



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

August 2, 2021

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Product Name/Code:

100B / 7M0592-7020B

Customer:

TRJ

Document No.:

WI-ENG-PDE-311C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:


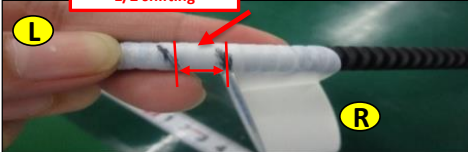
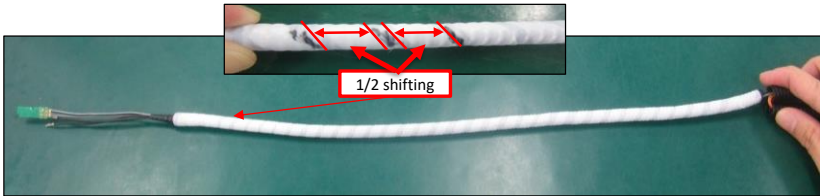

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PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3 Taping 1 Half-wrap taping	<p>Start of taping</p>  <p>1. Hold the corrugated tube using left hand and begin taping using right hand.</p> <p>1/2 shifting</p>  <p>2. Make 1/2 shifting. Repeat the process until the end of corrugated tube. Make 3 windings and then cut the tape.</p>  <p>3. Check the taping condition.</p>	<p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping</p> <ol style="list-style-type: none">1. Maintain and always practice 5's.2. Personal things on the workplace is prohibited. Keep it in your locker. <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <p>MEASURING TAPE</p> 	<p>Note:</p> <p>USE WHITE TAPE FOR EASY VISUALIZATION SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
08/02/21	1	Transfer process owner from Production (WI-PRO-ASY-116C) to Engineering (WI-ENG-PDE-311C). Apply some improvements and update picture/illustration in all process.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
04/10/18	n/a	Previously established as Engineering instruction (EI-ENG-PDE-027). Initial issue	S. Manalo	R. Alcantara	A. Arañes	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

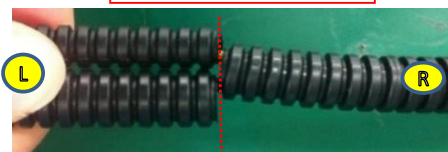
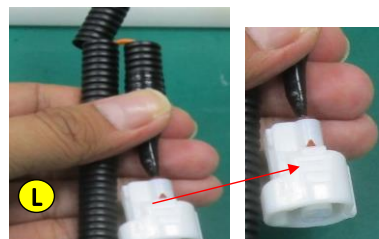
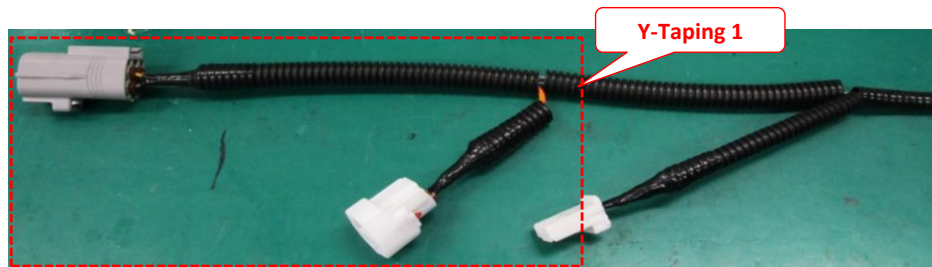
TOOLS/PPE

QUALITY POINTERS

2

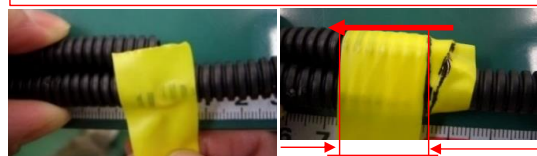
P3

Taping 2
Y- Taping (1)



1. Fix the corrugated tube . Follow the correct orientation of connectors.

Note: Do not exert excessive force during pulling & winding of tape



2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side , width must be same with tape (19mm)

**HARNESS
FACING**

MEASURING TAPE



NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong dimension
6. No wrong use of tape

Note:
Please use calibrated/verified measuring tape when getting the measurement.

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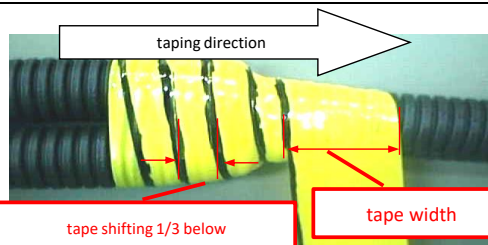
TOOLS/PPE

QUALITY POINTERS

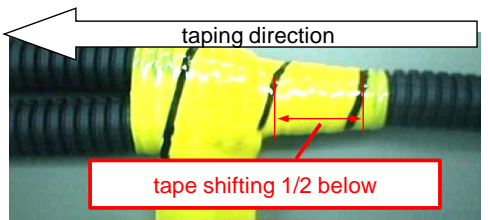
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P3

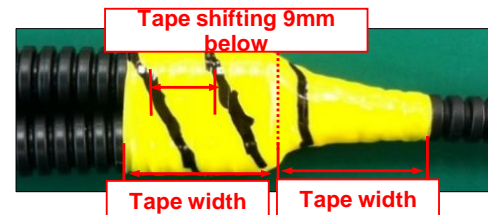
Taping 2
Y- Taping (1)
(Continuation)



