
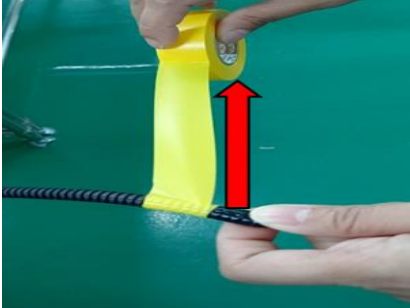


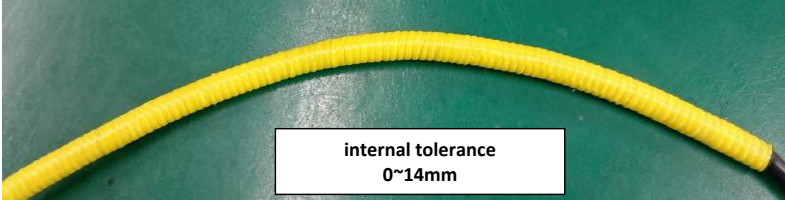

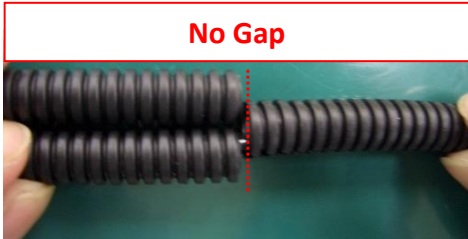
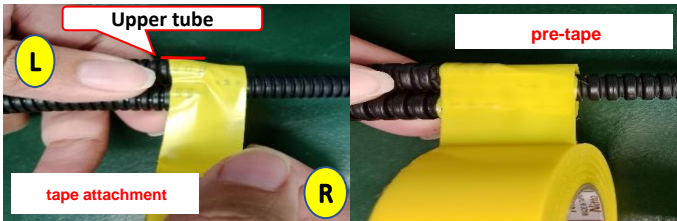
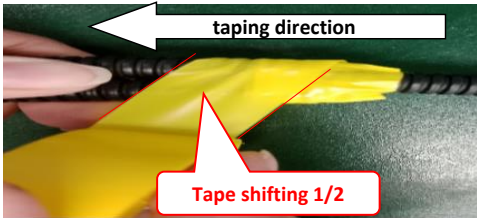
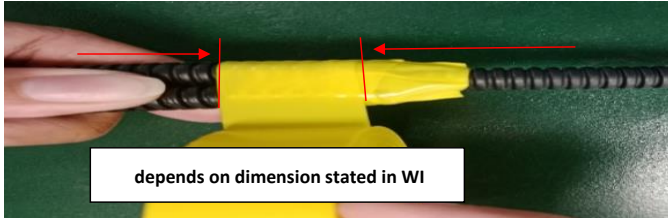
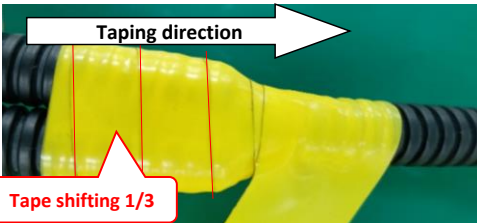
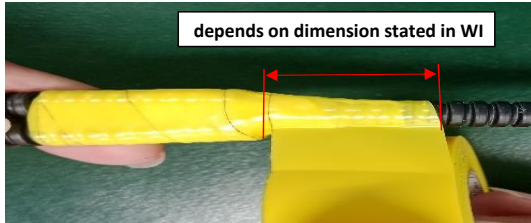
	Process Name/Title:		Document No:		WI-PRO-ASY-001C	
	SUB-ASSEMBLY TAPING PROCEDURE (Special)					
	WORK INSTRUCTION		Effective Date:		January 13, 2025	
	Product Code/Name: <b>COMMON</b>	Customer Code: <b>COMMON</b>	Rev.No.: 2	Page No.: 1 of 5		

No.	Work Procedure / Illustration			Records/Remarks/ Quality Pointers
1	Half wrap Taping	 <p>1. Attach the tape, then make 2 winds.</p>  <p>2. Pull the tape around 150mm~200mm.</p>  <p>3. Hold the other side of the harness on the table and apply force to rotate the tape to make halfwrap shifting until cover the COT with slit.</p>  <p>4. Make 2 winds before cut the tape.</p>  <p>5. After taping, check the condition of tape. <b>THERE MUST BE NO EXPOSED COT BETWEEN HALF WRAP TAPING.</b></p>	<p>1. No peel off tape 2. No flip out 3. No loose/tight tape 4. <b>No exposed COT between tape windings</b></p>  <p><b>Appearance after Taping</b></p> <p>Conduct <b>3x</b> pressing at the end of Taping to prevent peel off and loose tape using left thumb. <b>Refer to WI-PRO-COM-015</b></p> <p><b>Note: Used Yellow tape for easy visualization of shifting lines.</b></p>	

