

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**Product Name/Code: **900B / 7N0114-7020A** Customer: **TRJ**Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

July 17, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-274B

Revision No.:

1

Page No.:

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PARTS: 1. Assy parts; Black COT (with slit) Ø5 L=444±4mm; Black tape [1pc.]

JIG:

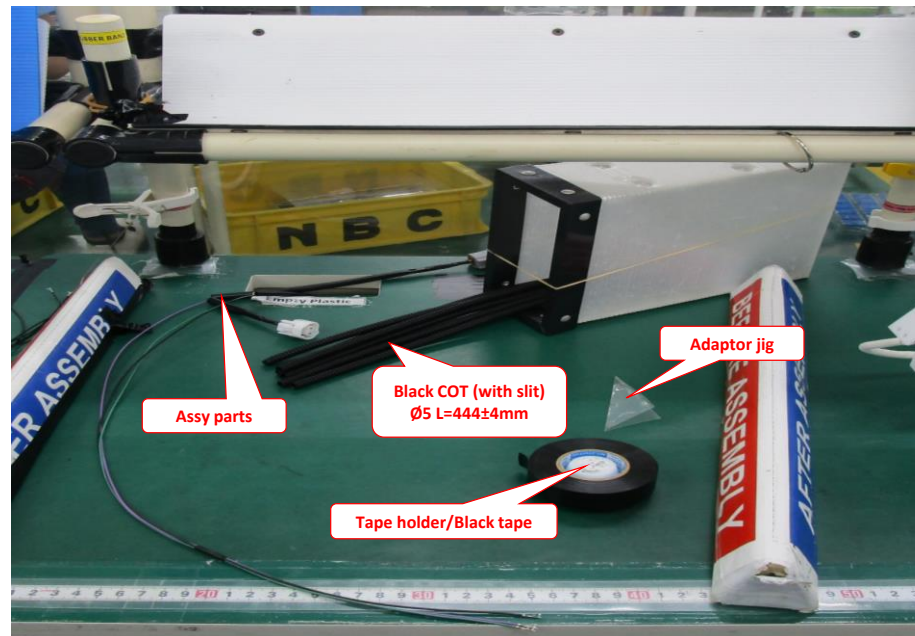
1. Adaptor jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
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1

P2

Table Lay-out

TABLE LAY-OUT**Safety Instruction**

Be sure to wear required 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
3. No wrong position of parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/17/21	1	Removal of validity date. Change document status from pre-launch to masspro.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
07/12/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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2 of 7**PARTS:**

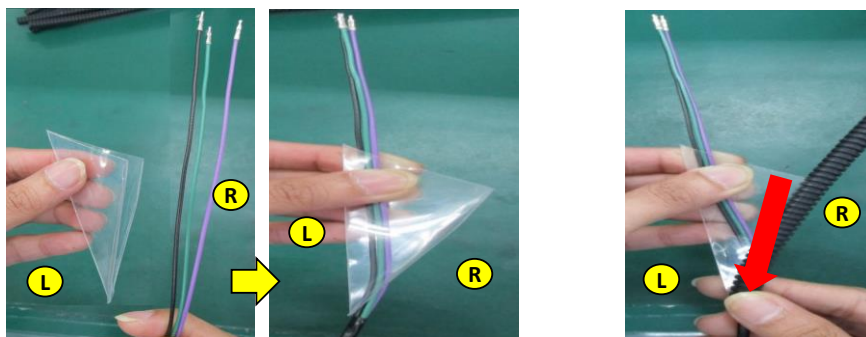
1. Assy parts
2. Black tape

JIG

1. Adaptor jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****2**

Wire insertion to
Black corrugated tube
(with slit)
Ø5 L=444±4mm



1. Get the adaptor jig using left hand then insert the wires using right hand.

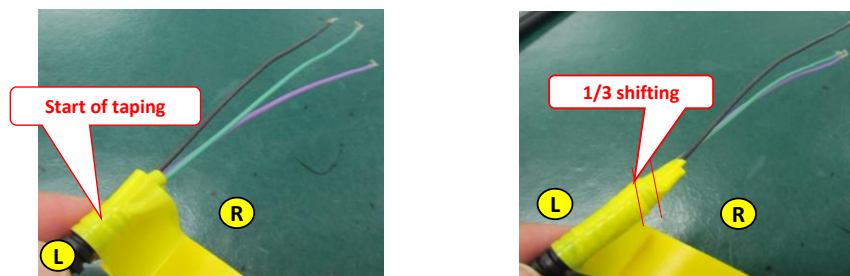
2. Get the corrugated tube **Ø5 L=444±4mm (no slit)** using right hand then start insertion to wires using right hand.

COT Adaptor

1. No wrong usage of parts
2. No wires left in between the COT with slit

P2**3**

Taping 1
Black vinyl tube to wire
near terminal



1. Hold the COT using left hand, get the **Black tape** using right then start pre-taping at the middle of COT and wires using both hands.