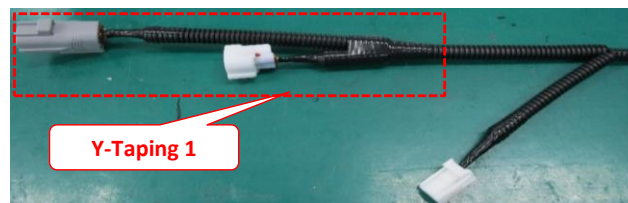
3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)



4. Wind the tape backward **1/2 shifting**



5. Wind the tape **1/2 shifting** going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.



MEASURING TAPE



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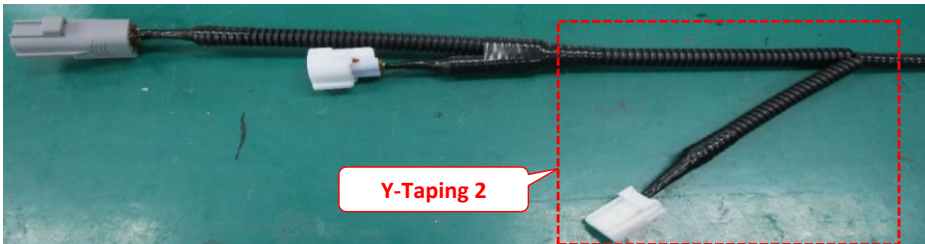
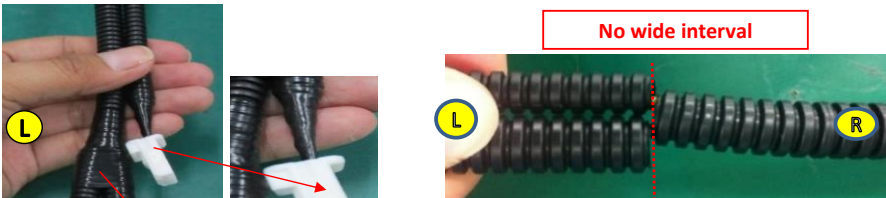
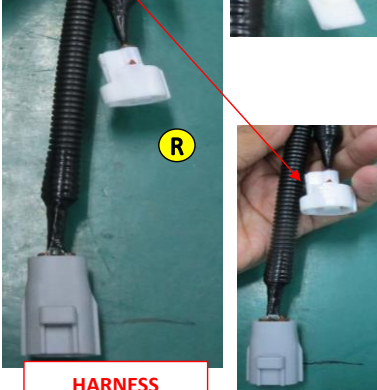

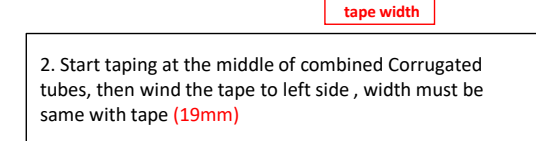

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 Taping 3 Y- Taping (2)	     <p>1. Fix the corrugated tube . Follow the correct orientation of connectors.</p> <p>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side , width must be same with tape (19mm)</p>	 <p>MEASURING TAPE</p>	<p>NOTE: USE <u>YELLOW TAPE</u> FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE <u>BLACK TAPE</u>.</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 <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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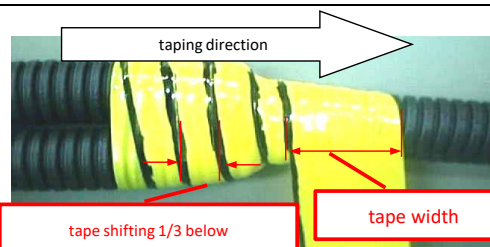
TOOLS/PPE

QUALITY POINTERS

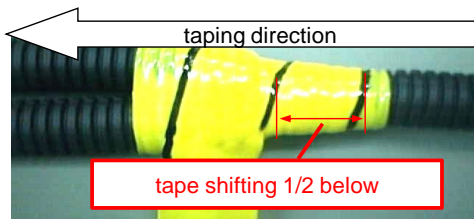
3

P3

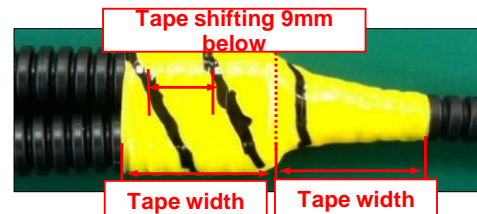
Taping 3
Y- Taping (2)
(Continuation)



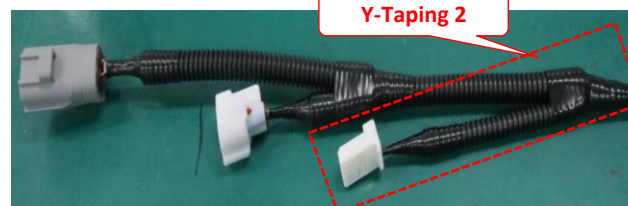
3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)



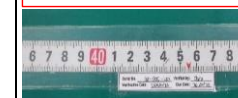
4. Wind the tape backward **1/2 shifting**



5. Wind the tape **1/2 shifting** going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.



MEASURING TAPE



1

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