

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 12, 2022

Model Code/Product Number:

749W / 7H0337W7020B

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-489C

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

1 of 5

PARTS:

1. All parts; Assy parts; Clamp 82711-52090 (W); Black Tape

JIG

1. Temporary Clamp Assembly jig

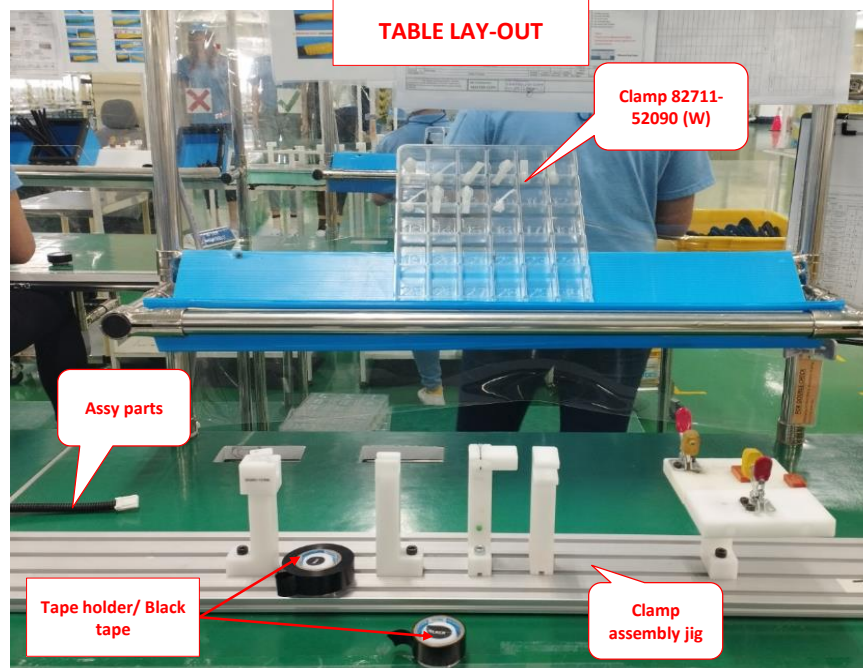
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P3

Table Lay-out

1

**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 missing parts/tools.
2. No excess parts/tools.

Revision History

Prepared by

Reviewed by

Approved by

Noted by

05/12/22

1

Change from Pre-Launch to Masspro. Additional table Lay-out.

M.Ariola

J. Loterte

C.Villanueva

A.Arañes

04/26/22

0

Initial Issue.

M.Ariola

J. Loterte

C.Villanueva

A.Arañes

Eff.Date

Rev.No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date

April 26, 2022

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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

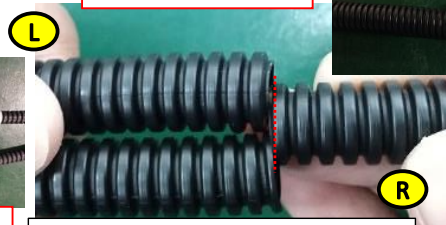
P3

Y-Taping

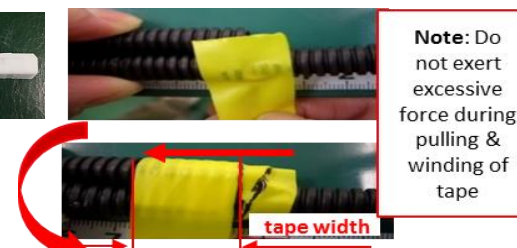
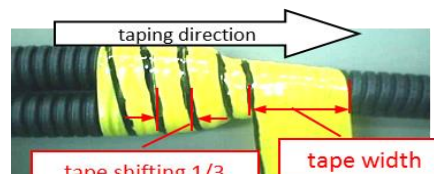


Y-Taping orientation

No wide interval



1. Fix the corrugated tube .



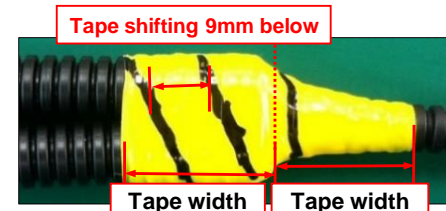
Note: Do not exert excessive force during pulling & winding of tape

2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be **tape width**.

3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be **tape width**.



4. Winding the tape backward 1/2 shifting.



5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.

NOTE:
USED YELLOW TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL SHOULD BE BLACK.

Note:
Please use calibrated/verified measuring tape when getting the measurement.

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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3 of 5**PARTS:**

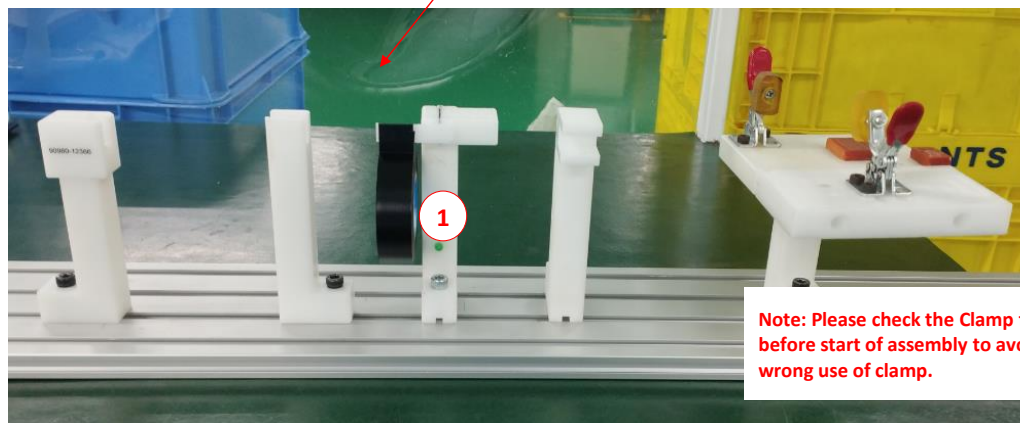
- 1.Clamp 82711-52090 (W)
2. Black tape

JIG

- 1.Temporary Assembly jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****3****P3**

