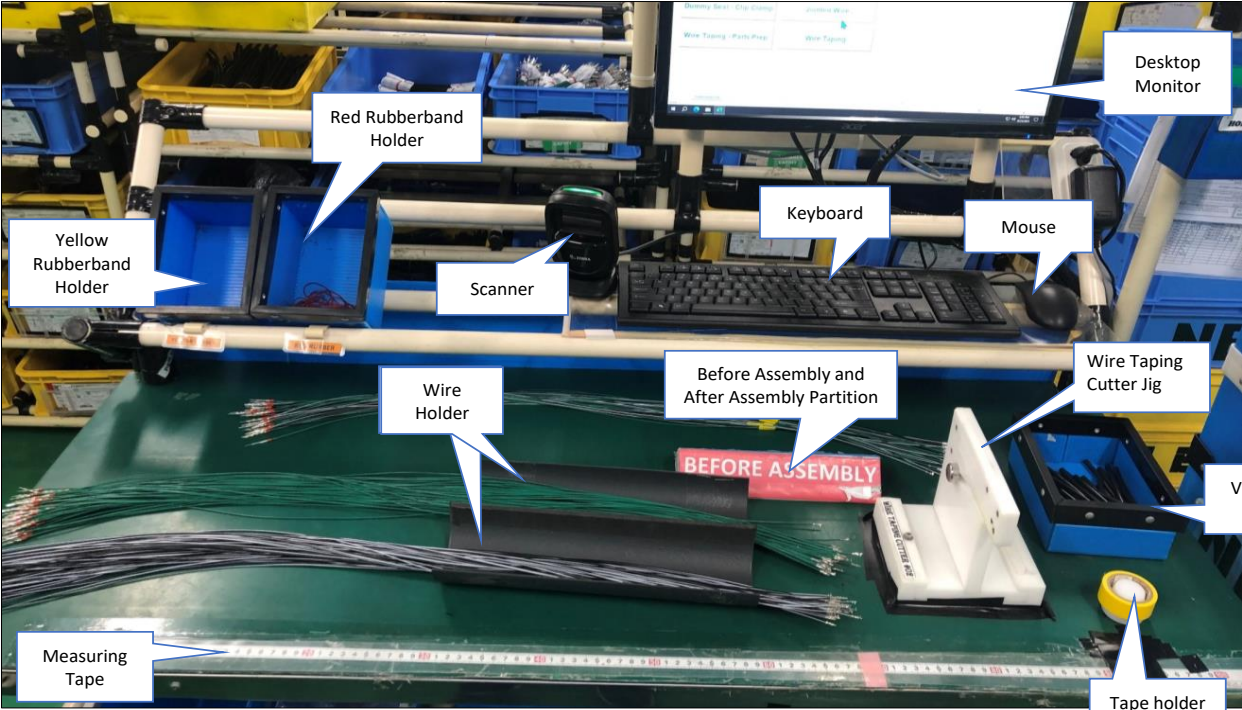
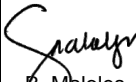




No.		Work Procedure/Illustration					Records/Remarks/ Quality Pointers			
1		<div>Table Layout</div> 					<div>* No wrong use of parts or tools</div> <div>* No missing tools or parts</div>			
11/09/2023	11	Change process of wire taping (remove rotating of tape to avoid muscle fatigue of operator and easy taping)			B. Maloles	W. Carbillon	O. Merin	Prepare	Check	Approve
09/20/2023	10	Change photo of table layout due to change position of vinyl tube holder (Due to additional desktop monitor for paperless improvement)			B. Maloles	W. Carbillon	O. Merin	<div> B. Maloles</div>	<div> W. Carbillon</div>	<div> O. Merin</div>
07/25/2023	9	Additional item no. 7 (page 4) output checking, countermeasure for wrong color of wire, missing and uninsert vinyl tube			B. Maloles	W. Carbillon	O. Merin			
02/23/2023	8	Correction of reference of tape color in item no. 2 and 6			B. Maloles	M. Cruzat	O. Merin			
Eff./Rev. Date	Rev. No.	Details of Change			Revise	Check	Approve	Est. date:	July 10, 2017	
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DCC Stamp										

Process Name/Title:

## WIRE TAPING

Document No:

# WI-PRO-KIT-006

## WORK INSTRUCTION

Effective Date:

**November 09, 2023**

Product Code/Name:  
**COMMON**

Customer Code:  
**COMMON**

Rev.No.: 11

Page No.:

Page 2 of 5

No.

