

	<b>WORK INSTRUCTION</b>				Effectivity Date:		March 14, 2025	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: <b>PRE-ASSY</b>		Customer: -	Car Model: -	Document No.: <b>WI-ENG-PDE-1151</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		2	Page No.: 1 of 7

<b>PARTS:</b>	1. Based on Part number Comparison Table				JIG:	n/a																																																	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>																																																
1	P1	<div style="text-align: center;"> <table border="1" style="margin: auto; border-collapse: collapse;"> <tr> <th colspan="8" style="background-color: #d3d3d3;">Part number Comparison Table</th> </tr> <tr> <th>No.</th> <th>Part number</th> <th>Wire Color</th> <th>Wire Length</th> <th>SV tube Color</th> <th>SV tube length</th> <th>Tape Color</th> <th>Page No.</th> </tr> <tr> <td style="text-align: center;">1</td> <td style="text-align: center;">75S744-7051</td> <td style="text-align: center;">GR/B</td> <td style="text-align: center;">120mm</td> <td style="text-align: center;">White</td> <td style="text-align: center;">ø3; 71±3mm</td> <td style="text-align: center;">Sky Blue</td> <td style="text-align: center;">Pg. 2-4</td> </tr> <tr> <td style="text-align: center;">2</td> <td style="text-align: center;">75S834-7051</td> <td style="text-align: center;">GR/B</td> <td style="text-align: center;">120mm</td> <td style="text-align: center;">White</td> <td style="text-align: center;">ø3; 71±3mm</td> <td style="text-align: center;">Sky Blue</td> <td style="text-align: center;">Pg. 2-4</td> </tr> <tr> <td style="text-align: center;">3</td> <td style="text-align: center;">75V076-7011</td> <td style="text-align: center;">GR/B</td> <td style="text-align: center;">120mm</td> <td style="text-align: center;">White</td> <td style="text-align: center;">ø3; 71±3mm</td> <td style="text-align: center;">Sky Blue</td> <td style="text-align: center;">Pg. 2-4</td> </tr> <tr> <td style="text-align: center;">2 4</td> <td style="text-align: center;">75V117-7111</td> <td style="text-align: center;">L</td> <td style="text-align: center;">89mm</td> <td style="text-align: center;">Black</td> <td style="text-align: center;">ø3; 25±3mm</td> <td style="text-align: center;">Black</td> <td style="text-align: center;">Pg. 5-7</td> </tr> </table> </div>				Part number Comparison Table								No.	Part number	Wire Color	Wire Length	SV tube Color	SV tube length	Tape Color	Page No.	1	75S744-7051	GR/B	120mm	White	ø3; 71±3mm	Sky Blue	Pg. 2-4	2	75S834-7051	GR/B	120mm	White	ø3; 71±3mm	Sky Blue	Pg. 2-4	3	75V076-7011	GR/B	120mm	White	ø3; 71±3mm	Sky Blue	Pg. 2-4	2 4	75V117-7111	L	89mm	Black	ø3; 25±3mm	Black	Pg. 5-7	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>          Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)       </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <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 style="border: 1px solid red; padding: 5px;"> <b>Alert level</b>          For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.       </div>	<b>Document reference/s:</b> 1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance  1. No deformed terminal 2. No wrong usage of parts
Part number Comparison Table																																																							
No.	Part number	Wire Color	Wire Length	SV tube Color	SV tube length	Tape Color	Page No.																																																
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Revision History						Prepared by	Checked by	Reviewed by	Approved by
03/14/25	2	Inclusion of 75V117-7111 on the Part number Comparison table and Taping assembly process.	D. Castillo	J. Loterte	C. Villanueva				
02/05/25	1	Inclusion of 75V076-7011 on the Part number Comparison table.	M. Ariola	n/a	C. Villanueva				
11/11/24	0	Initial issue. Separate process. Inclusion of common models	D. Castillo	n/a	C. Villanueva				
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	November 11, 2024	

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**WORK INSTRUCTION**

Effectivity Date:

**March 14, 2025**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity Date:

n/a

Model code/Part number:

**PRE-ASSY**

Customer: -

Car Model: -

Document No.:

**WI-ENG-PDE-1151**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

2

Page No.:

2 of 7

**PARTS:**

1. Based on Part number Comparison Table

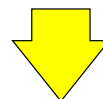
JIG:

n/a

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

2

P1

Wire Insertion to  
SV tube (Vinyl)

