

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

February 28, 2023

Model Code/Part Number:

TM3 / 7L0117-7020A

Customer:

TRQSS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-316C

Revision No.:

3

Page No.:

1 of 9

**PARTS:**

1. Assy parts
2. Black tape

**JIG:**

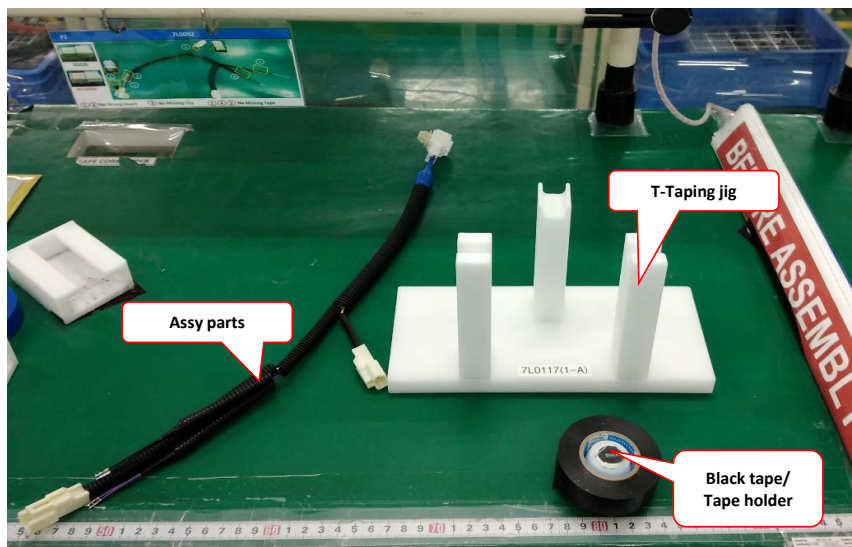
1. T-Taping jig

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P3

Table Lay-out

**Table Lay-out****Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

**Housekeeping**

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

**Alert level**

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools

**Revision History**

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
02/28/23	3	Inclusion of Quality checkpoints.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
09/01/22	2	Improve quality pointers and notes in: Process no.2 and 4 as document improvement.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
10/15/21	1	Provide tools and jigs; Apply some improvements in parts; Additional notes in T-taping process. Improve work procedure and illustration; Change from pre-launch to masspro.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				

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### PARTS:

1. Assy parts
2. Black tape

### JIG

1. T-Taping jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

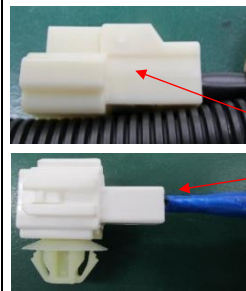
### TOOLS/PPE

### QUALITY POINTERS

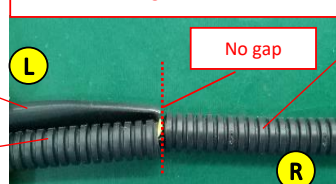
2

P3

Y-taping



No gap between Black SV tube (Vinyl) and Corrugated tubes



No gap

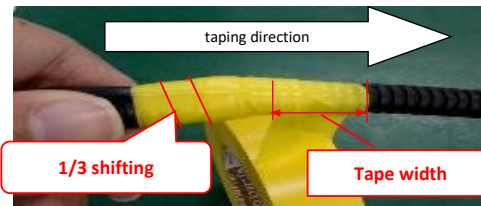
1. Fix the Black SV tube (Vinyl) and corrugated tube .



1/3 shifting

2. Start taping at the middle of combined Corrugated tubes and vinyl tube, make **1 wind** pre-tape before shifting then wind the tape going to corrugated tube and vinyl tube, width must be same with tape (19mm)

taping direction

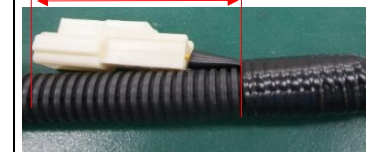


1/3 shifting

Tape width

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

$53 \pm 3\text{mm}$



**CORRECT MEASUREMENT**

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. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

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## PARTS:

