

	WORK INSTRUCTION				Effectivity Date:		May 12, 2022	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model Code/Product Number: 749W / 7H0337W7020B		Customer: NBS		Document No.: WI-ENG-PDE-489B	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.: 1 of 5

PARTS:	1. All parts; (Assy parts; Black Corrugated tube Ø5 L=174±3mm; Black Vinyl Tube Ø5 L=63±3mm; White Tape; Blue tape (10mm))	JIG	1. Terminal cover jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Table Lay-out	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px; text-align: center;">TABLE LAY-OUT</div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 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 dashed red; padding: 5px;"> 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								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	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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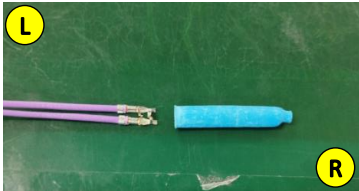




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PARTS:	1. Assy Parts. 2. Black Corrugated tube Ø5 L=174±3mm 3. Black Vinyl Tube Ø5 L=63±3mm			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	P2 Wire Insertion to Black Corrugated tube Ø5 L=174±3mm (No Slit)	<div><p>1. Get the terminal cover jig using right hand then insert the V-V wires using left hand.</p></div> <div><p>2. Get the Black COT Ø5 L=174±3mm using right hand and insert V-V wires using left hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>	<div>Terminal cover Jig</div> 	1. No wrong Insertion 2. No deformed terminal.	
3		<div><p>1. Get the Black Vinyl Tube Ø5 L=63±3mm using right hand and insert V-V wires using left hand.</p></div>	n/a		

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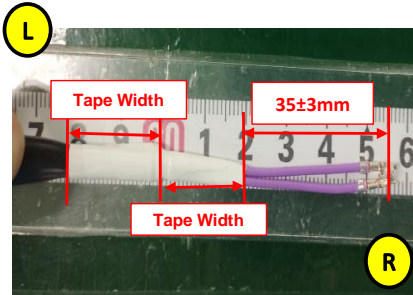
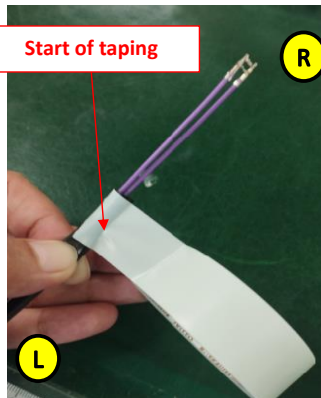

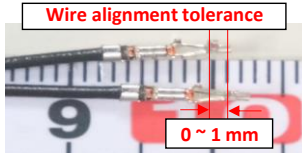
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PARTS:		1. Assy parts 2. White tape		JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Taping 1 Black Vinyl tube to Wire near terminal	<div><div><p>55±3mm</p></div><div><p>1. Measure the end of the Viny tube up to the end of the terminal pointed tip 55mm using both hands.</p></div><div><p>Tape Width</p><p>35±3mm</p><p>Tape Width</p></div></div> <div><div><p>Start of taping</p></div><div><p>2. Get Black tape, hold the vinyl tube ($\phi 5$ L=22±3mm) using left hand then fold the vinyl tube and start taping using right hand. <i>Refer to WI-PRO-ASY-001 for taping procedure</i></p></div><div><p>3. After taping, check the measurement, alignment and tape condition.</p></div></div>	<div><p>MEASURING TAPE</p></div>	<div><p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p></div> <div><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></div> <div><p>Wire alignment tolerance</p><p>0 ~ 1 mm</p></div>

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



0 ~ 1 mm

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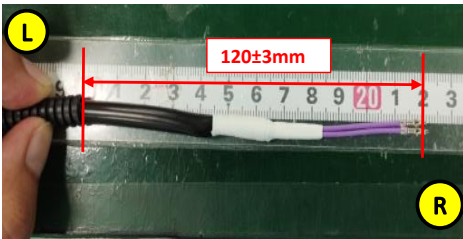
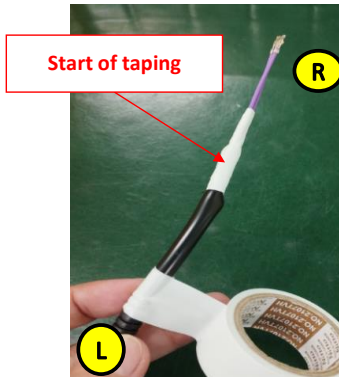
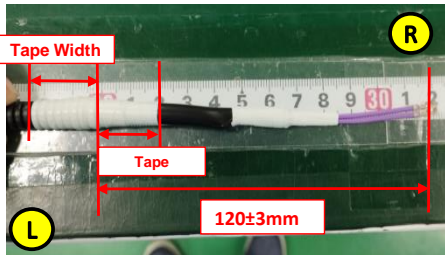

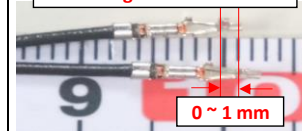
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PARTS:		1. Assy parts 2. White tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2 Taping 2 Black COT to Black Vinyl tube	<div><p>1. Measure the end of the COT up to the end of the terminal pointed tip 120mm using both hands.</p></div> <div><p>2. Hold the COT using left hand, get the White tape using right hand then start pre-taping using both hands.</p></div> <div><p>3. After taping, check the measurement, alignment and tape condition.</p></div>	<div>MEASURING TAPE</div> 	<div>Note: Please use calibrated/verified measuring tape when getting the measurement.</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>Wire alignment tolerance</div> 

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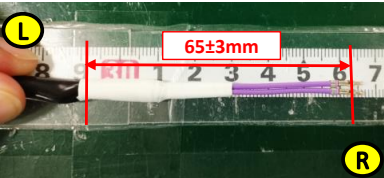
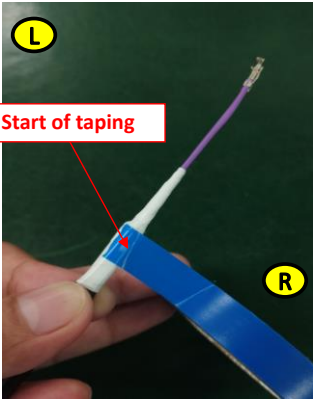
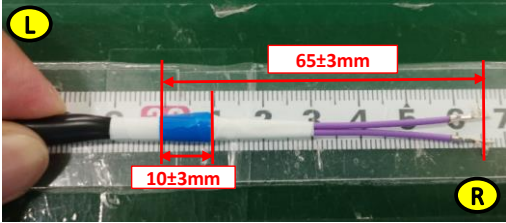

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PARTS:	1. Assy parts. 2. Blue tape (10mm)			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2 Spot Taping	<div data-bbox="622 501 1005 679"></div> <div data-bbox="604 708 1028 823"><p>1. Measure from Vinyl tube up to terminal pointed tip 65mm using both hands. NOTE: This dimension is for internal control only. Not specified in the drawing.</p></div> <div data-bbox="1173 443 1485 842"></div> <div data-bbox="1043 855 1514 986"><p>2. Get the Blue tape (10mm) using right hand, begin taping process, conduct 2 windings using both hands.</p></div> <div data-bbox="584 999 1088 1222"></div> <div data-bbox="1095 1098 1507 1209"><p>3. After spot taping, check the measurement, alignment and tape condition.</p></div>		<div data-bbox="1536 560 1765 603">MEASURING TAPE</div> <div data-bbox="1536 628 1751 711"></div>	<div data-bbox="1783 456 2125 587"><p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p></div> <div data-bbox="1771 799 1995 959"><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></div>

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