
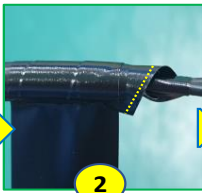

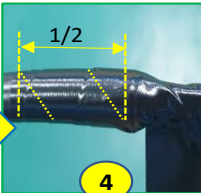
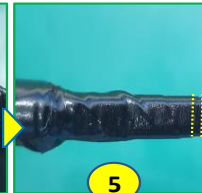


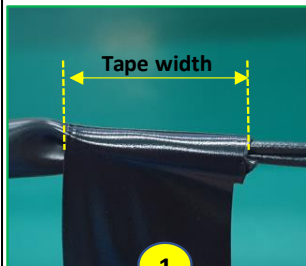
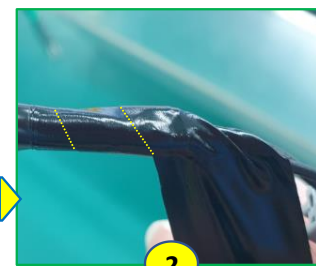
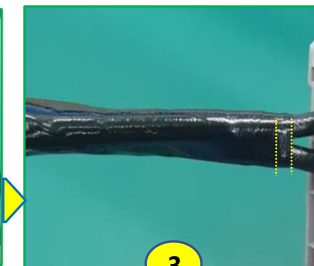

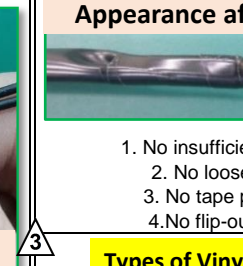



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	SUB-ASSEMBLY TAPING PROCEDURE (VT to wire and COT to VT)					
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	Product Code/Name: COMMON	Customer Code: COMMON	Rev.No.: 3	Page No.: 1 of 4		


No.	Work Procedure / Illustration							Records/Remarks/ Quality Pointers	
1 3	SV Vinyl tube to Crimped Wire/ Twisted tube to Crimped Wire ( ø4 VT without folding)								1. No insufficient taping 2. No loose tape 3. No tape peeling 4.No flip-out tape
		Pre-tape (middle) <b>1 wind</b>	Shift down	1 wind	Shifting (up) - 1/2	2 winds before end of tape	Conduct <b>3x</b> pressing at the end of Taping to prevent peel off and loose tape using left thumb. <i>Refer to WI-PRO-COM-015</i>		
2 3	SV Vinyl tube to Crimped Wire ( ø5 VT with folding)							1. No insufficient taping 2. No loose tape 3. No tape peeling 4.No flip-out tape	
		<b>2 winds</b> before shifting	Shift up - 1/2	2 winds before end of tape	Conduct <b>3x</b> pressing at the end of Taping to prevent peel off and loose tape using left thumb. <i>Refer to WI-PRO-COM-015</i>				
								3 <b>Types of Vinyl Tube</b>	
									SV Vinyl tube Hard type
									VM Sunprene tube Soft type

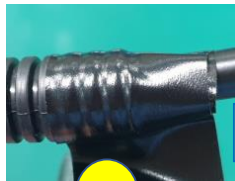

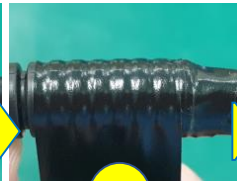
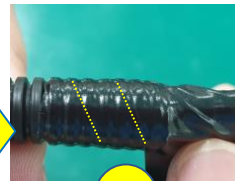

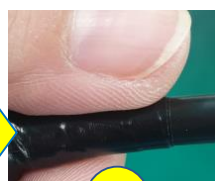

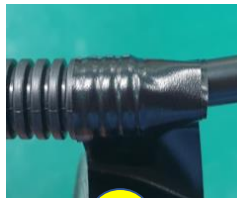
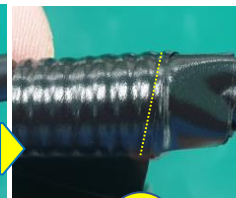

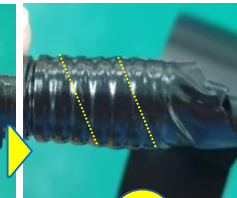
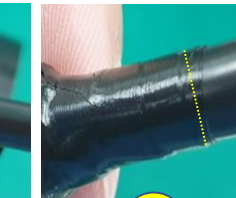




						Prepare	Check	Approve
04/29/2025	3	Include types of Vinyl tube & twisted tube same as taping condition of ø4 w/o folding Additional page for the steering taping process & change call out of No incomplete taping to No insufficient taping			J. Jarito	A. Ayop	W. Carbillon	
01/15/2025	2				J. Jarito	A. Ayop	W. Carbillon	
10/17/2024	1	Change Taping Method for COT to VT and COT to Sunprene			J. Reyes	C. Calayan	W. Carbillon	
07/10/2024	0	Initial issue. Separated from WI-PRO-ASY-001A.			C. Recto	C. Calayan	W. Carbillon	
Eff./Rev. Date	Rev. No	Details of change			Revise	Check	Approve	Est. date: 07/10/2024

