

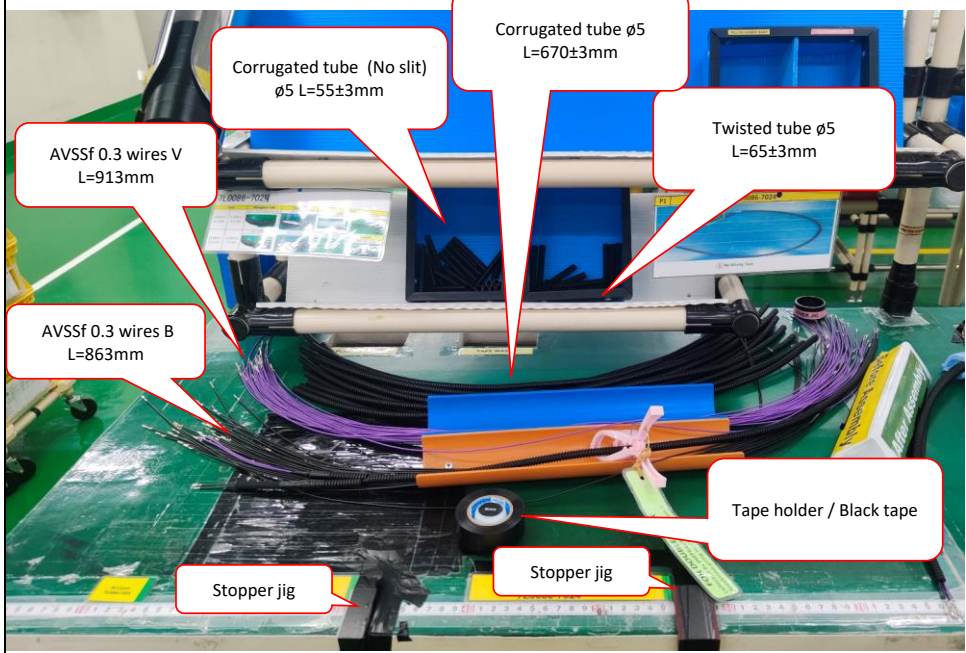





# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	June 1, 2023		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-029A		
Revision No.:	6	Page No.:	1 of 5

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Product Name/Code:	500B / 7L0086-7024	Customer:	TRQSS
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	1. AVSSf 0.3 wires B L=863mm 2. AVSSf 0.3 wires V L=913mm 3. Corrugated tube (No slit) ø5 L=55±3mm 4. Corrugated tube (No slit) ø5 L=670±3mm 5. Twisted tube ø5 L=65±3mm 6. Black tape	JIG	1. Stopper jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out	<p><b>Table Lay-out</b></p> 	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>Document reference/s:</b> 1. Please refer to WI-PRO-CNC-017 for wire and strip length tolerance.</p> <p>1.No missing parts/tools 2.No excess parts/tools</p>

Revision History							Prepared by:	Checked by:	Approved by:	Noted by:
06/01/2023	6	Inclusion of table lay-out and quality check points; improve important reminders/Note/s and document references; improve work procedure and illustration	J. Loterte	C.Villanueva	A.Arañes	n/a				n/a
04/17/2021	5	Remove validity date. Add quality pointers to Taping process. Change winds to windings.	D.Castillo	C.Villanueva	A.Shimamura	A.Arañes				
10/12/2020	4	Remove cycle time.	D.Castillo	R. Peñaloza	A.Shimamura	A.Arañes				
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	November 26, 2019		

