



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 26, 2024

Model code/Part number:

ES1

/

7M0515-7021

Customer:

TRJ

Car Model:

SUBARU

Document No.:

WI-ENG-PDE-770B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

1 of 4

PARTS:

1. All parts: Assy parts; Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

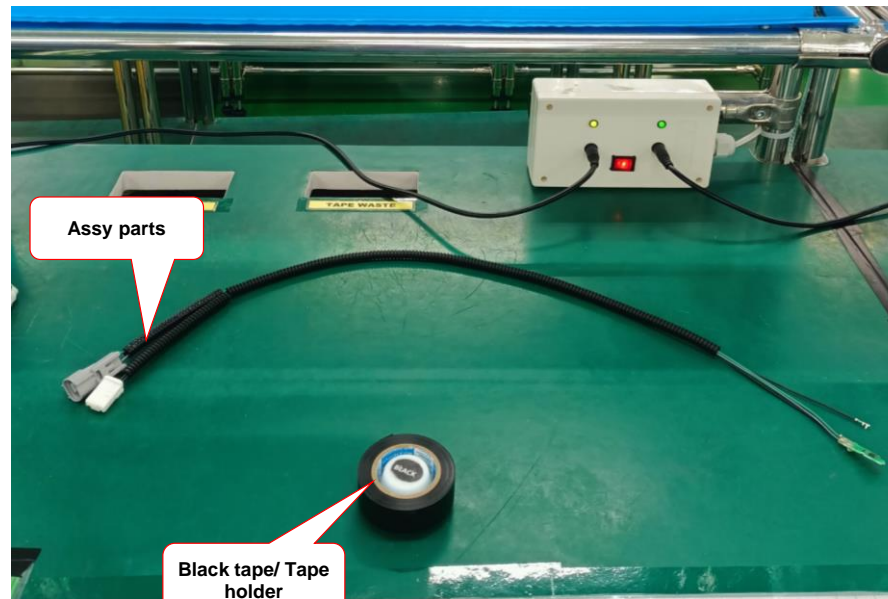
TOOLS/PPE

QUALITY POINTERS

1

P2

Table lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools


Revision History

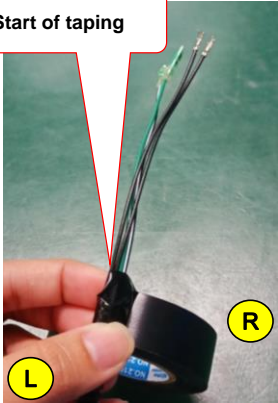
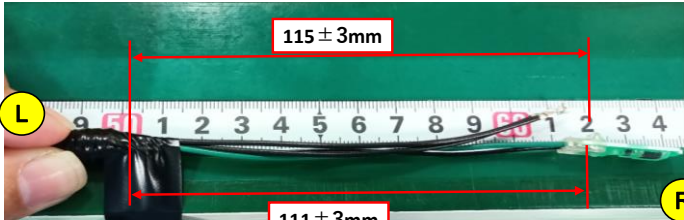
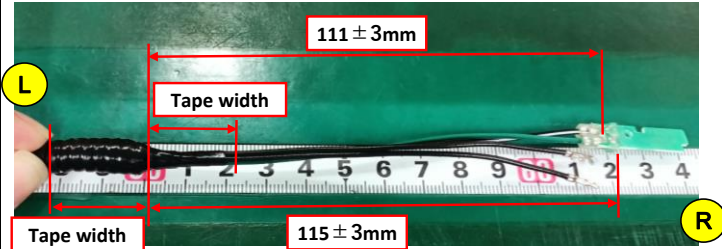

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
01/26/24	0	Initial issue. Additional Important reminders/Note/s in Half wrap taping due to customer claim countermeasure (Page 3).	D.Castillo	C. Villanueva	A. Arañes	n/a	D. Castillo	C. Villanueva	A. Arañes	n/a

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION				Effectivity Date:	January 26, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: ES1 / 7M0515-7021		Customer: TRJ	Car Model: SUBARU	Document No.:	WI-ENG-PDE-770B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	2 of 4


PARTS:	1. Assy parts 2. Black tape [1pc]			JIG:	n/a			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
2	P2 Taping 1 COT to wire near terminal and hotmelted	<div><div>Start of taping</div><div>1. Hold the corrugated tube using left hand, get the Black tape using right hand then start pre-taping using both hands.</div></div> <div><div>2. Measure from end of the corrugated tube up to hotmelted wires 131±3mm and corrugated tube to terminal pointed tip 115±3mm then continue the taping process using both hands.</div></div> <div><div>3. After taping, check the measurement, terminal appearance and taping condition.</div></div>			<div>MEASURING TAPE</div> 	<div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document references: 1. Refer to WI-PRO-ASY-001 for Taping process</div> <div>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</div>		


