

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**Product Name/Code: **100B / 7M0594-7020D**Customer: **TRJ**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

**June 22, 2021**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-286C**

Revision No.:

**2**

Page No.:

**1 of 7****PARTS:**

1. Assy parts
2. Black sunprene tube  $\phi 9$  L=93 $\pm$ 3mm

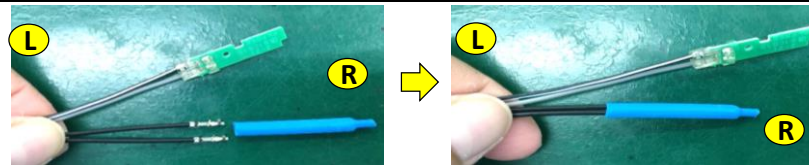
JIG:

1. Terminal cover jig

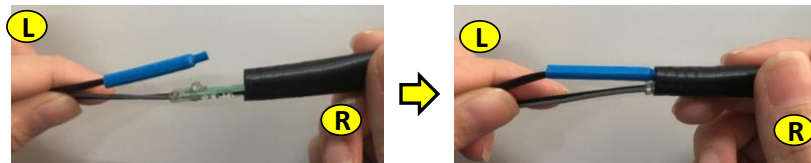
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

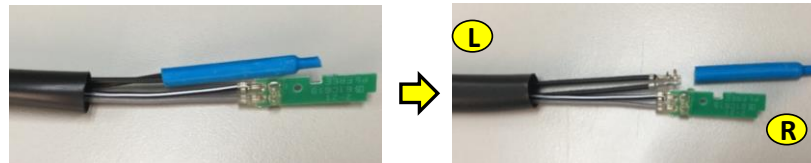
P3

Wire insertion to  
Black sunprene tube  
 $\phi 9$  L=93 $\pm$ 3mm

1. Get the terminal cover jig using right hand then insert the terminal **B/B wires** using left hand.



2. Hold the Black Sunprene tube  $\phi 9$  L=93 $\pm$ 3mm using right hand then Insert first the **hotmelted wires** and then next the **B/B wires** with cover jig using left hand.



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

**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 wrong use of parts
2. No deformed terminal

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/22/21	2	Transfer process owner from Production (WI-PRO-ASY-122C) to Engineering (WI-ENG-PDE-286C). Apply some improvements and update picture in all process.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
03/17/20	1	Include insertion jig/change illustration of coupler	J. Silang	A. Morcozo	O. Merin					
04/10/18	n/a	Previously established as Engineering instruction (EI-ENG-PDE-030). Initial issue	D. Castillo	R. Alcantara	A. Arañes	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **100B / 7M0594-7020D**

Customer: **TRJ**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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### PARTS:

1. Assy parts
2. Black tape

**JIG**

n/a

**NO.**

**PROCESS NAME**

**WORK PROCEDURE/ ILLUSTRATION**

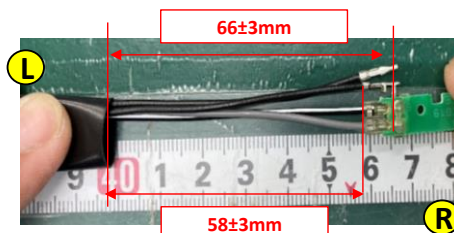
**TOOLS/PPE**

**QUALITY POINTERS**

2

P3

Taping 1  
Black sunprene tube to  
Black COT tube

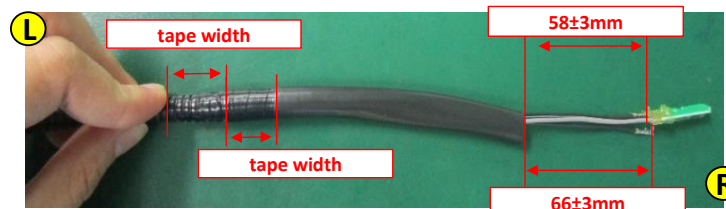


1. Measure from end of the sunprene tube up to the edge of hotmelt **58±3mm** and sunprene tube up to terminal tip **66±3mm**.