1. Assy parts
2. Black tape

## JIG

1. T-Taping jig

## NO.

## PROCESS NAME

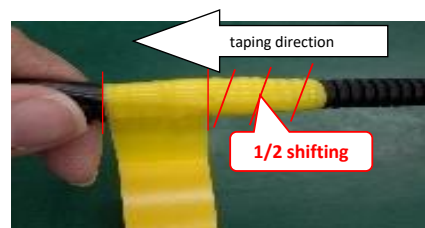
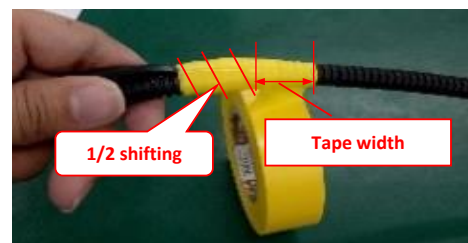
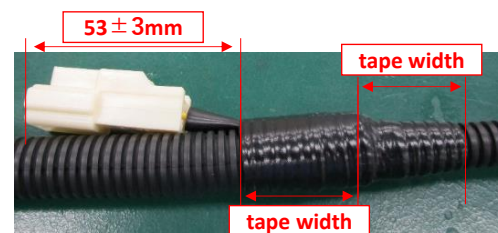
## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

## QUALITY POINTERS

2

P3

Y-taping  
(Continuation)4. Wind the tape backward **1/2 shifting**.5. Wind the tape **1/2 shifting** going to other side of corrugated tube then make **3 windings** of tape before cut.**ACTUAL ASSY PARTS**

## MEASURING 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

**Important reminders/Note/s:**

1. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

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☒ MASSPRO

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### PARTS:

1. Assy parts
2. Black tape

### JIG

1. T-Taping jig

### NO.

### PROCESS NAME

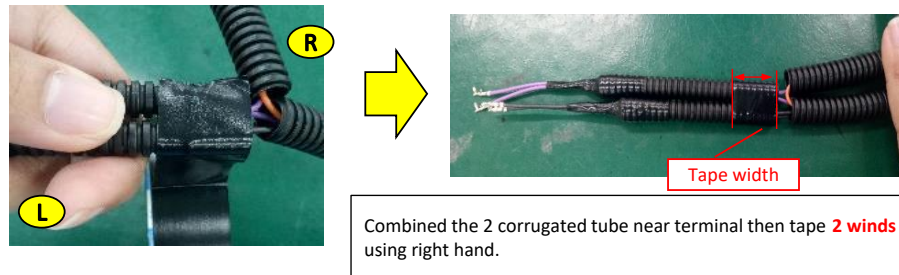
### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### QUALITY POINTERS

3

Pre-tape



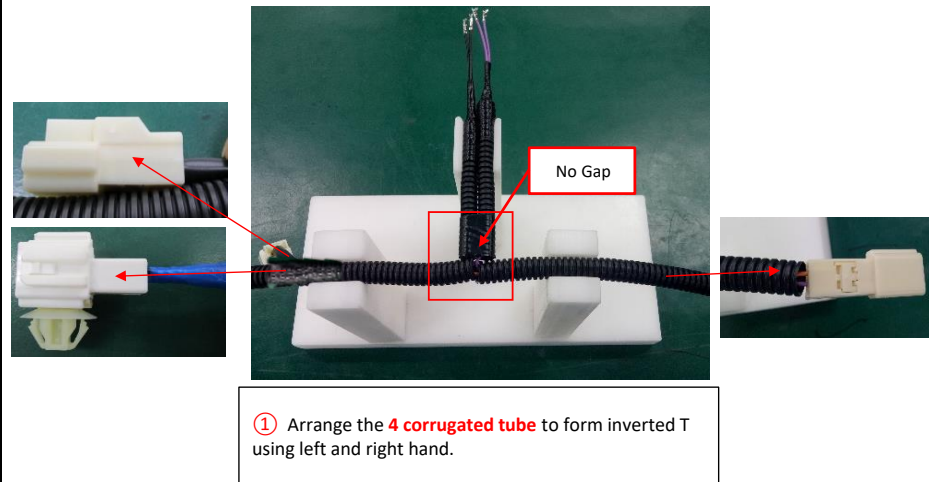
n/a

1. No flip out tape
2. No tape peeling
3. No loose tape
4. No wrong use of tape
5. No exposed wire

4

P3

T-taping



n/a

1. No flip out tape
2. No tape peeling
3. No loose tape
4. No wrong use of tape
5. No wide interval between COT
6. No exposed wire

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### PARTS:

1. Assy parts
2. Black tape

### JIG

1. T-Taping jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### QUALITY POINTERS

4

P3

T-taping  
(Continuation)



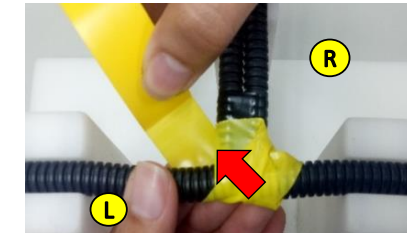
- ② Start taping at the middle to fix the 4 corrugated tubes using right hand.



- ③ Wind the tape from front to back at the right side



- ④ Wind the tape from back to front (cross pattern)



- ⑤ Wind the tape from front to back at the left side

n/a

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. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

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## PARTS:

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2. Black tape

## JIG

1. T-Taping jig

## NO.

## PROCESS NAME

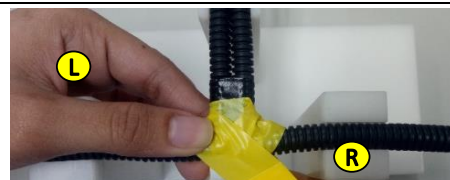
## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

## QUALITY POINTERS

4

P3

T-taping  
(Continuation)

⑥ Wind the tape from back to front (cross pattern)

⑦ Repeat the process from ③~⑥ 3 times then after windings remove the harness from jig then continue to process ⑧.



⑧ Tape the right side corrugated tube (3 windings), width must be same as tape (19mm)



⑨ From the right side, wind the tape 2/3 shifting going to center.  
Note: Flip the harness for the continuation of taping process.



⑩ Wind the tape from front to back side (cross pattern)

n/a

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. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

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## PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

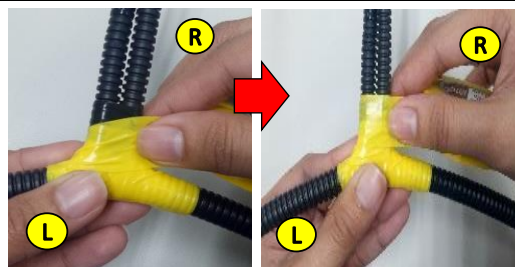
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

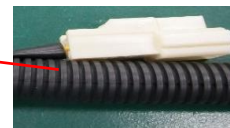
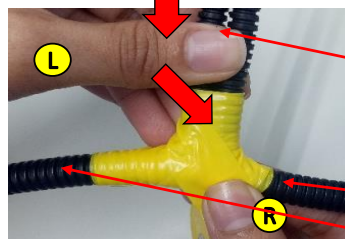
P3

T-taping  
(Continuation)

⑪ Tape the top side of corrugated tube  
(3 windings), width must be same as tape  
(19mm)



⑫ From the top side, wind the tape 2/3 shifting  
going to center



n/a

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. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

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### PARTS:

1. Assy parts
2. Black tape

### JIG

n/a

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### QUALITY POINTERS

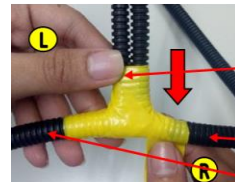
4

P3

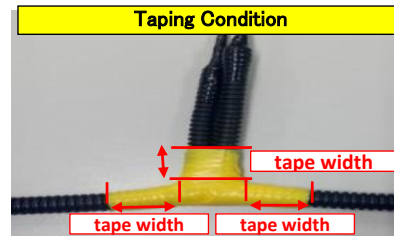
T-taping  
(Continuation)



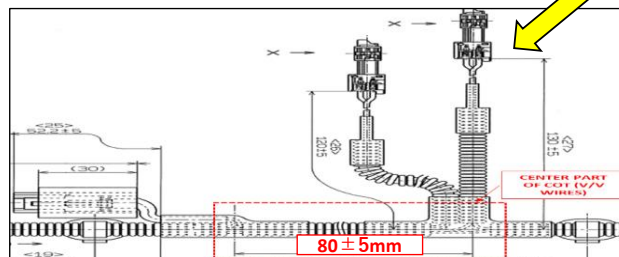
⑬ Wind the tape from front to back side (cross pattern)



⑭ Tape the right side corrugated tube (3 windings), width must be same as tape (19mm).



⑮ After taping, check the measurement and condition of tape.



ACTUAL ASSY PARTS

### MEASURING 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

### Important reminders/Note/s:

1. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

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PARTS:

n/a

JIG

n/a

**3**

### QUALITY CHECKPOINTS

**P3**

**7L0117-7020A**

**52±3 -END OF TAPE  
TO END OF  
CONNECTOR**

**1**

**1**

**1**

**No MISSING TAPE**

**CORRECT FACING OF T-TAPING**

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