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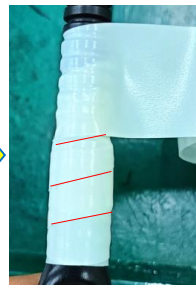


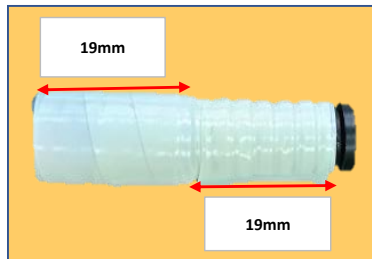







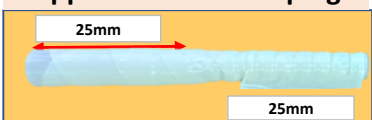


No.	Work Procedure / Illustration						Records/Remarks/ Quality Pointers	
3 3	ø 5 COT to ø 5 SV VT							Appearance after Taping 
		Pre-tape(middle) <u>1 wind</u>	Shift down	1 wind taping before shifting	1/3 shifting	2 winds before end of tape	Conduct <u>3x</u> pressing at the end of Taping to prevent peel off	1. No insufficient taping 2. No loose tape 3. No tape peeling 4.No flip-out tape
4 3	ø 7 COT to ø 5 SV VT							Appearance after Taping 
		Pre-tape(middle) <u>2 winds</u>	Shift down	1 winds taping before shifting	1/3 shifting	2 winds before end of tape	Conduct <u>3x</u> pressing at the end of Taping to prevent peel off	1. No insufficient taping 2. No loose tape 3. No tape peeling 4.No flip-out tape
								<b>Types of Vinyl Tube</b>
								 SV Vinyl tube Hard type
								 VM Sunprene tube Soft type

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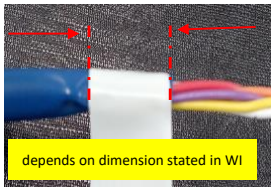
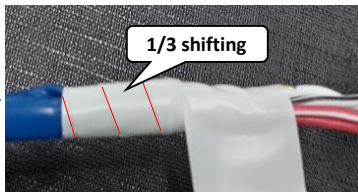
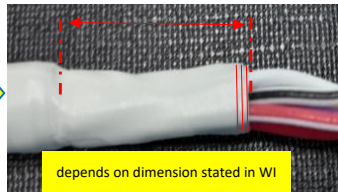







No.	Work Procedure / Illustration							Records/Remarks/ Quality Pointers	
5	COT to VM Sunprene tube 19mm 3								
		1. <u>1 Wind</u> pre tape in the middle of cot and sunprene tube	2. shift the tape <u>1/2 shifting</u> going to sunprene tube must be 19mm	3. make <u>1 Wind</u> before shifting	4. shift the tape <u>1/3 shifting</u> going to cot	6. make <u>2 winds</u> before end of tape	7. conduct 3x pressing at the end of tape to avoid peel off.	1. No insufficient taping 2. No loose tape 3. No tape peeling 4.No flip-out tape	
6	COT to VM Sunprene tube 25mm 3								<b>Appearance after Taping</b> 
		1. <u>1 Wind</u> pre tape in the middle of cot and sunprene tube	2. shift the tape <u>1/2 shifting</u> going to sunprene tube must be 25mm	3. make <u>1 Wind</u> before shifting	4. shift the tape <u>1/3 shifting</u> going to cot	5. shift the tape <u>1/2 shifting</u> upward until it reach 25mm	6. make <u>2 winds</u> before end of tape	7. conduct 3x pressing at the end of tape to avoid peel off.	1.No insufficient taping 2. No loose tape 3. No tape peeling 4.No flip-out tape
<b>Types of Vinyl Tube</b>									
 SV Vinyl tube Hard type									
 VM Sunprene tube Soft type									

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No.	Work Procedure / Illustration					Records/Remarks/ Quality Pointers		
7 3	Vinyl tube to Crimped Wire (All dimension) VM Sunprene tube  Applicable to Steering process					<b>Appearance after Taping</b>   1. No insufficient taping 2. No loose tape 3. No tape peeling 4.No flip-out tape		
		1. <u>2 Winds</u> before shifting ( width must be depends on stated in WI)	2. shift up <u>1/3</u> going to crimped wire	3. make <u>3 Winds</u> before end of tape ( width must be depends on stated in WI)	Conduct <u>3x</u> pressing at the end of Taping to prevent peel off and loose tape using left thumb. <i>Refer to WI-PRO-COM-015</i>	<div>3</div> <b>Types of Vinyl Tube</b> <table><tr><td></td><td>SV Vinyl tube Hard type</td></tr><tr><td></td><td>VM Sunprene tube Soft type</td></tr></table>		SV Vinyl tube Hard type
	SV Vinyl tube Hard type							
	VM Sunprene tube Soft type							

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