2. Hold the sunprene tube using left hand then start taping using right hand.

**Note: Refer to WI-PRO-ASY-001 for taping procedure**



3. After taping, check the dimension, terminal appearance and taping condition.

### MEASURING TAPE



**Note:**  
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 dimension
6. No wrong use of tape

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**PARTS:**

1. Assy parts
2. Black tape

**JIG**

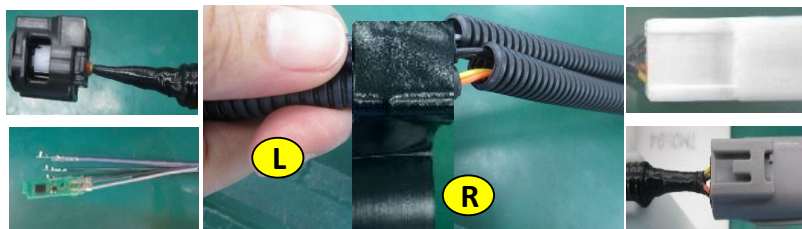
1. T-Taping jig

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

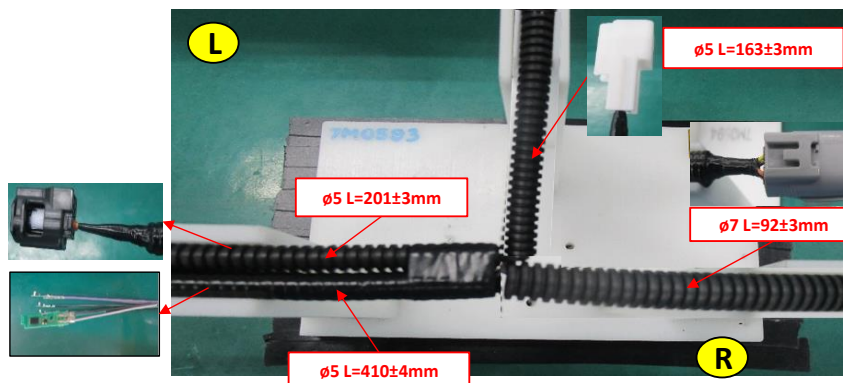
3

P2

T- Taping



1. Align both COT  $\phi 5$ . (Follow the correct orientation of connector). Tape 2 winds using black tape then cut the tape.



2. Arrange the 4 corrugated tube to form inverted T into jig using left and right hand.

**T-TAPING JIG**

1. No flip out tape
2. No tape peeling
3. No loose tape
4. No wrong use of tape
5. No wrong facing of assy parts

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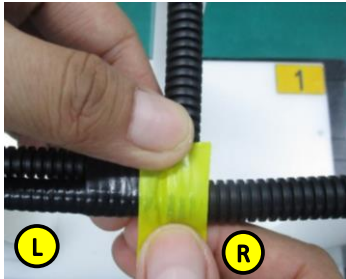
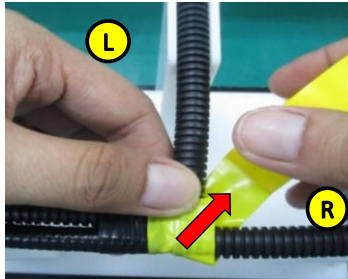
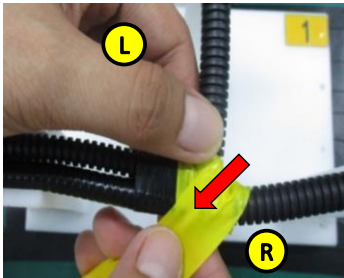
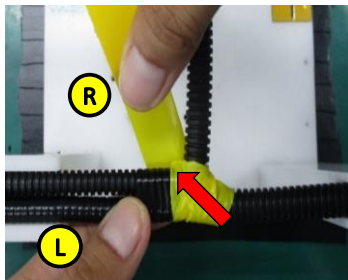


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PARTS:		1. Assy parts 2. Black tape		JIG	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3  T-taping (Continuation)	<div><div></div><div>3. Start taping at the middle to fix the 4 corrugated tubes using right hand.</div><div></div><div>4. Wind the tape from front to back at the right side</div><div></div><div>5. Wind the tape from back to front (cross pattern)</div><div></div><div>6. Wind the tape from front to back at the left side</div></div> <td><div>T-TAPING JIG</div><div></div></td> <td><div>2</div><div>Note: USE <u>YELLOW TAPE</u> FOR EASY VISUALIZATION SHIFTING LINES, BUT ACTUAL SHOULD BE <u>BLACK TAPE</u>.</div><div>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</div></td>		<div>T-TAPING JIG</div> <div></div>	<div>2</div> <div>Note: USE <u>YELLOW TAPE</u> FOR EASY VISUALIZATION SHIFTING LINES, BUT ACTUAL SHOULD BE <u>BLACK TAPE</u>.</div> <div>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</div>

