



# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

June 6, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number: 910B / 7L0126-7023

Customer: TRQSS

Document No.:

WI-ENG-PDE-636B

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

2

Page No.:

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PARTS:		1. All parts: Assy parts ; Black tape ; Black corrugated tube Ø7 L=403±4mm (No slit)				JIG:	1.Terminal cover jig										
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS							
1		P2		Table lay-out				<div><div>TABLE LAY-OUT</div><div></div></div> <div><div><b>Safety Instruction</b> Be sure to wear required 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</div><div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div> <td colspan="4">1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools</td>				1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools					
Revision History																	
06/06/23	2	Changed Quality Checkpoint illustration;Inclusion of spot tape				M. Ariola	J. Loterte	C. Villanueva	A. Arañes	Prepared by		Reviewed by		Approved by		Noted by	
04/17/23	1	Document purpose from prelaunch to masspro. Change taping: From VM tube sunprene to wire near terminal to Spot taping (Brown tape). Additional table layout. Improve work procedure due to improvement. Change spot taping from L=200±3mm > 180±3mm to L=120±3mm > 100±3mm. Align quality checkpoints on finished assy parts.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Ariola		J. Loterte		C. Villanueva		A. Arañes	
03/02/23	0	Initial issue				M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Ariola		J. Loterte		C. Villanueva		A. Arañes	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:		March 02, 2023					

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### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

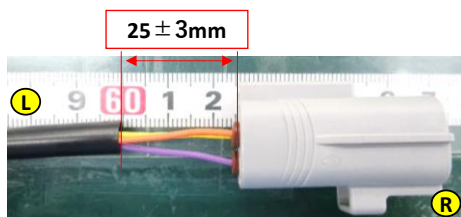
TOOLS/PPE

QUALITY POINTERS

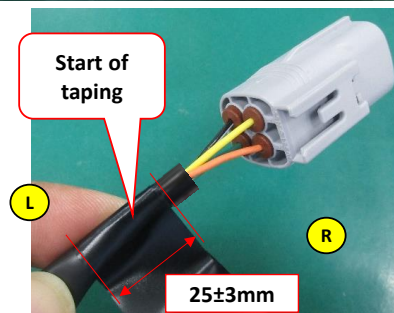
2

P2

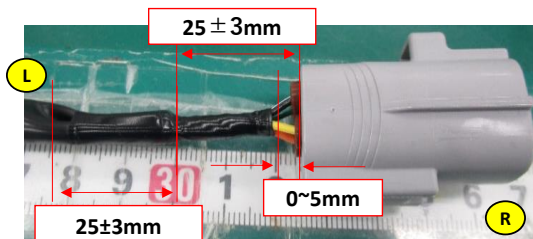
Taping 1  
Black vinyl tube to wire  
near connector



1. Measure from end of Black SV tube (Vinyl) up to edge of connector **25±3mm** using both hands.



2. Get the **Black tape** using right hand then start taping process using both hands.



3. After taping, check the measurement and taping condition.

### MEASURING TAPE



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

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### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

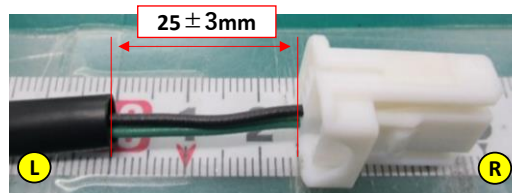
TOOLS/PPE

QUALITY POINTERS

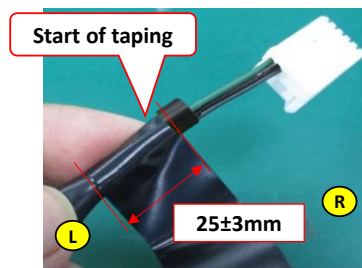
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P2

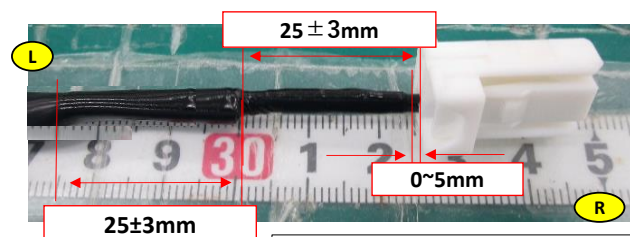
Taping 2  
Black SV tube (Vinyl) to  
wire near Connector



1. Measure from end of Black SV tube (Vinyl) up to edge of connector **25±3mm** using both hands.



2. Get the **Black tape** using right hand then start taping process using both hands.



3. After taping, check the measurement and taping condition.

MEASURING TAPE



**Important reminders/Note/s:**  
**1. Please use calibrated/verified measuring tape when getting the measurement.**

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

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### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

