



WORK INSTRUCTION

Process Name/Title: TAPING ASSEMBLY PROCESS

Effectivity Date:

May 06, 2022

Model Code/Part Number: 715W / 7H0421W7020

Customer: NBS

Validity Date:

n/a

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-516

Revision No.:

1

Page No.:

1 of 6

PARTS:

1. All Parts; Pre-assy parts from Offline assembly; Black corrugated tube $\phi 5$ L=36 \pm 3mm (w/slit L=25 \pm 5mm); Black vinyl tube $\phi 5$ L=38 \pm 3mm; Black tape; Yellow tape.

JIG:

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	1. No missing parts/tools. 2. No excess parts/tools.

Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
05/06/22	1	Change from Pre-Launch to Masspro. Additional Table Lay-out.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
05/04/22	0	Issue.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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Revision No.:

1

Page No.:

2 of 6

PARTS:		1. Pre-assy parts from Offline assembly 2. Black corrugated tube $\varnothing 5$, L=36 \pm 3mm (w/slit L=25 \pm 5mm) 3. Black vinyl tube $\varnothing 5$ L=38 \pm 3mm	JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black corrugated tube $\varnothing 5$, L=36 \pm 3mm (w/slit L=25 \pm 5mm)	 1. Get the terminal cover jig using right hand and insert the B-B wires using left hand.  2. Get the Black corrugated tube $\varnothing 5$, L=36\pm3mm (w/slit L=25\pm5mm) using right hand and insert the wires using left hand.  3. Remove the terminal cover jig after insertion using right hand.	 TERMINAL COVER JIG	1. No wrong usage of parts 2. No deformed terminal
3	Wire insertion to Black vinyl tube $\varnothing 5$ L=38 \pm 3mm	 1. Get the Black vinyl tube $\varnothing 5$ L=38\pm3mm using right hand then insert the B-B wires using left hand. 	n/a	1. No wrong usage of parts 2. No deformed terminal

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Page No.:

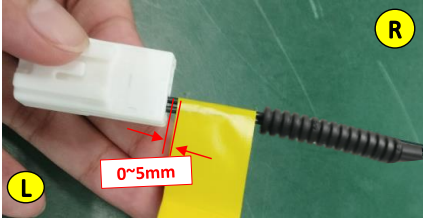

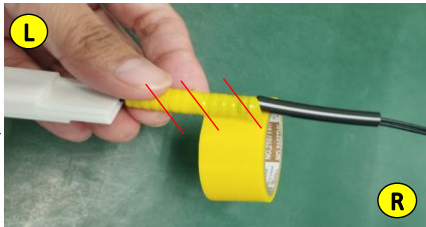
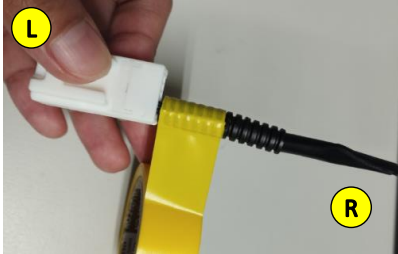

3 of 6

PARTS:

1. Assy parts
2. Yellow tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 1 From wire near connector to corrugated tube and from corrugated tube to vinyl tube	<div><p>1. Hold the connector using left hand and attach the Yellow tape on wires using right hand (<i>see picture for illustration</i>) then make 3 winds, do not cut the tape. Note: Attachment of tape to wire must be from 0~5mm.</p><p>2. After taping, insert the COT w/slit into Yellow tape using right hand.</p><div></div><p>3. After insertion, conduct 2x winding of tape then make 1/2 shifting going to right side until it covers the COT with slit.</p></div>	<p>MEASURING TAPE</p> 	<ol style="list-style-type: none">1. No loose tape2. No peel-off tape3. No flip-out tape4. No wrong use of tape5. No wrong dimension <p>Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p>

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Page No.:

4 of 6

PARTS:

1. Assy parts
2. Yellow tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

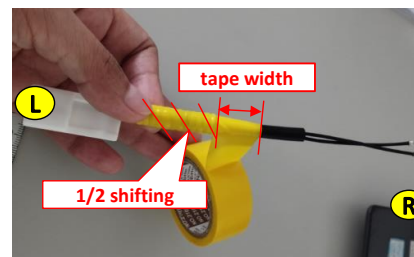
TOOLS/PPE

QUALITY POINTERS

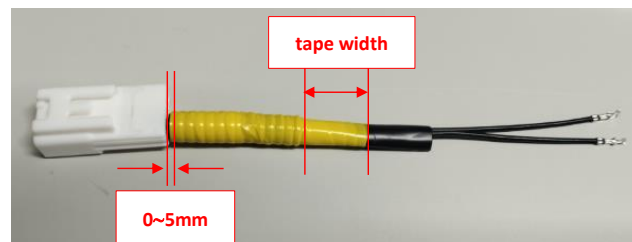
4

P1

Taping 1
From wire near connector
to corrugated tube and from
corrugated tube to vinyl
tube
(continuation)



4. Fix the vinyl tube to COT and continue the taping process using both hands. Make **3 winds** then cut the tape.



5. After taping, check measurement, taping condition and wire alignment.

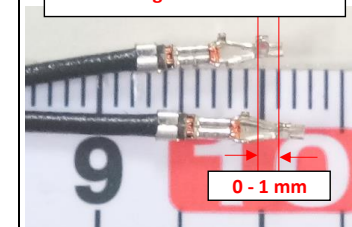
MEASURING TAPE



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

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape

Wire alignment tolerance



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Revision No.:

1

Page No.:

5 of 6

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

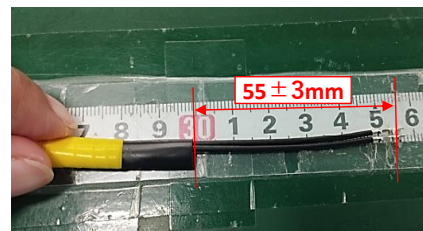
TOOLS/PPE

QUALITY POINTERS

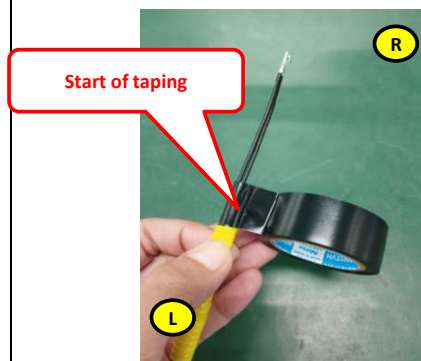
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P1

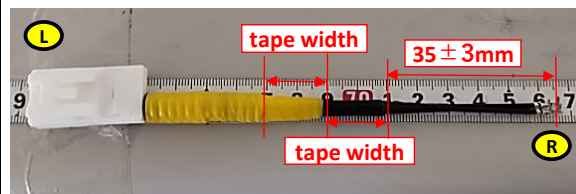
Taping 2
Black Vinyl tube to wire
near terminal



2. Measure the end of vinyl tube up to the terminal pointed tip **55mm** using both hands



1. Get the **Black tape**, hold the Black vinyl tube ($\phi 5 L=38 \pm 3mm$) using left hand then fold the vinyl tube start taping process using both hands.
Note: Please refer to WI-PRO-ASY-001 for taping procedure.



2. After taping, check the measurement, terminal appearance and taping condition.

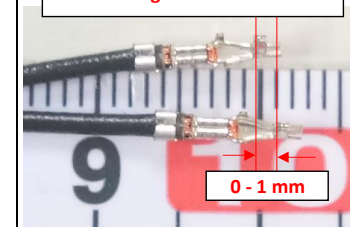
MEASURING TAPE



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

Wire alignment tolerance



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6 of 6**PARTS:**

n/a

JIG

n/a

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

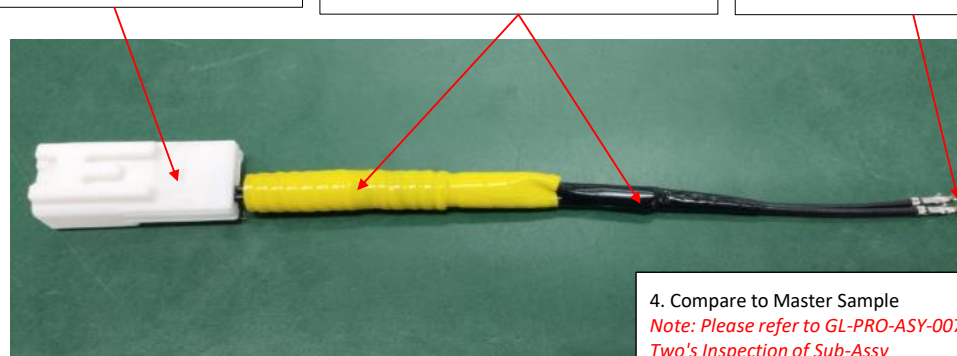
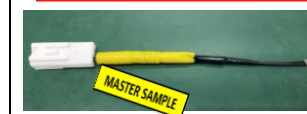
6

P1

Visual/By Two's inspection

1. Check the connector lock.

2. Check the taping condition.

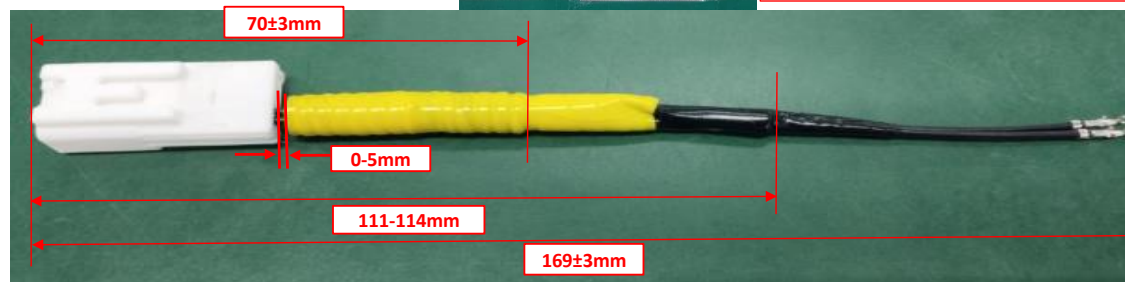
3. Check the terminal appearance.
Make sure no deformed terminal.**MASTER SAMPLE**

7

Measurement

MEASURING TAPE

Note:

Please use calibrated/verified measuring
tape when getting the measurement.**NOTE: FOR HATSUMONO AND
OWARIMONO**

1. No wrong dimension

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