							Prepare	Check	Approve
01/13/2025	2	Change 1/2 to 1/3 shifting of Y-taping condition	J. Jarito	A. Ayop	W. Carbillon				
08/30/2024	1	Additional page of Y-taping condition	J. Jarito	A. Ayop	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:	July 10, 2024		

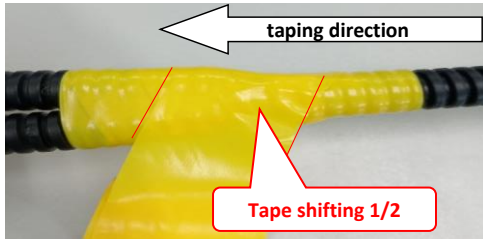
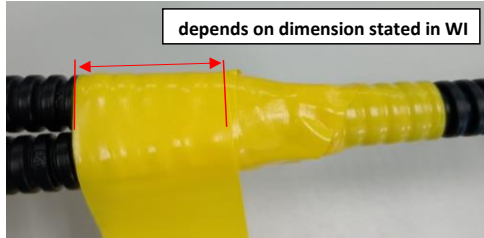
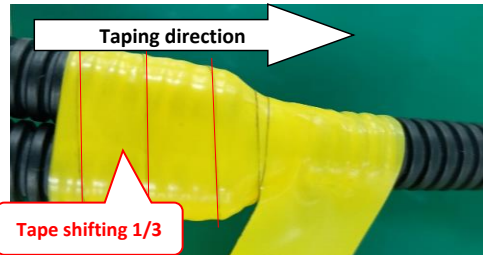
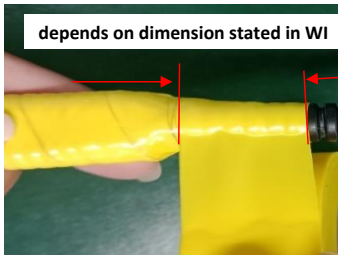

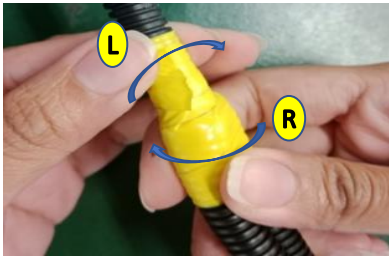
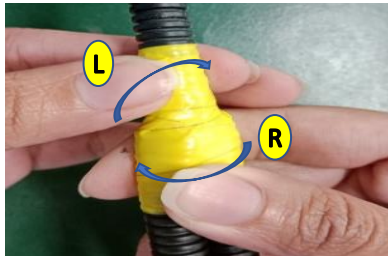
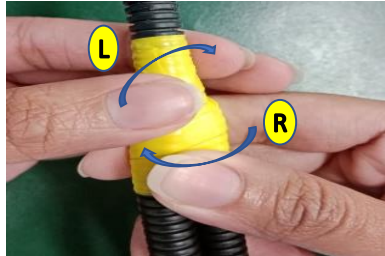


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No.	Work Procedure / Illustration		Records/Remarks/ Quality Pointers
2	<b>Y-Taping (3-4 tubes) (All dimension)</b>	<div><p><b>No Gap</b></p><p>1. Fix the tubes.</p></div> <div><p>Upper tube</p><p>L</p><p>R</p><p>tape attachment</p><p>pre-tape</p><p>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape <b>2 windings</b>. <i>Note: Do not exert excessive force during pulling &amp; winding of tape.</i></p></div> <div><p>taping direction</p><p>Tape shifting 1/2</p><p>3. Winding the tape <b>1/2 shifting</b> going to the left side.</p></div> <div><p>depends on dimension stated in WI</p><p>4. Make <b>2 windings</b>, width must be (depends on dimension stated in WI)</p></div> <div><p>Taping direction</p><p>Tape shifting 1/3</p><p>5. Winding the tape <b>1/3 shifting</b> going to the right side until reach the other side of tube.</p></div> <div><p>depends on dimension stated in WI</p><p>6. Make <b>2 windings</b>, width must be (depends on dimension stated in WI)</p></div>	<ol style="list-style-type: none"><li>1. No tape peeling</li><li>2. No flip out of tape</li><li>3. No wide interval between the COT</li><li>4. No exposed wire</li></ol> <p>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></p> <p><b>Note: Used Yellow tape for easy visualization of shifting lines.</b></p>