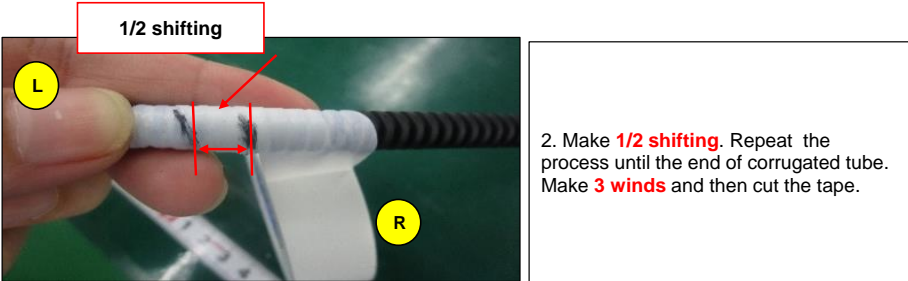
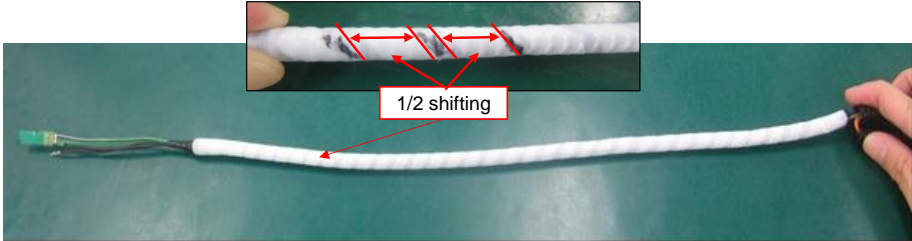

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp

	WORK INSTRUCTION				Effectivity Date:	January 26, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: ES1 / 7M0515-7021		Customer: TRJ	Car Model: SUBARU	Document No.:	WI-ENG-PDE-770B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	3 of 4

PARTS:	1. Assy parts 2. Black tape [1pc]			JIG:	n/a			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
3	P2 Half-wrap Taping 2	<div><div><div>Start of taping</div></div><div><div>1/2 shifting</div></div><div><div>1/2 shifting</div></div><div>3. Check the taping condition.</div></div>			<div>MEASURING TAPE</div> 	<div>Important reminders/Note/s 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Used <u>WHITE TAPE</u> to easily visualize the tape shifting, but actual should be <u>BLACK TAPE</u>. 3. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape</div>		

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 26, 2024

Validity Date:

n/a

Model code/Part number:

ES1

/

7M0515-7021Customer: **TRJ**

Car Model:

SUBARU

Document No.:

WI-ENG-PDE-770B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

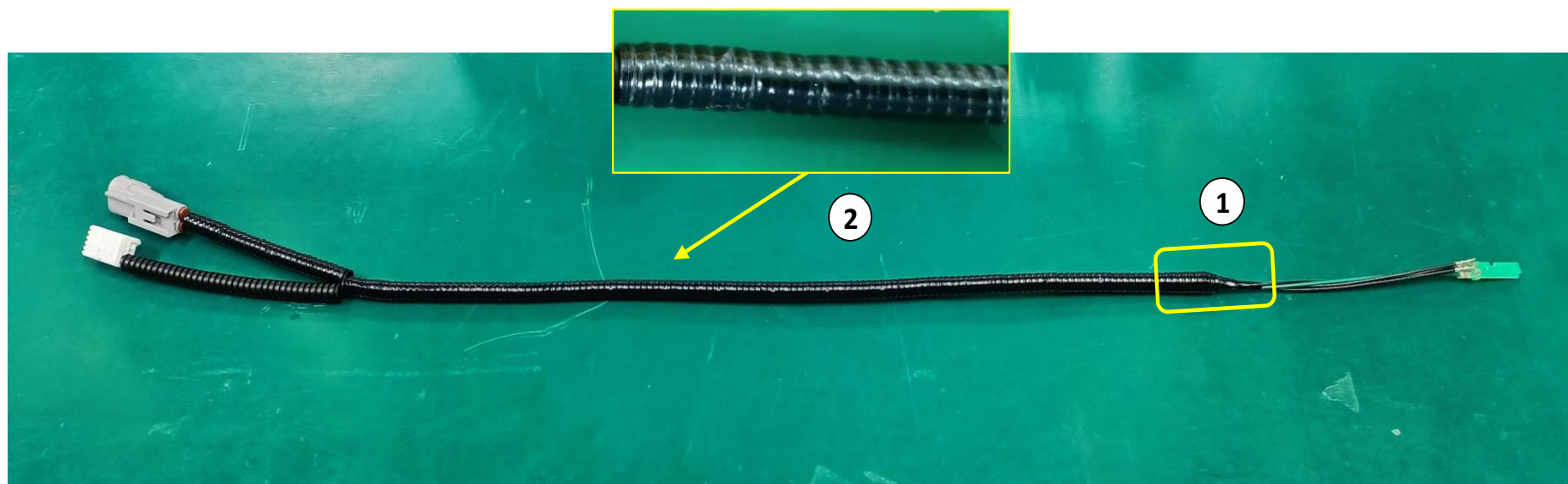
4 of 4

PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**P2****7M0515-7021****1****No MISSING TAPE****2****CHECK HALF WRAP TAPING**

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp