

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Process Name/Title:

Model Code/Part Number: **096B / A7075D**

Customer:

**TRQSS**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

**October 05, 2022**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-590B**

Revision No.:

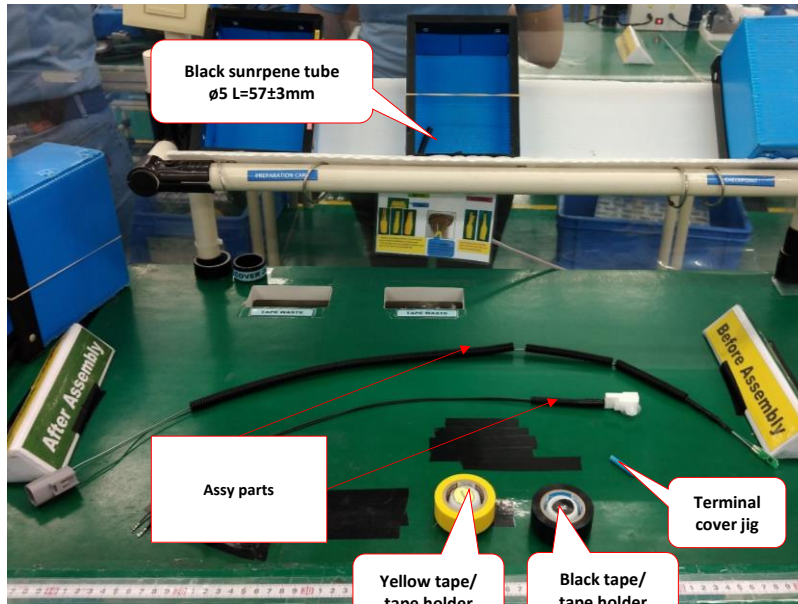
**1**

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**1 of 7****PARTS:**1. Assy parts: Black sunrpene tube  $\varnothing 5$  L=57 $\pm$ 3mm; Black tape; Yellow tape

JIG:

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Table lay-out	<p><b>Table Lay-out</b></p>  <p>Black sunrpene tube <math>\varnothing 5</math> L=57<math>\pm</math>3mm</p> <p>Assy parts</p> <p>Yellow tape/ tape holder</p> <p>Black tape/ tape holder</p> <p>Terminal cover jig</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 workplace 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>	1. No missing parts/tools 2. No excess parts/tools

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Reviewed by	Approved by
10/05/22	1	Change document status from Pre-launch to masspro. Additional: Table-layout (Work illustration). Note and procedure in process no.1 and no.6.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes		M. Catapang	J. Loterte	C. Villanueva	A. Arañes
09/17/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes		M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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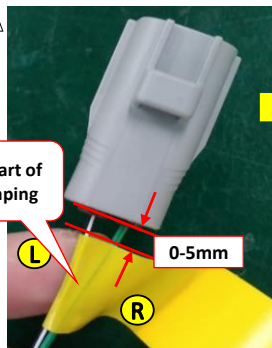
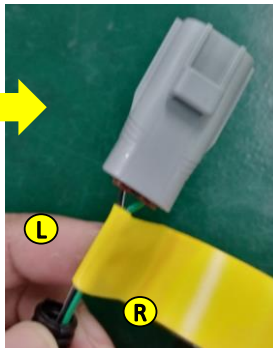
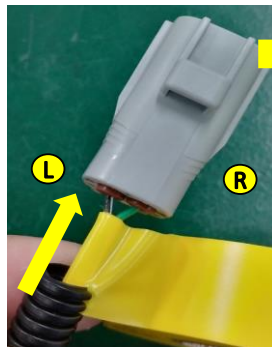


