

	WORK INSTRUCTION				Effectivity Date:		June 28, 2021	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Product Name/Code: RE7 / 15F855-0050		Customer: TRP		Document No.: WI-ENG-PDE-022B	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		5	Page No.: 1 of 2

PARTS:	1. Tesa Tape No.51618 2. Assy parts	JIG:	1. Tesa Cutter jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Taping 1 Vinyl tube to wire near connector	<div style="display: flex; flex-direction: column; align-items: center;"> <div style="border: 1px solid black; padding: 5px; margin: 5px; width: 100%;">1. Hold the vinyl tube using left hand and measure the vinyl tube up to the connector <u>38mm</u>.</div> <div style="border: 1px solid black; padding: 5px; margin: 5px; width: 100%;">2. Fold the vinyl tube then conduct taping, 1 wind before shifting</div> <div style="border: 1px solid black; padding: 5px; margin: 5px; width: 100%;">3. Make 1/2 shifting, 3 winds going to right direction.</div> <div style="border: 1px solid black; padding: 5px; margin: 5px; width: 100%;">4. 1 wind before end of tape</div> <div style="border: 1px solid black; padding: 5px; margin: 5px; width: 100%;">5. Cut the tape using the provided cutter then press the end</div> <div style="border: 1px solid black; padding: 5px; margin: 5px; width: 100%;">6. Press the end tape using left hand.</div> <div style="border: 1px solid black; padding: 5px; margin: 5px; width: 100%;">7. After taping, check the measurement and taping condition.</div> <div style="border: 1px solid black; padding: 5px; margin: 5px; width: 100%;">8. Check the measurement from tube to connector</div> </div>	<div style="border: 2px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 2px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 2px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div> <div style="margin-top: 10px;"> MEASURING TAPE </div>	<div style="border: 1px solid black; padding: 5px; margin-bottom: 10px;"> TESA TAPE CONDITION Whitish appearance of Tesa Tape due to thickness variation Judgement: GOOD </div> <div> 1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong dimension 5. No damage parts </div> <div style="margin-top: 10px; color: red; font-size: small;"> Note: Please use calibrated/verified measuring tape when getting the measurement. </div>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
06/28/21	5	Removal of validity date.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	
01/28/21	4	Update effective and validity date; change the taping dimension reference from vinyl tube to connector from 35mm to 38mm due to change in overall length from 243mm to 246mm as per customer request	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes	
02/08/19	n/a	Previously established as Engineering Instruction (EI-ENG-PDE-068). Initial issue.	R. Alcatara	A. Shimamura	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Note	Est. Date: February 08, 2019

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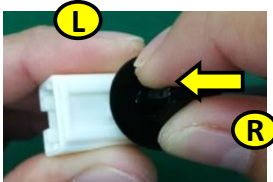
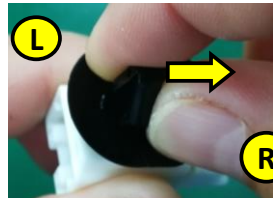

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PARTS:

1. Type Clamp B001200839

JIG

N/A

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Clamp attachment (Clip type Clamp B001200839)	  <p>1. Get clamp using right hand then Hold the connector using left hand. Insert the clamp and slightly push into connector using right hand. Click sound will be heard if insertion was OK.</p> <p>2. Make sure clamp is fully inserted by 1x pushing downward.</p> <p>Clamp B001200839</p> <p><i>Note: Only one side of the clamp can be inserted to connector.</i></p>	N/A	1. No loose attachment of clamp 2. No damage parts
3	Pass WIP to P3	 <p>Put WIP to WIP holder. <i>Note: One Piece Flow</i></p>	n/a	1. No WIP overflow

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