### Work Procedure/Illustration

### Records/Remarks/ Quality Pointers

2

## Daily Operation Report

[illegible]

1. Conduct Hatsumono by Operator and Freeman/Leader.  
Update the date, ID No., and judgement (O- Good or X- No Good) in Wire Taping Checksheet portion.

## 1. No missing details

3

## Vinyl Tube Insertion

**(Note: Applicable only for model that have Vinyl Tube)**



2. Get the partner wires using left hand then insert vinyl tube using right hand.

**1. No wrong use of parts**  
(Refer to Daily Operation Report (Wire Taping Process) F-PRO-KIT-002-6 per model for the correct color of wire and specification of Vinyl Tube)


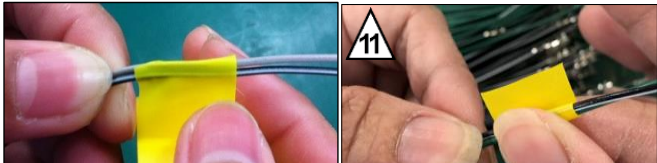

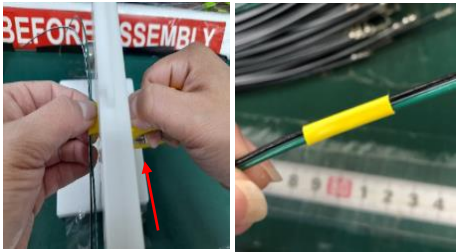
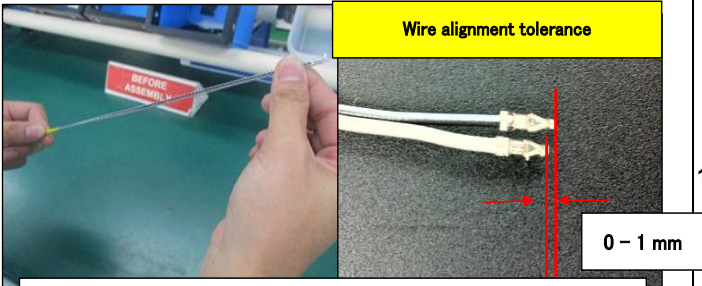
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Process Name/Title: <b>WIRE TAPING</b>		Document No:	<b>WI-PRO-KIT-006</b>	
<b>WORK INSTRUCTION</b>		Effective Date:	<b>November 09, 2023</b>	
Product Code/Name: <b>COMMON</b>	Customer Code: <b>COMMON</b>	Rev.No.: 11	Page No.:	<b>Page 3 of 5</b>

No.	Work Procedure/Illustration		Records/Remarks/ Quality Pointers
4	Wire Measurement	 <p>3. Align the 2 partner wires together. End of terminal tip must be align to one another.</p> <p>4. Align the wires then measure <b>220mm</b> from the terminal tip.</p>	1. No deform terminal 2. No wrong use of parts 3. No mis-align end of terminal tip 4. No wrong dimension
5	Wire taping	 <p>5. Hold the wire using left hand and then start taping using right hand. Standard No. of windings: <b>Max. 2</b> Refer to Parts Preparation Card for the correct tape color per model.</p> 	1. No wrong use of tape color 2. No excessive windings of tape
6	Tape cutting	 <p>6.. Cut the tape using the provided cutter, then press the end tape.</p>  <p>7. Align the 2 wires from tape to terminal tip then check the condition of the terminal.</p>	1. No wrong use of parts

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Process Name/Title:

**WIRE TAPING**

Document No:

**WI-PRO-KIT-006****WORK INSTRUCTION**

Effective Date:

**November 09, 2023**Product Code/Name:  
**COMMON**Customer Code:  
**COMMON**

Rev.No.: 11

Page No.:

**Page 4 of 5****No.****Work Procedure/Illustration****Records/Remarks/  
Quality Pointers****7****Ouput checking**

8. After completing the set, count the wire taped one by one until 100 pieces.  
Note: While counting, check the appearance of tape and wire must be different wire color.



