guide for
their separate cycle time.

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