1. Get the **wire** using left hand. Get 1 pc of **SV tube (Vinyl)** using right hand then insert the **wire**.

1. No deformed terminal  
2. No wrong usage of parts

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

March 14, 2025

Process Name/Title:

Model code/Part number:

PRE-ASSY

Customer: -

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n/a

Document No.:

WI-ENG-PDE-1151

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

2

Page No.:

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### PARTS:

1. Assy parts
2. Sky Blue

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

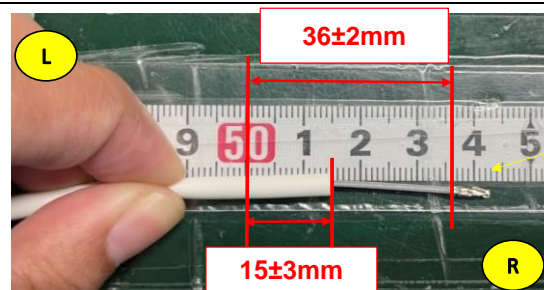
TOOLS/PPE

QUALITY POINTERS

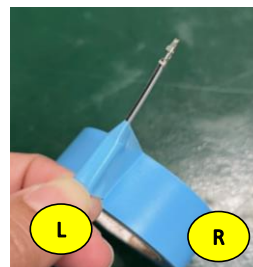
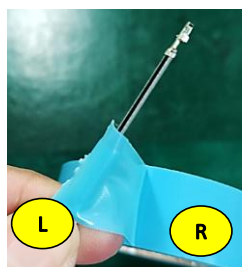
3

P1

Taping 1  
SV tube (Vinyl) to Wire  
near terminal

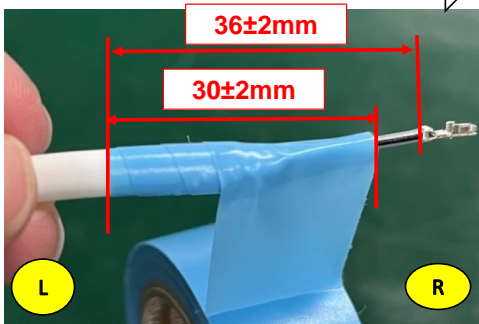


1. Position the end of White SV tube (Vinyl) to **15±3mm**. Then hold the wire and position the terminal to **36±2mm** using both hands.  
*Note: Follow the above illustration. Do not hold the terminal.*



2. Get the Sky Blue tape, position the tape to White SV tube. Make **1 wind** only using both hands.

**WRONG POSITION OF  
END TAPE**

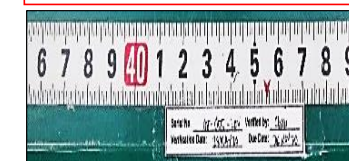


3. Make 1/3 shifting up to wire. Measure from end of tape up to terminal **36±2mm** and end of tape up to end of tape **30±3mm**. Then make **2 windings** using both hands.

*Note: Last wind must be slanted and end tape must be within the tape or not overlapped to first wind.*

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
7. No deformed terminal
8. No insufficient tape

### MEASURING TAPE




### Important reminders and note/s;

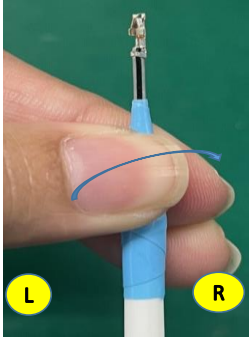
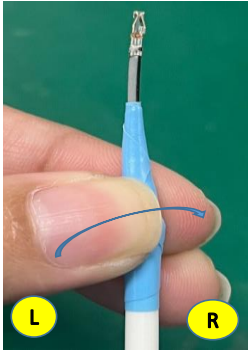
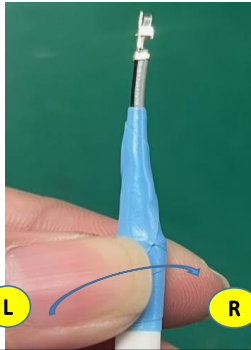
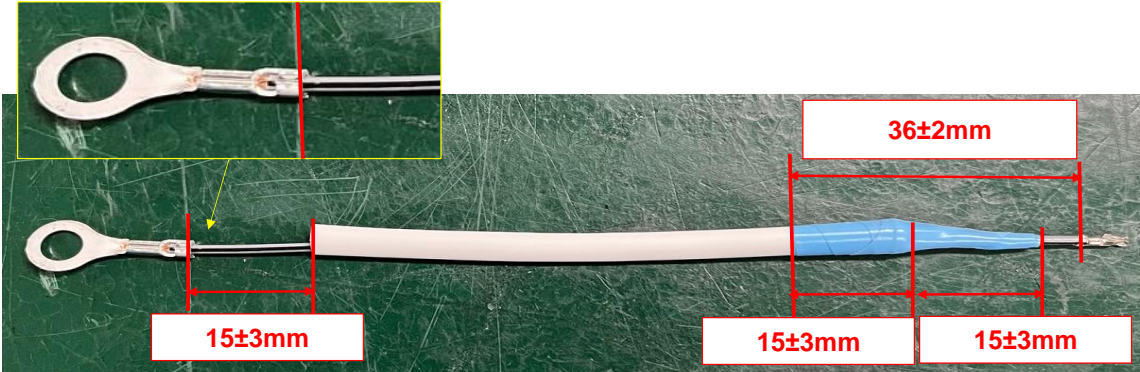

