



# WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Product Name/Code: **780B / 7R0103-7021** Customer: **TRMX**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

April 17, 2021

Validity Date:

n/a

Document No.:

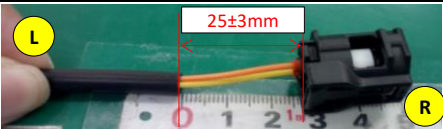
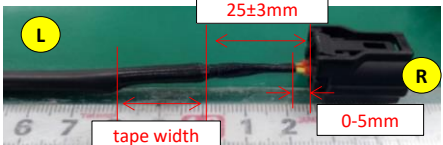

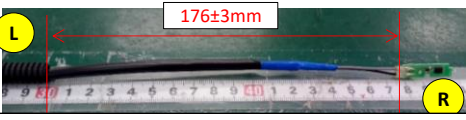
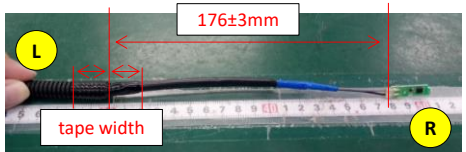
WI-ENG-PDE-206B

Revision No.:

1

Page No.:

1 of 2

PARTS:		1. Black tape [1pc] 2. Assy parts				JIG:	N/A			
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS		
1	P2	Taping 2 Vinyl tube to wire near connector	<div></div> <div>1. Hold the Vinyl tube using left hand. Measure the end of Vinyl up to the connector <b>25±3mm</b> using right hand.</div> <div></div> <div>2. Hold the Vinyl tube using left hand. Get the <b>Black tape</b> using right hand and start taping. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></div> <div>3. After taping, check the measurement and taping condition.</div>				<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div> <div><b>Measuring tape</b> </div>	<div>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</div> <div><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</div>		
2		Taping 3 COT to Sunprene tube near to PCB	<div></div> <div>1. Hold the COT using left hand. Measure the end of COT up to the edge of hotmelted wire <b>176±3mm</b> using right hand.</div> <div></div> <div>2. Hold the COT using left hand. Get the <b>Black tape</b> using right hand and start taping. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></div> <div>3. After taping, check the measurement and taping condition.</div>							
Revision History							Prepared by:	Checked by:	Approved by:	Noted by:
4/17//21	1	Change part number from 7R0103-7020B to 7R103-7021 and change from pre-launch to masspro.				D.Castillo	C.Villanueva	A.Shimamura	A.Arañes	
12/07/20	0	Initial issue.				D.Castillo	R. Peñaloza	A.Shimamura	A.Arañes	
Eff. Date	Rev. No	Details of Change				Revise	Check	Approve	Noted	
						Est. Date:	December 07, 2020			

**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**

Product Name/Code: **780B / 7R0103-7021**  Customer: **TRMX**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

April 17, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-206B

Revision No.:

1

Page No.:

2 of 2

### PARTS:

1. Black tape [1pc]
2. Assy parts

JIG

N/A

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

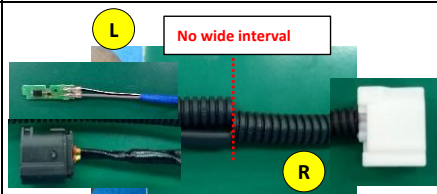
TOOLS/PPE

QUALITY POINTERS

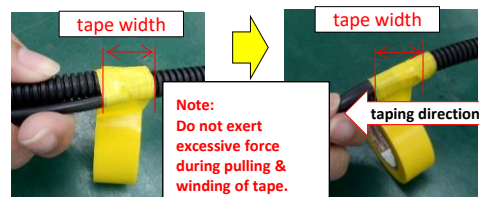
3

P2

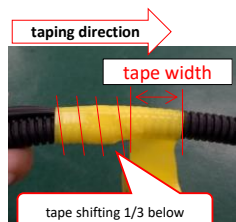
Y-taping



1. Fix the corrugated and Vinyl tube using both hands.  
*See illustration for correct facing of connector.*



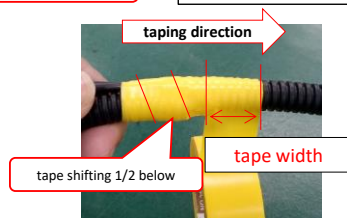
2. Start taping at the middle of combined Corrugated tubes and vinyl tube, make 1 winding pre-tape before shifting then winding the tape going to corrugated tube and vinyl tube (2 windings). (must be tape width)



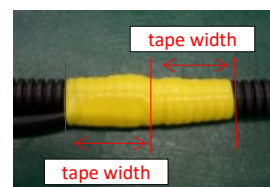
3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)



4. Winding the tape backward 1/2 shifting.



5. Winding the tape 1/2 shifting going to other side of corrugated tube then 3 windings before cut the tape. After taping, check the condition of tape.



### Measuring tape



**Note:**  
Used **Yellow** tape to easily visualize the tape shifting.  
But actual should be **Black**.

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wide interval between the COT
5. No wrong use of tape

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



**Connector Orientation**

**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