



# WORK INSTRUCTION

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

Effectivity Date:

July 19, 2021

Product Name/Code: **310B / 7M0522-7020C**

Customer: **TRJ**

Validity Date:

n/a

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

WI-ENG-PDE-166B

Revision No.:

3

Page No.:

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PARTS:

1. Assy parts
2. Black tape [1pc]

JIG:

N/A

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Y-taping	<div>Measuring tape</div> <div>Safety Instruction</div> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots,</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<div>Note:</div> <p>Used yellow tape for easy visualization of tape shifting. But actual should be <b>BLACK</b>.</p> <div>Note:</div> <p>Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none"><li>1. No loose tape</li><li>2. No peel-off tape</li><li>3. No flip-out tape</li><li>4. No wrong dimension</li><li>5. No wrong use of tape</li><li>6. No missing tape</li></ol>

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Reviewed by	Approved by
07/19/21	3	Remove validity date and add tape quantity.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes				
01/20/21	2	Change part number due to design change. Remove cycle time.	D. Castillo	R. Peñaloza	A. Shimamura	A. Arañes				
09/08/20	1	Change Process owner from Production to Engineering. Improved process and add cycle time. Updated pictures. Change part number.	D. Castillo	R. Peñaloza	A. Shimamura	A. Arañes				
07/12/18	n/a	Previously established Engineering Instruction (EI-ENG-PDE-051). Initial issue.	D. Castillo	R. Alcantara	A. Arañes	n/a				

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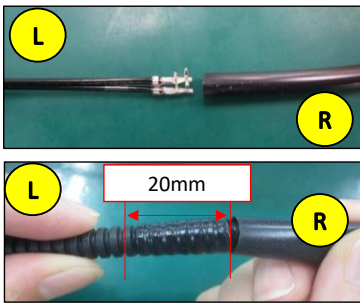
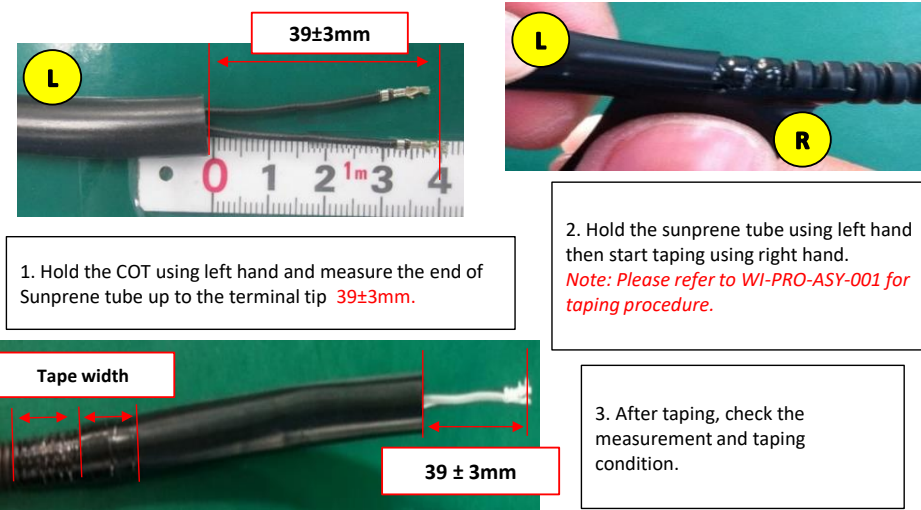

PARTS:

3

1. Black Sunprene tube  $\varnothing 9$  L=120 $\pm$ 3mm
2. Black tape [1pc]

JIG

N/A

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black Sunprene tube $\varnothing 9$ L=120 $\pm$ 3mm	 <p>1. Hold the Black wires using left hand and insert the Sunprene tube <math>\varnothing 9</math> L=120<math>\pm</math>3mm using right hand.</p> <p>2. Insert the Sunprene tube to COT 20mm (Tape width)</p>	N/A	1. No wrong use of parts
3	Taping 3 Corrugated tube to Sunprene tube	 <p>1. Hold the COT using left hand and measure the end of Sunprene tube up to the terminal tip 39<math>\pm</math>3mm.</p> <p>2. Hold the sunprene tube using left hand then start taping using right hand. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p> <p>3. After taping, check the measurement and taping condition.</p>	<p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Measuring tape</p> 	1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape

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