1. **USE SKY BLUE TAPE only.**
2. **Please use calibrated/verified measuring tape when getting the measurement.**

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	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>PRE-ASSY</b>		Customer: -	Car Model: -	Document No.:	<b>WI-ENG-PDE-1151</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	4 of 7


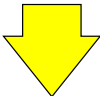

<b>PARTS:</b>		1. Assy parts 2. Sky Blue		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
3	P1 Taping 1 SV tube (Vinyl) to Wire near terminal (Continuation)	<div><p>4. Conduct proper pressing of end tape using left hand (<b>top part</b>).</p></div> <div><p>5. Conduct proper pressing of end tape using left hand (<b>Middle part</b>).</p></div> <div><p>6. Conduct proper pressing of end tape using left hand (<b>bottom part</b>).</p></div> <div><p>7. After taping, check the dimension, terminal condition and taping condition.</p></div>		<div><b>MEASURING TAPE</b> </div> <div><b>Important reminders and note/s;</b>  <b>1. USE SKY BLUE TAPE only.</b>  <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b></div>	

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	5 of 7

<b>PARTS:</b>	1. Based on Part number Comparison Table			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
4	P1 <div>2</div> Wire Insertion to SV tube (Vinyl)	<div>  <div>1. Get the <b>wire</b> using left hand. Get 1 pc of <b>SV tube (Vinyl)</b> using right hand then insert the <b>wire</b>.</div></div> <div>1. No deformed terminal 2. No wrong usage of parts</div>			

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## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

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Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

2

Page No.:

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## PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

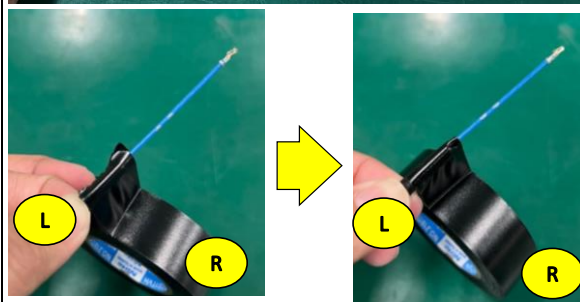
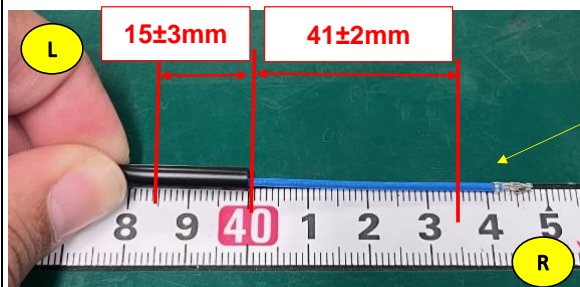
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

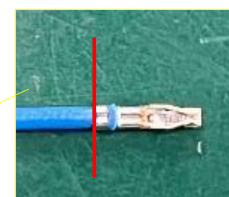
QUALITY POINTERS

5

P1

SV tube (Vinyl) to Wire  
near terminal

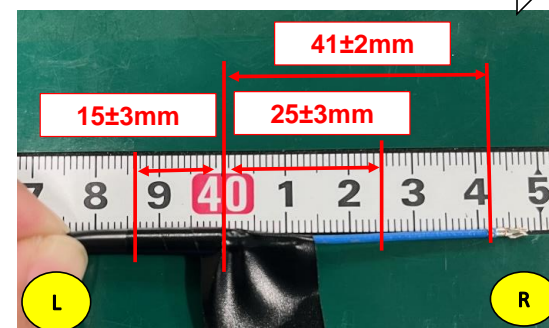
2. Get the Black tape, position the tape to Black SV tube. Make **1 wind** only using both hands.