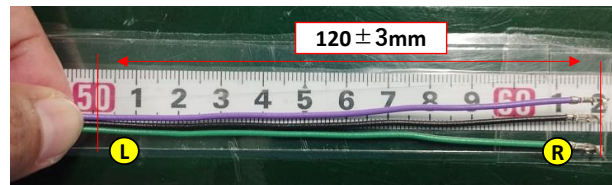
4

P2

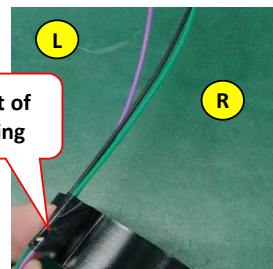
Spot taping



1. Combine the assy parts then align all terminals.



2. Conduct measurement from wires to terminal pointed tip  $120 \pm 3\text{mm}$  using both hands.

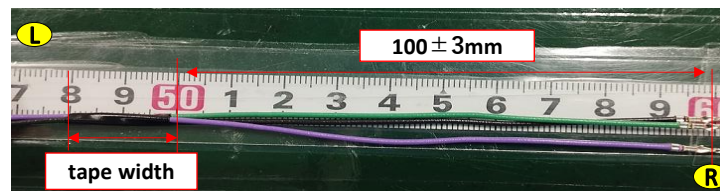


3. Get the **Black tape** using right hand then conduct **2 windings of spot taping** using both hands.

MEASURING TAPE



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



4. After taping, check the measurement and taping condition.

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**5 of 6****PARTS:**

1. Assy parts
2. Black tape

3. Black corrugated tube  $\varnothing 7$  L=403 $\pm$ 4mm (no slit)

**JIG****n/a****NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****5****P2**

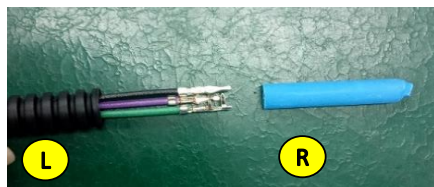
Wire insertion to  
Black corrugated tube  
 $\varnothing 7$  L=403 $\pm$ 4mm  
(No slit)



1. Get the terminal cover jig using right hand and insert wires using left hand.



2. Get the Black corrugated tube (no slit)  $\varnothing 7$  L=403 $\pm$ 4mm using right hand and insert the wires using left hand.



3. After insertion, remove the terminal cover jig using right hand.

**Terminal Cover jig**

1. No wrong usage of parts
2. No damaged rubber seal

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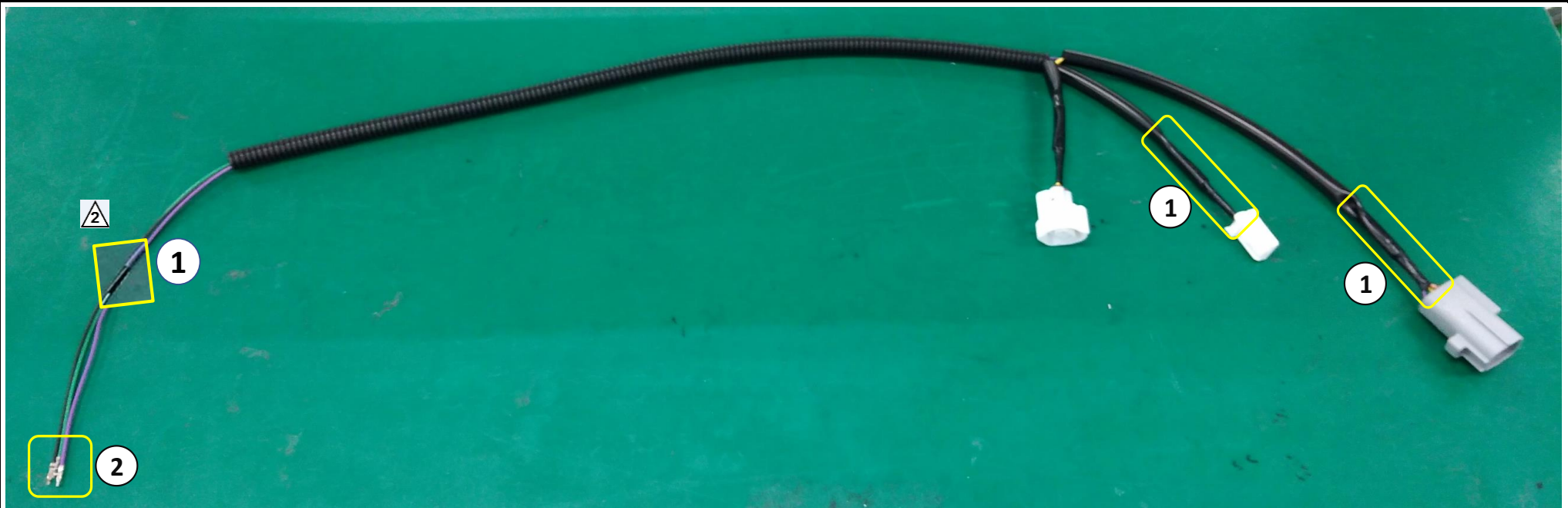
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**PARTS:**

1. Assy parts

**JIG**

n/a

**QUALITY CHECKPOINTS****P2****7L0126-7023****1 No Missing Tape****2 No Deformed Terminal**

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