2. Make **1/3 shifting** going to the side of COT until it reach **25mm**.

n/a

NOTE:
USED **YELLOW TAPE** FOR EASY
VISUALIZATION OF SHIFTING LINE,
BUT ACTUAL SHOULD BE **BLACK**.

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

Note: 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

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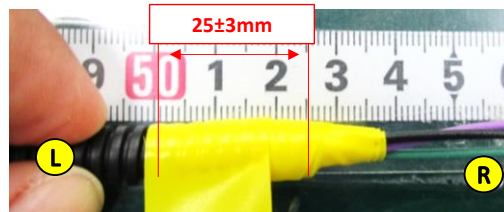
TOOLS/PPE

QUALITY POINTERS

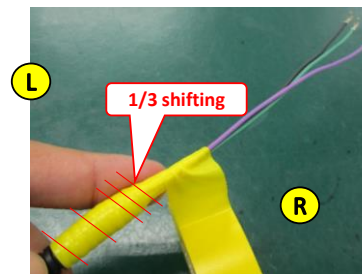
3

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Taping 1
Black vinyl tube to wire
near terminal
(Continuation)



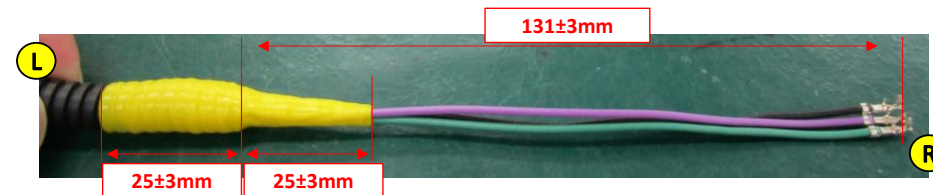
3. Confirm **25±3mm** measurement from end of tape up to end of COT then make **2 windings** of tape using both hands before shifting to other side.



4. Make **1/3 shifting** going to wires using both hands.



5. Measure from end of COT up to terminal pointed tip **131±3mm** then continue the taping process using both hands.



6. After taping, check the measurement and taping condition.

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

Note:

Please use calibrated/verified measuring tape when getting the measurement.

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2. Black tape

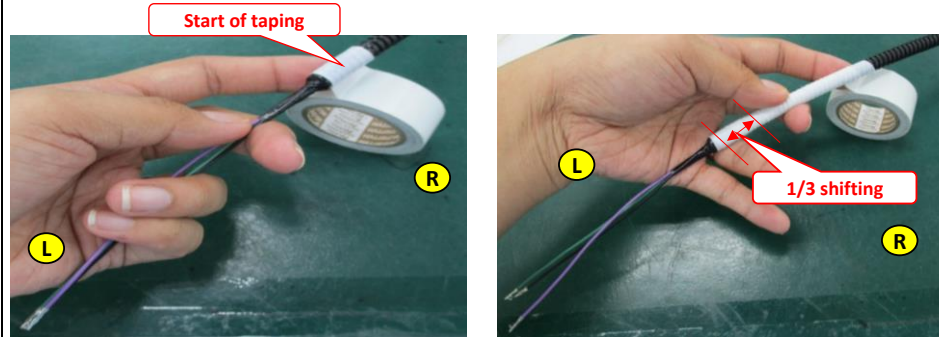
JIG

n/a

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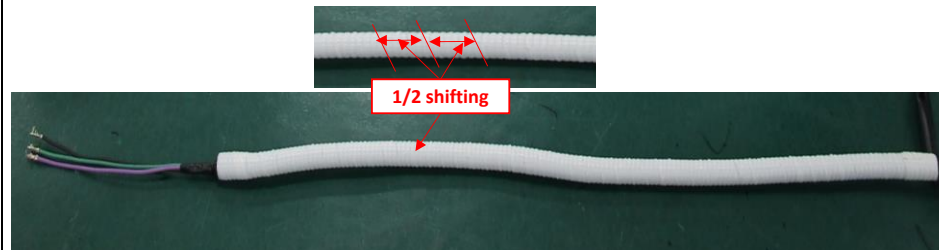
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P2

Taping 2
Half-wrapped taping

1. Hold the corrugated tube using left hand and begin taping using right hand.

2. Make **1/2 shifting**. Repeat the process until the end of corrugated tube. Make **3 windings** and then cut the tape.