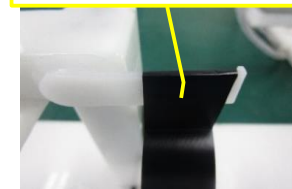
Clamp setting

**82711-52090 (W)**

1. Get 1pc. of clamp **82711-52090 (W)** using right hand and set to clamp location **1** using both hands.

2. Initially attach **Black tape** to clamp location **1** using both hands.

One side tape under clamp



1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

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PARTS:

1. Assy parts.
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1. Temporary Clamp Assembly jig

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PROCESS NAME

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TOOLS/PPE

QUALITY POINTERS

4

P3

Clamp Assembly



1. Hold the tape on clamp location **1**, make **3 windings** of tape then cut the tape using both hands.

2. Conduct **POINT CHECKING** before removing the harness from jig.

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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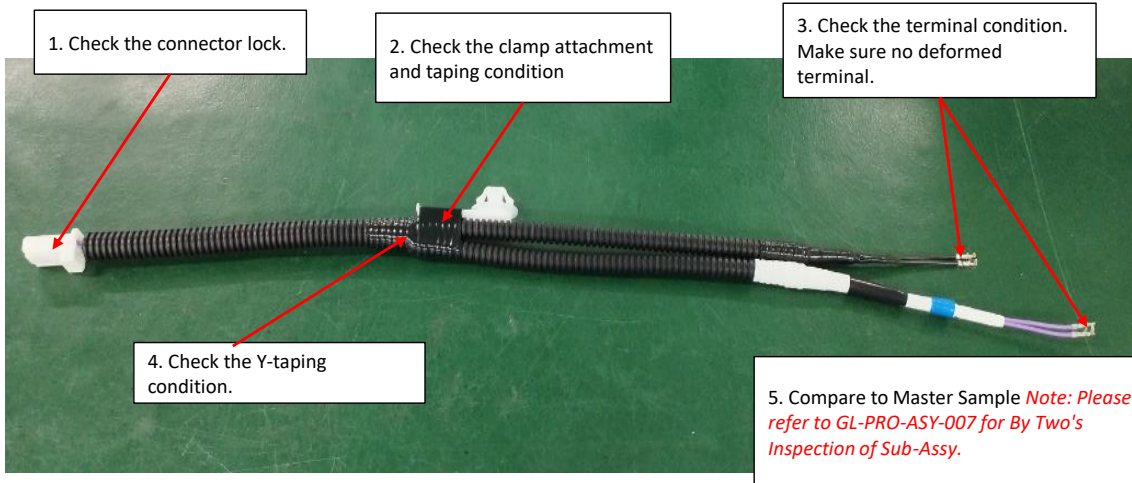
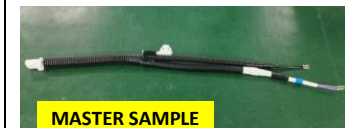
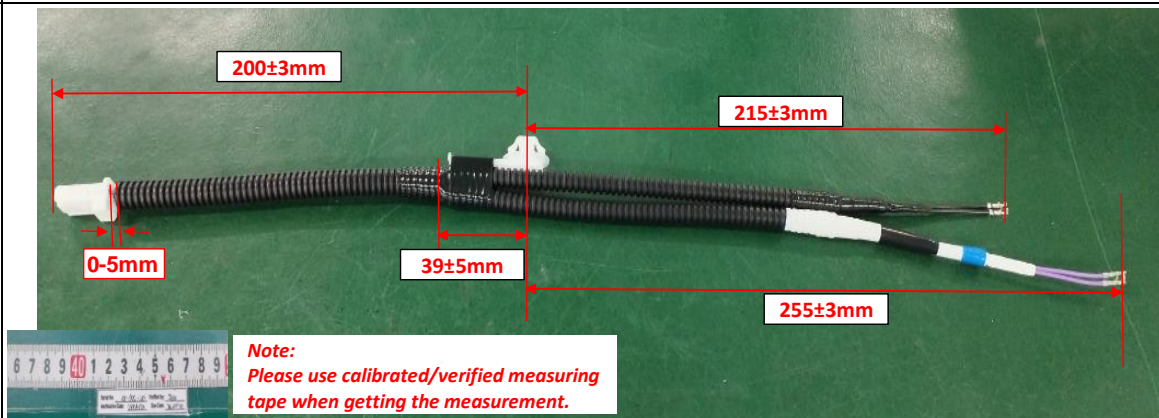
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NO.	PROCESS NAME	WORK PROCEDURE/ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P3	Visual/ By two's inspection			<div>MASTER SAMPLE</div> 
6		Measurement			<div>NOTE: FOR HATSUNOMO OWARIMONO</div> 1. No wrong Dimension

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