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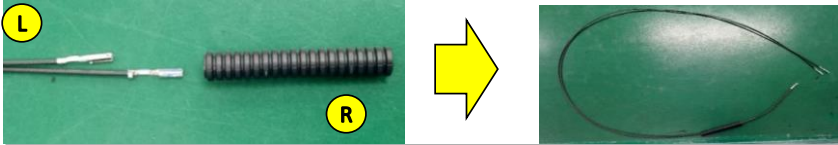
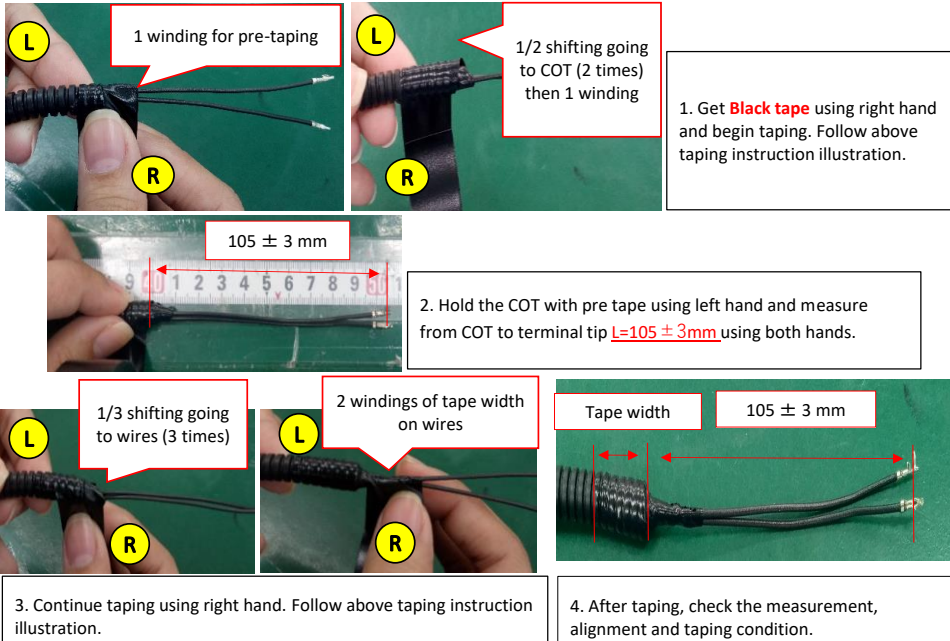

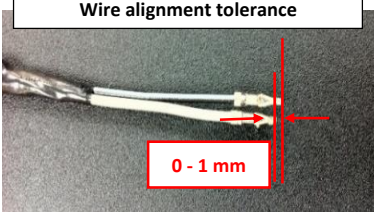
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Process Name/Title: **500B / 7L0086-7024**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. AVSSf 0.3 wires B L=863mm [2 pcs] 2. Corrugated tube (No slit) $\phi 5$ L=55 $\pm$ 3mm 3. Black tape		JIG	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Corrugated tube (No slit) $\phi 5$ L=55 $\pm$ 3mm	 <p>1. Get the Corrugated tube <math>\phi 5</math> L=55<math>\pm</math>3mm using right hand then insert the 2pcs Black wires.</p>		n/a	<p>Document reference/s:</p> <p>1. Please refer to WI-PRO-CNC-017 for wire and strip length tolerance.</p> <p>1. No wrong usage of parts</p>
3	Taping 1 COT to wire near terminal	 <p>1 winding for pre-taping</p> <p>1/2 shifting going to COT (2 times) then 1 winding</p> <p>1. Get Black tape using right hand and begin taping. Follow above taping instruction illustration.</p> <p>2. Hold the COT with pre tape using left hand and measure from COT to terminal tip <math>L=105 \pm 3</math>mm using both hands.</p> <p>1/3 shifting going to wires (3 times)</p> <p>2 windings of tape width on wires</p> <p>Tape width <math>105 \pm 3</math> mm</p> <p>3. Continue taping using right hand. Follow above taping instruction illustration.</p> <p>4. After taping, check the measurement, alignment and taping condition.</p>		<p>MEASURING TAPE</p> 	<p>Wire alignment tolerance</p>  <p>0 - 1 mm</p> <p>1.No flip out tape 2.No peel-off tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</p> <p>Important reminders and Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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## WORK INSTRUCTION