3. Check the taping condition.

n/a

NOTE: USE WHITE 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

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

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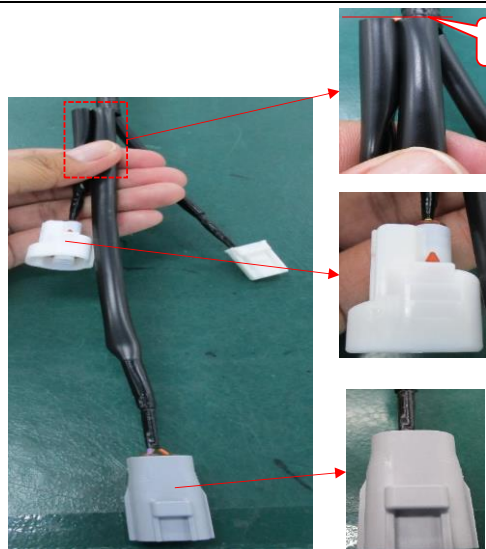
TOOLS/PPE

QUALITY POINTERS

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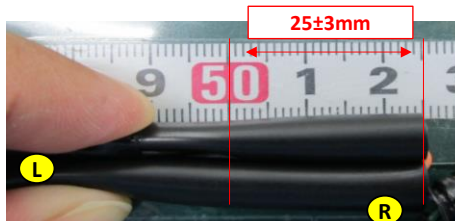
P2

Y-Taping



must be aligned

1. Conduct harness facing using both hands. Combine the vinyl tube $\phi 7 L=57\pm 3mm$ and $\phi 7 L=189\pm 3mm$ using both hands.



25±3mm

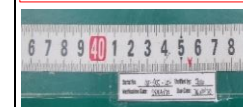
2. Measure from vinyl tube up to its end $25\pm 3mm$ using both hands.



Start of taping

3. Get the **Black tape** using right hand then start pre-taping process using both hands.
Note: Do not exert extra force.

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
7. No wrong orientation of assy parts

Note:

Please use calibrated/verified measuring tape when getting the measurement.

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2. Black tape

JIG

n/a

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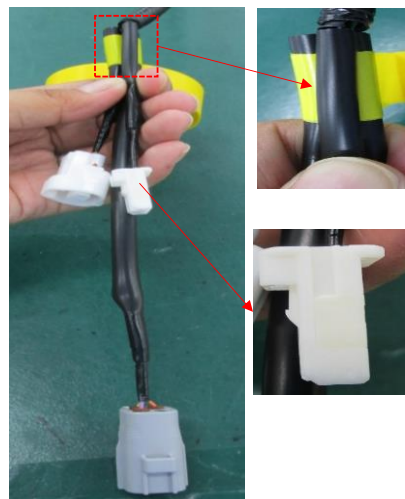
WORK PROCEDURE/ ILLUSTRATION

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QUALITY POINTERS

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P2

Y-Taping
(Continuation)

4. After pre-taping, combine the vinyl tube $\varnothing 5$
 $L=69\pm 3\text{mm}$ to assy parts using both hands.



5. Make **2 windings** of tape before shifting then
wind **1/3 shifting** going to COT using both hands.
Note: Do not exert extra force.



6. Measure from end of vinyl tube up to end of tape
25±3mm using both hands. Make **2 windings** of tape
before shifting.

MEASURING TAPE



NOTE:
USED **YELLOW TAPE** FOR EASY
VISUALIZATION OF SHIFTING LINE,
BUT ACTUAL SHOULD BE **BLACK**.

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 wrong orientation of assy parts

Note:
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measuring tape when getting the
measurement.

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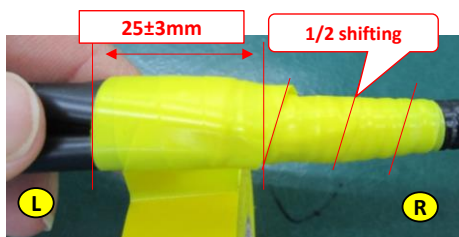
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

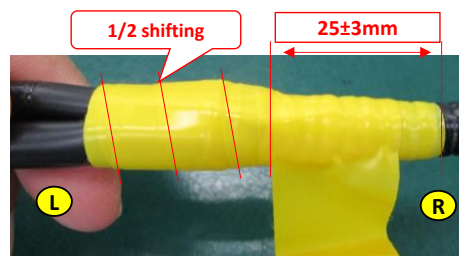
QUALITY POINTERS

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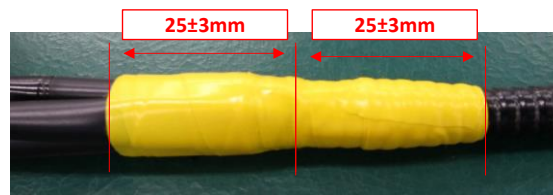
P2

Y-Taping
(Continuation)

7. Make **1/2 shifting** going to vinyl tube until **25±3mm** then make **2 windings** of tape before final shifting.

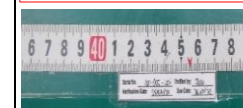


8. Make **1/2 shifting** going to COT until **25±3mm** then make **3 windings** of tape then cut the tape.



9. After taping, check the measurement and taping condition.

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
7. No wrong orientation of assy parts

Note:

Please use calibrated/verified measuring tape when getting the measurement.

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