1. Measure Black SV tube (Vinyl) up to terminal **41±2mm**. Then hold the wire and position the tape to **15±3mm** using both hands.

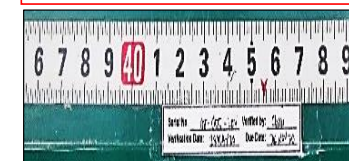
*Note: Follow the above illustration. Do not hold the terminal.*

taping direction



3. Make 1/3 shifting up to wire. Measure from tube up to terminal **41±2mm** and tube up to end of tape **25±3mm**. Then make **2 windings** using both hands.

## MEASURING TAPE




## Important reminders and note/s;

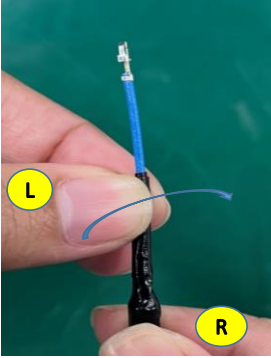
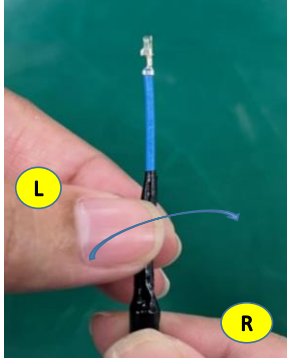
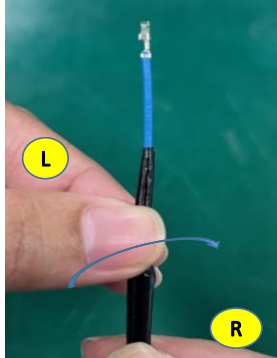
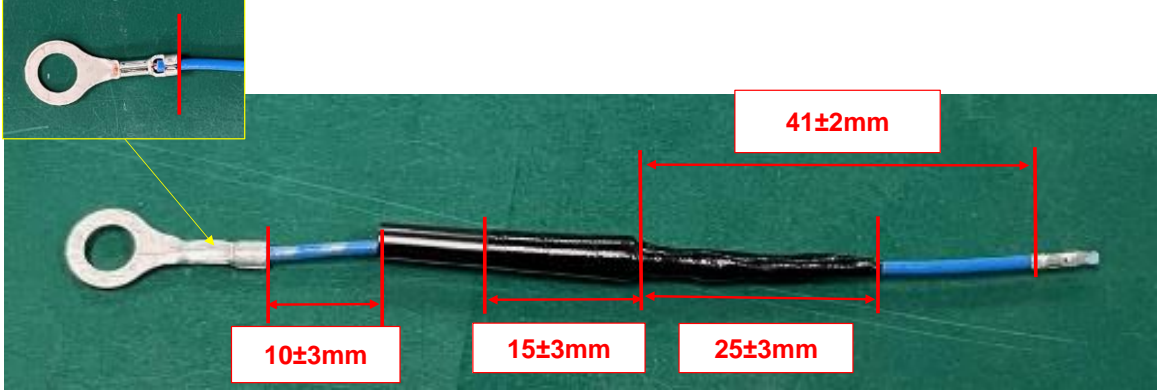

1. **USE BLACK TAPE only.**
2. **Please use calibrated/verified measuring tape when getting the measurement.**

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	7 of 7

<b>PARTS:</b>	1. Assy parts 2. Black tape			JIG:	n/a		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
5	P1 SV tube (Vinyl) to Wire near terminal (Continuation)	<div><p>4. Conduct proper pressing of end tape using left hand (<b>top part</b>).</p></div> <div><p>5. Conduct proper pressing of end tape using left hand (<b>Middle part</b>).</p></div> <div><p>6. Conduct proper pressing of end tape using left hand (<b>bottom part</b>).</p></div> <div><p>7. After taping, check the dimension, terminal condition and taping condition.</p></div>				<div><b>MEASURING TAPE</b></div>  <p><b>Important reminders and note/s;</b></p> <p>1. <b>USE BLACK TAPE only.</b></p> <p>2. <b>Please use calibrated/verified measuring tape when getting the measurement.</b></p>	

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