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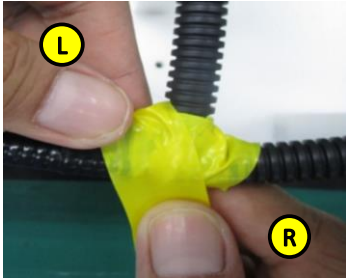
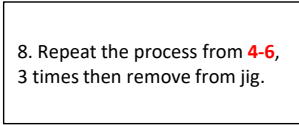
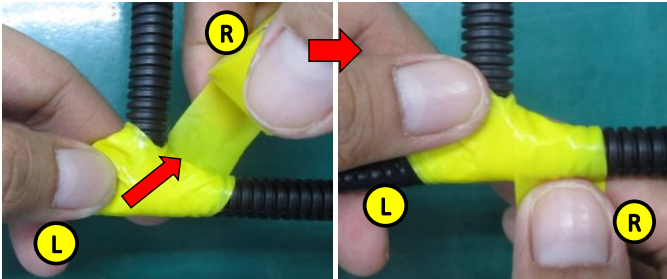
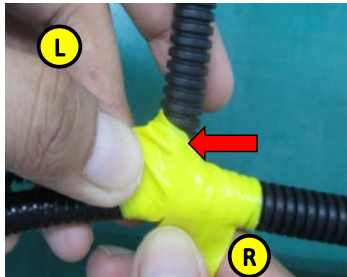
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PARTS:		1. Assy parts 2. Black tape	JIG	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 T-taping (Continuation)	<div><p>7. Wind the tape from back to front (<b>cross pattern</b>)</p></div> <div><p>8. Repeat the process from <b>4-6</b>, 3 times then remove from jig.</p></div> <div><p>9. Tape the right side corrugated tube (<b>3 winds</b>), width must be same as tape (<b>19mm</b>)</p></div> <div><p>10. From the right side, wind the tape <b>2/3 shifting</b> going to center</p></div>	n/a	<div><p><b>Note:</b> <b>USE YELLOW TAPE FOR EASY VISUALIZATION SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</b></p></div> <div><p>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</p></div>

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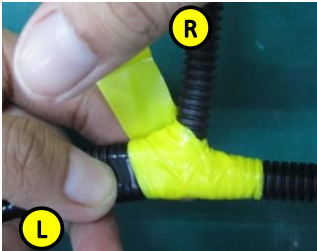
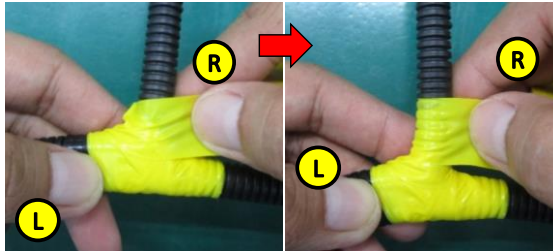
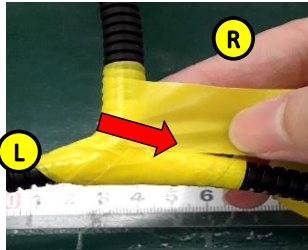
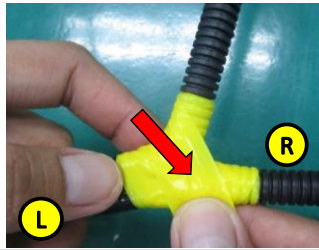
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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3  T-taping (Continuation)	<div><p>11. Wind the tape from front to back side (<b>cross pattern</b>)</p></div> <div><p>12. Tape the top side corrugated tube (<b>3 winds</b>), width must be same as tape (<b>19mm</b>)</p></div> <div><p>13. From the top side, wind the tape <b>2/3 shifting</b> going to center</p></div> <div><p>14. Wind the tape going to front side (<b>cross pattern</b>)</p></div>	n/a	<div><p><b>Note:</b> <b>USE YELLOW TAPE FOR EASY VISUALIZATION SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</b></p></div> <div><p>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</p></div>

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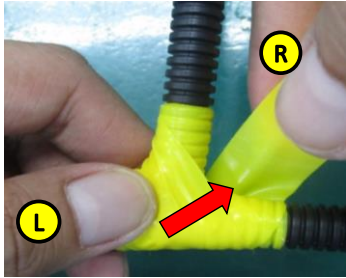
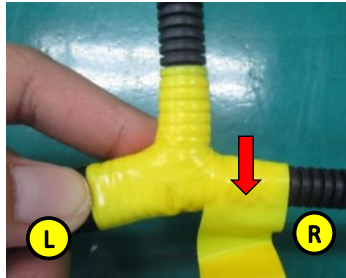
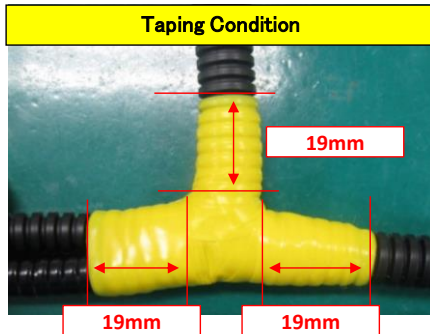

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PARTS:		1. Assy parts 2. Black tape		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3 T-taping (Continuation)	<div><p>15. Wind the tape from front to back side <b>(cross pattern)</b></p></div> <div><p>16. Tape the right side corrugated tube <b>(3 winds)</b>, width must be same as tape <b>(19mm)</b></p></div> <div><p>17. After taping, check the measurement and condition of tape.</p></div>		<p><b>MEASURING TAPE</b></p> 	<p><b>Note:</b> USE <b>YELLOW TAPE</b> FOR EASY VISUALIZATION SHIFTING LINES, BUT ACTUAL SHOULD BE <b>BLACK TAPE.</b></p> <p>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</p> <p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p>

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