(Note: Applicable only for models that have Vinyl Tube)

9. Check one by one if all wires are inserted in vinyl tube.

1. No wrong color of wire
2. No wrong color of tape
3. No missing vinyl tube
4. No same color of wire
5. No uninsert vinyl tube

**8****Daily Operation Report**

Daily Operation Report (Wire Taping Process)													
Model Code:		7L0048-7023										Month/ Year:	
I. WIRE TAPING CHECKSHEET													
Insurge: <input type="radio"/> Operator <input type="radio"/> Line Leader <input type="radio"/> Judgement: <input type="radio"/> Good <input type="radio"/> No Good													
Criteria	Date	ID No.	Date	ID No.	Date	ID No.	Date	ID No.	Date	ID No.	Date	ID No.	Remarks
<b>A. PARTS DELIVERED</b>													
1. Count Wire Color													
2. Count Wire Dimension													
3. Count Wire Type													
4. Count Wire Length													
5. Count Wire Weight													
6. Count Wire Quantity													
7. Count Wire Material													
8. Count Wire Finish													
9. Count Wire Label													
10. Count Wire Tag													
<b>B. WIRE TAPED</b>													
1. Presence of Tape and													
2. Presence of Wire and													
3. Presence of Wire and													
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10. Conduct Owarimono by Operator and Freeman/Leader.  
Update the ID No., and judgement (O- Good or X- No Good) in Wire Taping Checksheet portion.

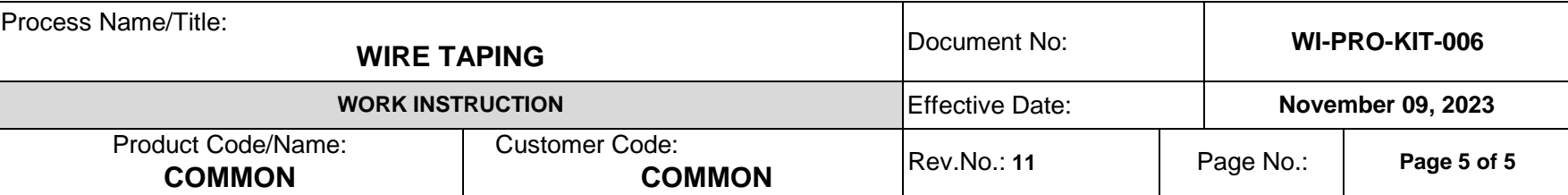
**1. No missing details****9****ID Tag**

MAIN ASSEMBLY		Model Code		7M0519-7020A		PD DATE		MM DD YY		Line No.		Quantity of Sale		200	
MR		ID #		700349-0000		Start Time:		End Time:		NG Qty		REF Qty			
Kitting		Sub-Assy		QC SUB ASSY INSPECTION		Soldering 1		Soldering 2		Hotmelt		QC FG		FG PACKING	
2nd Shift		1st Shift		2nd Shift		1st Shift		2nd Shift		1st Shift		2nd Shift		1st Shift	
MR		DO		YY		MR		DO		YY		MR		DO	
NG Qty		Operator		Date		Start Time		End Time		NG Qty		Operator		Date	
1		JWS		11/09/23		08:30		18:30		1		JWS		11/09/23	

11. Update ID tag (Date, Shift, Time Start and End, Operator, and " - " dash symbol for the items that are not applicable).

**1. No missing details**





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