



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: 150B / 3 7L0058-7023

Customer:

TRQSS

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

November 25, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-228C

Revision No.:

3

Page No.:

1 of 3

PARTS: 3 1. Assy parts; Black tape [2pcs.]

JIG:

1. Taping jig

NO.

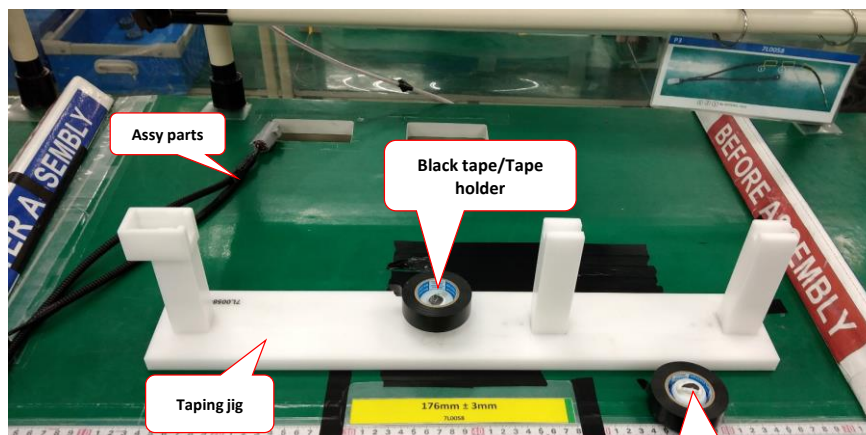
PROCESS NAME

3 WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

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

Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
11/25/21	3	Change part number from 7L0058-7022 to 7L0058-7023 due to additional clamp (82711-52090 (W)) (Refer to WI-ENG-PDE-228D). Improve work procedure and illustration. Additional table lay-out.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
02/01/21	2	Transfer process owner from Production (WI-PRO-ASY-134C) to Engineering (WI-ENG-PDE-228C). Add calibrated measuring tape illustration and instruction on pg.2	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
07/05/20	1	Additional work procedure in taping	A. Roxas	A. Morcozo	O. Merin	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted

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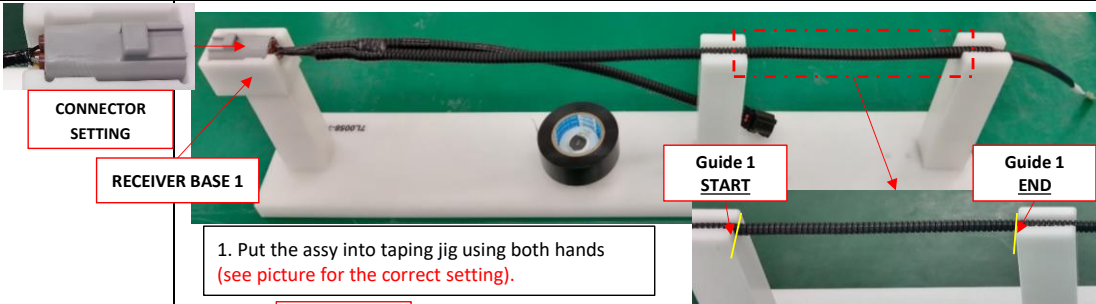
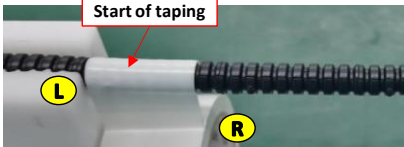
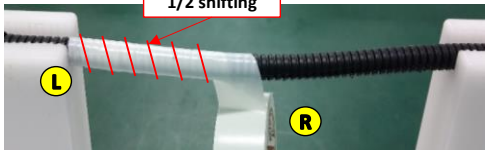
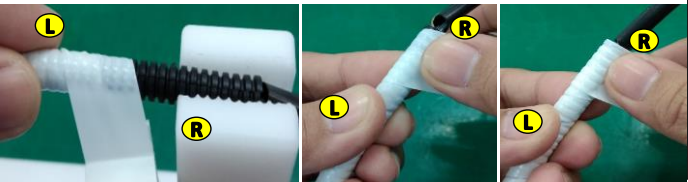
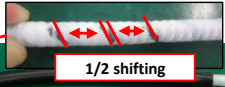
☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape	JIG	1. Taping jig
NO.	PROCESS NAME	3 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3	<div>Half-wrap taping</div> <div><p>1. Put the assy into taping jig using both hands (see picture for the correct setting).</p><p>2. Hold the COT using left hand, get the Black tape using right hand then start taping process using both hands.</p><p>3. Make 1/2 shifting going to other side of COT.</p><p>4. Remove the assy parts then continue the taping process using both hands until covers the COT with slit. Make 3 windings of tape then cut.</p><p>5. Check the taping condition.</p></div>	MEASURING JIG	<p>Note: USE WHITE TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape</p>

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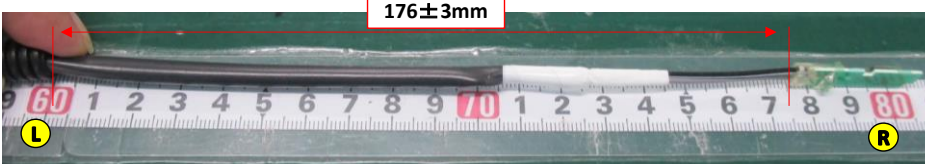




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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	<p>Taping COT to Sunprene</p>  <p>1. Measure from end of COT up to hotmelted wire 176mm using both hands.</p>  <p>2. Fix the COT and sunprene tube using both hands. Make sure no gap in between.</p>  <p>3. Get the Black tape using right hand then start taping process using both hands. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>4. After taping, check the dimension and taping condition.</p>	<p>MEASURING JIG</p> 	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape

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