Process Name/Title: TAPING ASSEMBLY PROCESS

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Customer: TRQSS

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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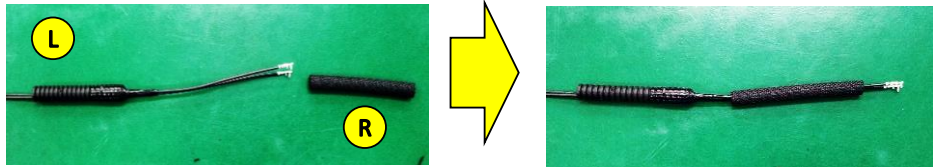
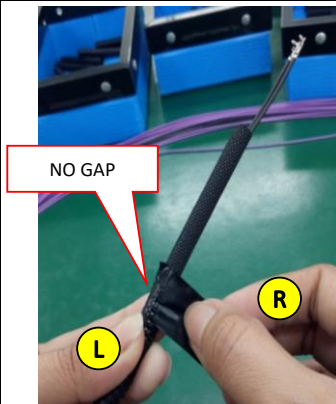
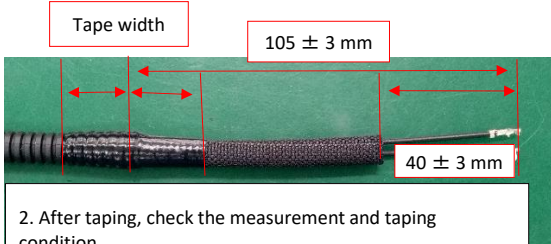

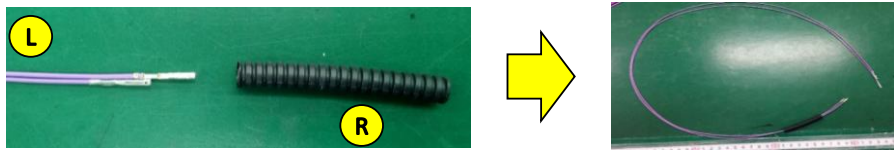
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PARTS:		1. Twisted tube 2420F $\phi 5$ L=65 $\pm$ 3mm 2. Corrugated tube (No slit) $\phi 5$ L=55 $\pm$ 3mm 3. Black tape 4. AVSSf 0.3 wires V L=913mm [2 pcs]			JIG	N/A
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Wire Insertion to Twisted tube $\phi 5$ L=65 $\pm$ 3mm	<div></div> <div>1. Get the twisted tube <math>\phi 5</math> L=65<math>\pm</math>3mm using right hand and insert to black wires using left hand.</div>		N/A	1. No wrong usage of parts
5		Taping 2 Corrugated tube to twisted tube	<div></div> <div>NO GAP</div> <div></div> <div>1. Hold the twisted tube using left hand and get <b>Black tape</b> using right hand and begin taping.</div> <div>2. After taping, check the measurement and taping condition.</div>		<div>MEASURING JIG</div> 	<div><b>Important reminders and Note/s;</b></div> <div>6</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div><b>Document reference/s:</b></div> <div>1. Refer to WI-PRO-ASY-001 for taping procedure.</div> <div>1.No flip out tape 2.No peel-off tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</div>
6		Corrugated tube insertion $\phi 5$ L=55 $\pm$ 3mm (No slit)	<div></div> <div>1. Get the corrugated tube <math>\phi 5</math> L=55<math>\pm</math>3mm using right hand then insert the 2 pcs of Violet wires.</div>		N/A	<div><b>Document reference/s:</b></div> <div>6</div> <div>1. Please refer to WI-PRO-CNC-017 for wire and strip length tolerance.</div> <div>1. No wrong usage of parts</div>

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## WORK INSTRUCTION

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Customer: TRQSS

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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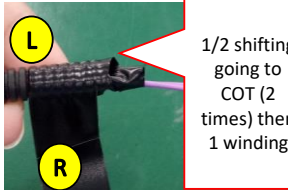
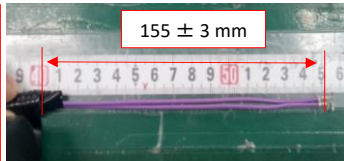

