

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**Product Name/Code: **970A / 17J711-7051P** Customer: **NBC**Purpose: ☐ PROTOTYPE ☒ PRE-LAUNCH ☐ MASSPRO

Effectivity Date:

**August 12, 2021**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-299F**

Revision No.:

**0**

Page No.:

**1 of 4****PARTS:**  
1. Assy parts  
2. Black TESA Tape No 51036

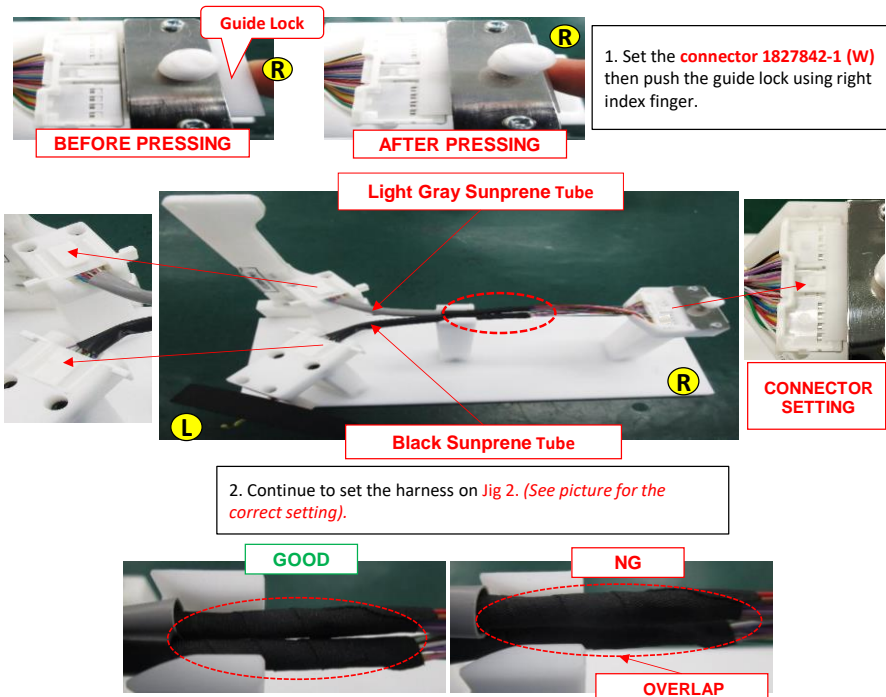
JIG:

1. Taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
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1

P6

Taping 3  
Wire taping (Tesa)**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 wrong setting of harness
2. No wrong orientation of connector

## Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
08/12/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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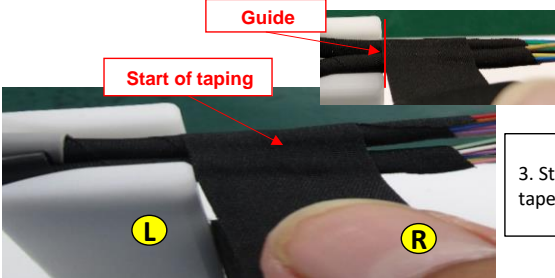
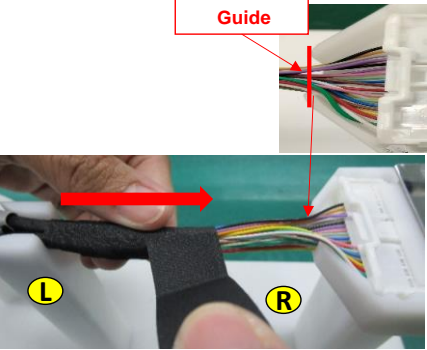
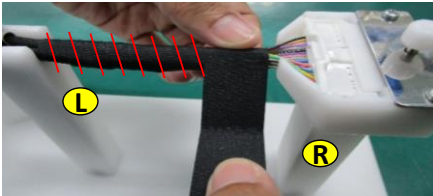
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**PARTS:**

1. Assy parts

**JIG**

1. Taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P6 Taping 3 Wire taping (Tesa) (Continuation)	   <p>3. Start taping using guide <b>2 windings</b> of tape.</p> <p>4. Make <b>7~8 windings</b> from pre-tape going to right side until it reach the guide near connector. <b>DO NOT PULL THE TAPE TOO TIGHT DURING TAPING TO AVOID STRESS ON WIRES.</b></p> <p>5. Once it reaches the guide, make <b>2 windings</b> of tape. <b>DO NOT PULL THE TAPE TOO TIGHT DURING TAPING TO AVOID STRESS ON WIRES.</b></p>	n/a	1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend wire 6. No NG of end tape

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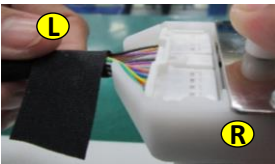
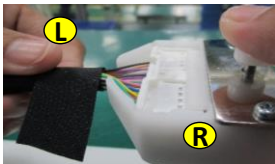
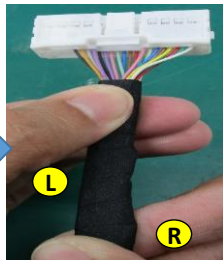
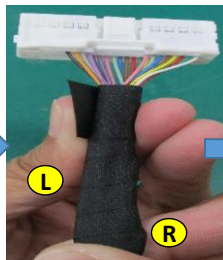
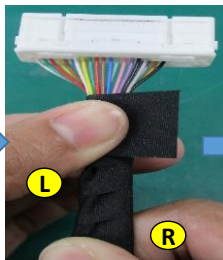
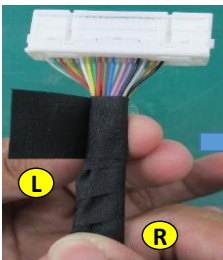

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#### PARTS:

1. Assy parts

#### JIG

1. Taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P6 Taping 3 Wire taping (Tesa) (Continuation)	<div><p>6. Cut the tape using provided cutter only using both hands.</p></div> <div><p>BEFORE PRESSING</p><p>AFTER PRESSING</p><p>7. Hold the assy parts then press the lock button using right thumb. Remove the harness from jig.</p></div> <div><p>8. Press the end tape using left hand. Do not touch the adhesive</p></div>	 <p>Use only this cutter</p>	<ol style="list-style-type: none"><li>1. No loose tape</li><li>2. No excessive tape winding</li><li>3. No damage on parts</li><li>4. No peel off tape</li><li>5. No bend wire</li><li>6. No NG of end tape</li></ol>

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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P6

Taping 3  
Wire taping (Tesa)  
(Continuation)



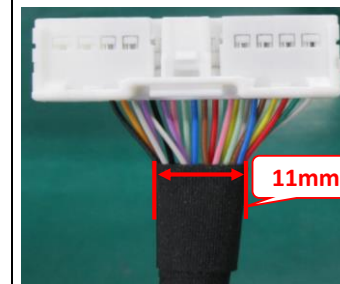
8. After taping, check the alignment and condition of tape.

9. Proceed to **Continuity checking**, refer to **WI-ENG-PDE-308** if encountered problem, refer to **Treatment on Levercon continuity checker NG WI-ENG-PDE-001**.

10. Refer to **WI-ENG-PDE-309 End Tape Pressing**.

11. Refer to **IS-ENG-PDE-002 17J711-7051P Inspection Guide**.

n/a



1. No loose tape
2. No excessive tape winding
3. No damage on parts
4. No peel off tape
5. No bend Wire

**Note:**  
Refer to Work instruction of  
Continuity checking, End Tape  
Pressing and Inspection Guide for  
their separate cycle time.

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