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PARTS:		1. Assy parts 2. Yellow tape		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2  Taping 1 Wire to COT (with slit in 25mm) near connector	<div><div><div><div><div><div>1</div><div></div></div><div></div></div><div><div></div><div></div></div><div><div>1. Hold the COT and wires using left hand, get the Black tape then conduct <b>6 windings</b> of tape using both hands. Do not cut the tape. <b>Note: Attachment of tape on wires must be from 0-5mm.</b></div><div>2. Insert the <b>COT (with slit in 25mm)</b> to tape then push upward until it reach the edge of connector.</div></div></div><div><div>MEASURING TAPE</div></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><div><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b> <b>2. Use <u>YELLOW TAPE</u> only.</b></div></div></div>			

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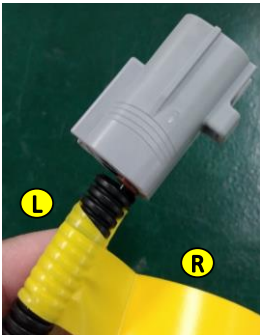
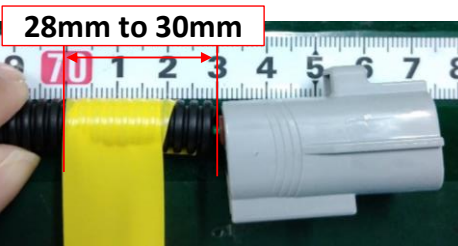
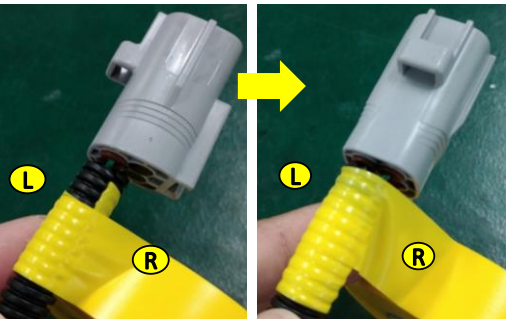
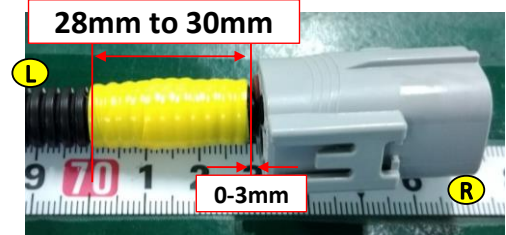

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### PARTS:

1. Assy parts
2. Yellow tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 Wire to COT (with slit in 25mm) near connector (Continuation)	 <p>3. Wind the tape going down to COT to ensure that slit in of COT will covers the tape.</p>  <p>4. Confirm measurement from end of tape up to end of COT <b>28mm to 30mm</b> using both hands.</p>  <p>5. Make <b>2 windings</b> of tape before shifting then make <b>1/3 shifting</b> going to COT until it cover the slit in. Make <b>3 windings</b> of tape before cut.</p>  <p>6. After taping, check the measurement and taping condition.</p>		<ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ol> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please use calibrated/verified measuring tape when getting the measurement.</li><li>2. Use <b>YELLOW TAPE</b> only.</li></ol>

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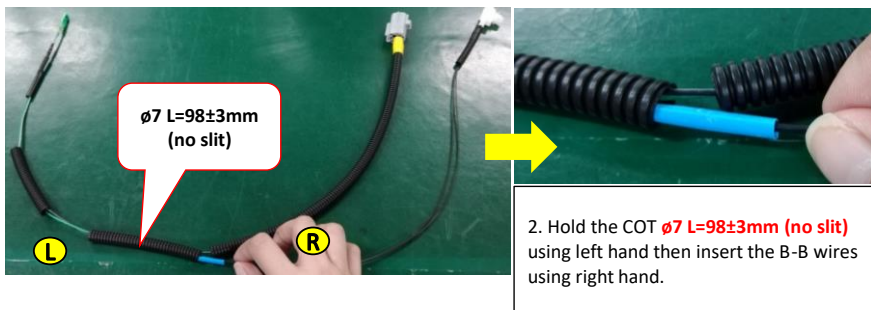
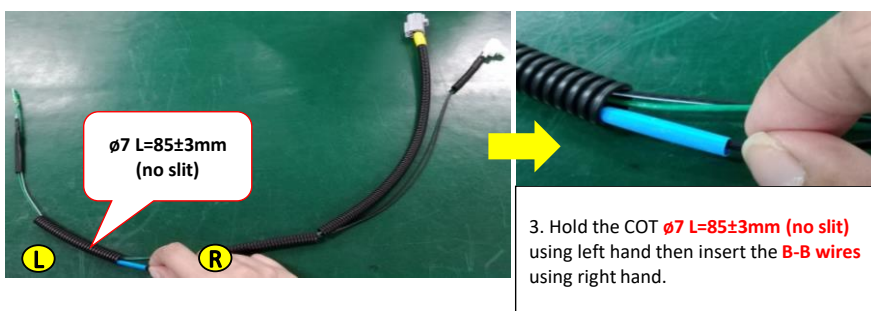