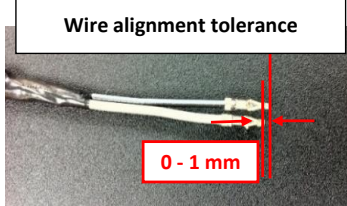


## PARTS:

1. Corrugated tube (No slit)  $\varnothing 5$  L=670 $\pm$ 3mm  
2. Black tape

3. Assy Parts

JIG

N/A

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	Taping 3 Corrugated to wire near terminal	<div><div><p>1 winding for pre-taping</p></div><div><p>1/2 shifting going to COT (2 times) then 1 winding</p></div><div><p>155 ± 3 mm</p></div><div><p>1. Get <b>Black tape</b> using right hand and begin taping. Follow above taping instruction illustration.</p><p>2. Hold the COT with pre tape using left hand and measure from COT to terminal tip <b>L=155 ± 3mm</b> using both hands.</p></div></div>	<div><p>MEASURING JIG</p></div> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div>	<div><p>Important reminders and Note/s: 1. <b>Please use calibrated/verified measuring tape when getting the measurement.</b></p><p>1.No flip out tape 2.No peel-off tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</p></div>	
8		Corrugated tube insertion ø5 L=670±3mm (No slit)	<div><div><p>1. Get the <b>Corrugated tube ø5 L=670±3mm</b> using right hand then insert the Violet and Black wires.</p></div><div></div></div>	N/A	1. No wrong usage of parts	

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PROTOTYPE



PRE-LAUNCH



MASSPRO

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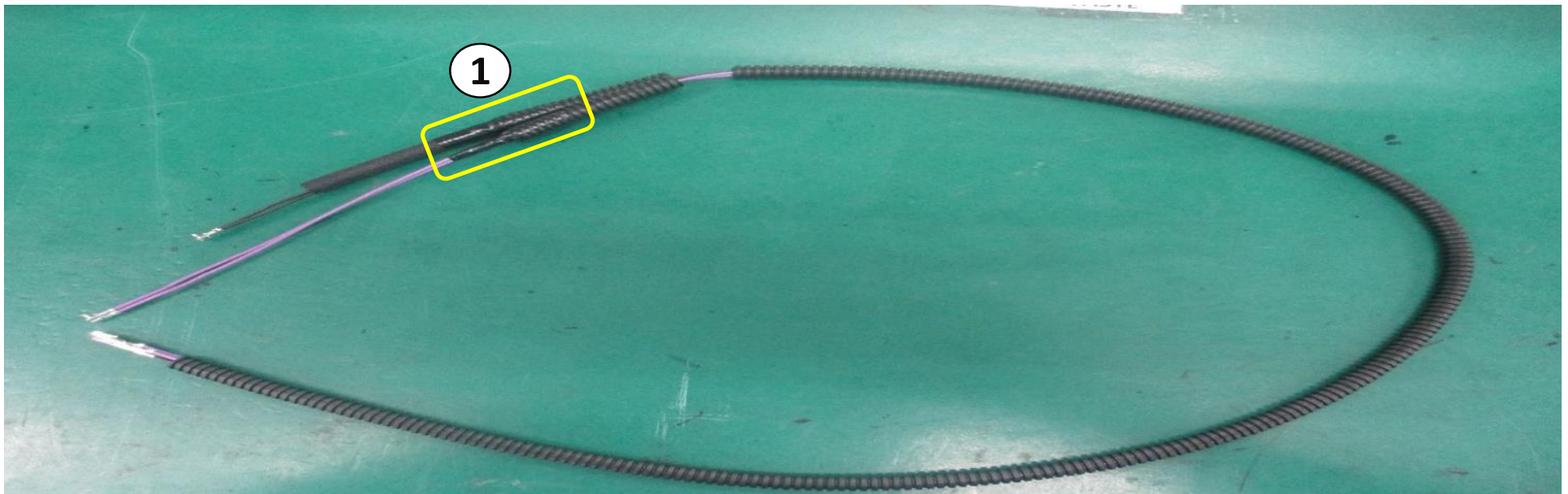
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**PARTS:**

1. Assy parts

**JIG**

N/A

**QUALITY CHECKPOINTS****P1****7L0086-7024****1****No Missing Tape**

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