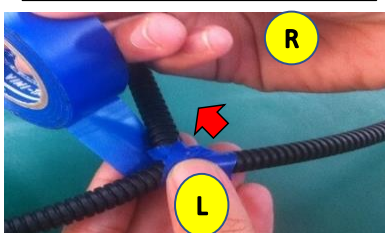


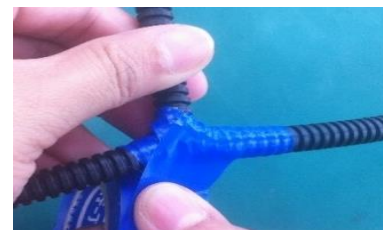
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No.	Work Procedure / Illustration		Records/Remarks/ Quality Pointers
3	<div>△ <b>Y-Taping (3-4 tubes) (All dimension) (continuation)</b></div>	<div><p>7. Winding the tape <b>1/2 shifting</b> going to the left side.</p><p>8. Make <b>2 windings</b>, width must be (depends on dimension stated in WI)</p><p>9. Winding the tape <b>1/3 shifting</b> going to the right side until it reach the other side of tube</p><p>10. Make <b>3 winds</b>, width must be (depends on dimension stated in WI). Then cut the tape.</p><p>11. conduct proper pressing of end tape using left hand (<b>top part</b>)</p><p>12. conduct proper pressing of end tape using left hand (<b>Middle part</b>)</p><p>13. conduct proper pressing of end tape using left hand (<b>bottom part</b>)</p></div>	<div>1. No tape peeling 2. No flip out of tape 3. No wide interval between the COT 4. No exposed wire</div> <div>Conduct <b>3x</b> pressing at the end of Taping to prevent peel off and loose tape using left thumb. <b>Refer to WI-PRO-COM-015</b></div>

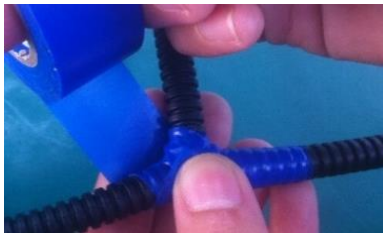





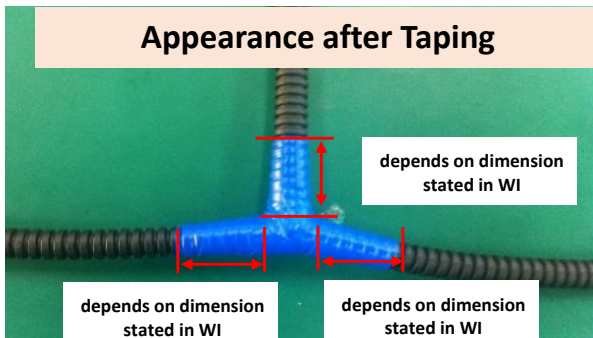




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No.	Work Procedure / Illustration			Records/Remarks/ Quality Pointers	
4	T - Taping (All dimension)	 <p>1. Arrange the 3 corrugated tube to form inverted T using left and right hand.</p>	 <p>2. Start taping at the middle to fix the 3 corrugated tubes using right hand.</p>	 <p>3. Wind the tape from front to back at the right side</p>	<div>1. No peel-off tape</div> <div>2. No flip out tape</div> <div>3. No wide interval between the COT</div> <div>4. No exposed wire</div> <div>Conduct <b>3x</b> pressing at the end of Taping to prevent peel off and loose tape using left thumb.</div> <div><b>Refer to WI-PRO-COM-015</b></div> <div><b>Note: Used Blue tape for easy visualization of shifting lines.</b></div>
 <p>4. Wind the tape from back to front (cross pattern)</p>		 <p>5. Wind the tape from front to back at the left side</p>	 <p>6. Wind the tape from back to front (cross pattern)</p>		
<p>7. Repeat the process from 3-6, 3 times</p>		 <p>8. Tape the right side corrugated tube (3 winds), width must be (depends on dimension stated in WI)</p>	 <p>9. From the right side, wind the tape 2/3 shifting going to center</p>		

	Process Name/Title: <b>SUB-ASSEMBLY TAPING PROCEDURE (Special)</b>		Document No:	<b>WI-PRO-ASY-001C</b>
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No.	Work Procedure / Illustration			Records/Remarks/ Quality Pointers	
5	T - Taping (All dimension) (continuation)	 <p>10. Wind the tape from front to back side (cross pattern)</p>	 <p>11. Tape the top side corrugated tube (3 winds), width must be (depends on dimension stated in WI)</p>	 <p>12. From the top side, wind the tape 2/3 shifting going to center</p>	<div>1. No peel-off tape 2. No flip out tape 3. No wide interval between the COT 4. No exposed wire</div> <div>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></div>
 <p>13. Wind the tape going to front side (cross pattern)</p>		 <p>14. Wind the tape from front to back side (cross pattern)</p>	 <p>15. Tape the right side corrugated tube (3 winds), width must be (depends on dimension stated in WI)</p>		
<p>16. After taping, check the measurement and condition of tape.</p>		<div>Appearance after Taping</div>  <p>depends on dimension stated in WI</p> <p>depends on dimension stated in WI</p> <p>depends on dimension stated in WI</p>			