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PARTS:		1. Assy parts			JIG	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Wire insertion to assy parts	<div><div><p>1. Get the terminal cover jig using right hand then insert the <b>B-B wires</b>.</p></div><div><p>2. Hold the COT <math>\phi 7 L=98\pm 3\text{mm}</math> (no slit) using left hand then insert the <b>B-B wires</b> using right hand.</p></div><div><p>3. Hold the COT <math>\phi 7 L=85\pm 3\text{mm}</math> (no slit) using left hand then insert the <b>B-B wires</b> using right hand.</p></div><div><p>4. After insertion, remove the terminal cover jig using right hand.</p></div></div> <div><div>TERMINAL COVER JIG</div></div>		1. No deformed terminal 2. No wrong usage of parts 3. No wrong insertion	

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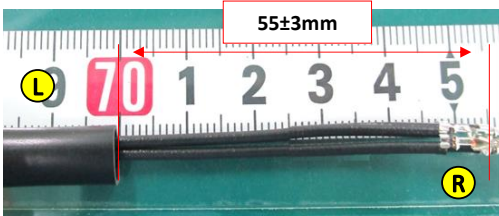

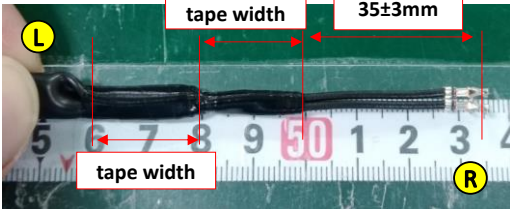

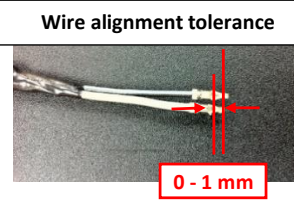
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PARTS:		1. Assy parts 2. Black sunprene tube $\phi 5$ L=57 $\pm$ 3mm 3. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black sunprene tube $\phi 5$ L=57 $\pm$ 3mm	 <p>1. Hold the wires using left hand, get the Black sunprene tube <math>\phi 5</math> L=57<math>\pm</math>3mm using right hand then insert to B-B wires.</p>	n/a	1. No wrong use of parts 2. No wrong insertion
5	P2 Taping 2 Black sunprene tube to wire near terminal	 <p>1. Hold the vinyl tube using left hand, measure from end of vinyl tube up to terminal tip <b>55<math>\pm</math>3mm</b>.</p>  <p>2. Hold the assy parts using left hand, get the <b>Black tape</b> using right hand then start taping process using both hands.</p>  <p>3. After taping, check the measurement, taping condition and wire alignment.</p>	 <p><b>MEASURING TAPE</b></p>	 <p><b>Wire alignment tolerance</b></p> <p>0 - 1 mm</p> <p>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</p> <p><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p>

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2  Taping 3 Black COT to Black sunprene tube ( 2 tubes)	    	 MEASURING TAPE	<ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ol> <b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b>

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P2	Y-Taping	n/a	<p><b>Important reminders/Note/s:</b></p> <ul style="list-style-type: none"><li>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</li><li>2. Please use calibrated/verified measuring tape when getting the measurement.</li></ul> <ul style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ul>

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