

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 07, 2022

Validity Date:

n/a

Model Code/Part Number:

TP1 / 7L0092-7021

Customer:

TRQSS

Document No.:

WI-ENG-PDE-063C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:

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PARTS:

1. Assy parts
2. Black tape [1pc.]

JIG:

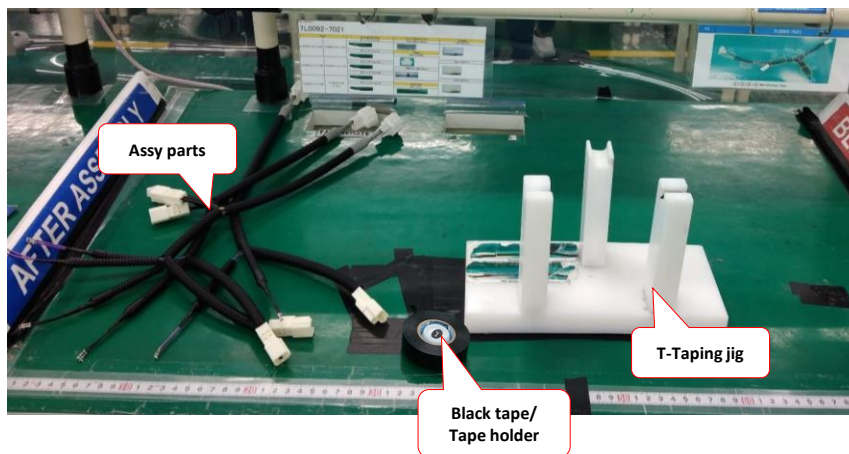
1. T-Taping jig

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

1

P3

Table Lay-out

Table Lay-out**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

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
10/07/22	7	Improve quality pointers: References in process no.2 and 4 due to document improvement.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
04/12/22	6	Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
02/15/21	5	Change part number from 7L0092-7020A to 7L0092-7021 due to change in tape color from Black tape to Gray tape from COT to wire near connector. Conduct review of documents.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
02/03/21	4	Apply some improvements. Remove cycle time in every process. Conduct semi-annual review of documents.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				

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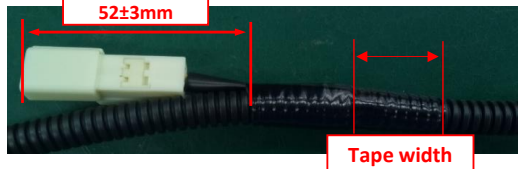
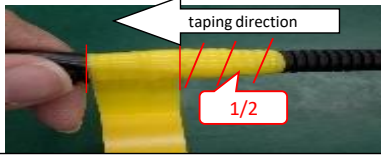
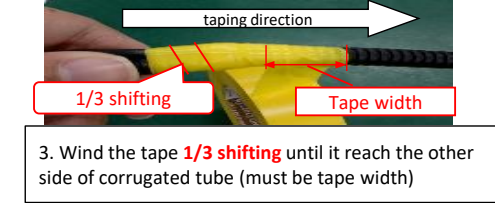
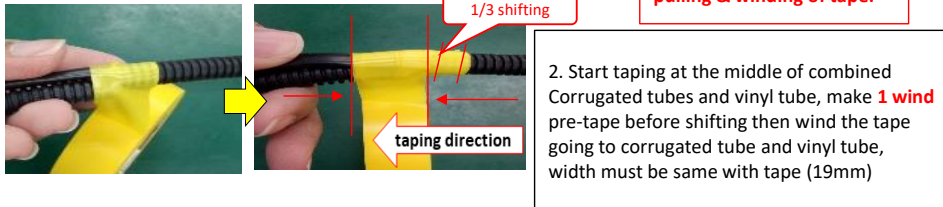
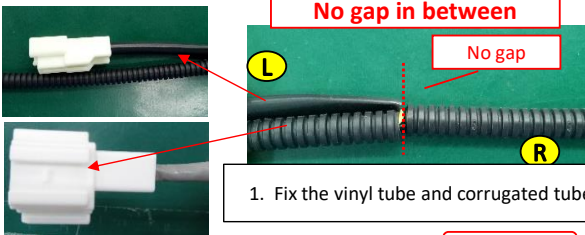

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P3 Y-taping	<div></div>			<div></div>	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.2. Please use calibrated/verified measuring tape when getting the measurement. <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape

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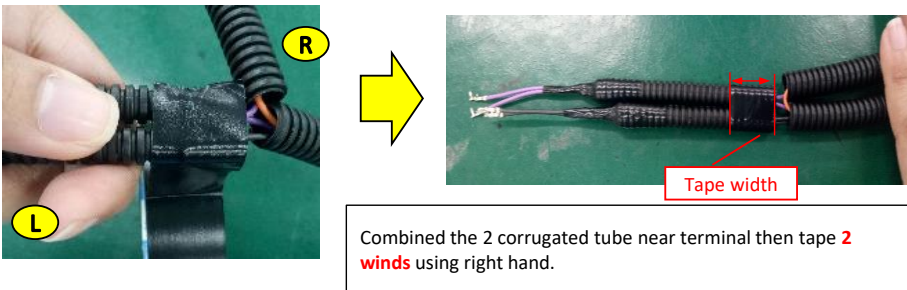
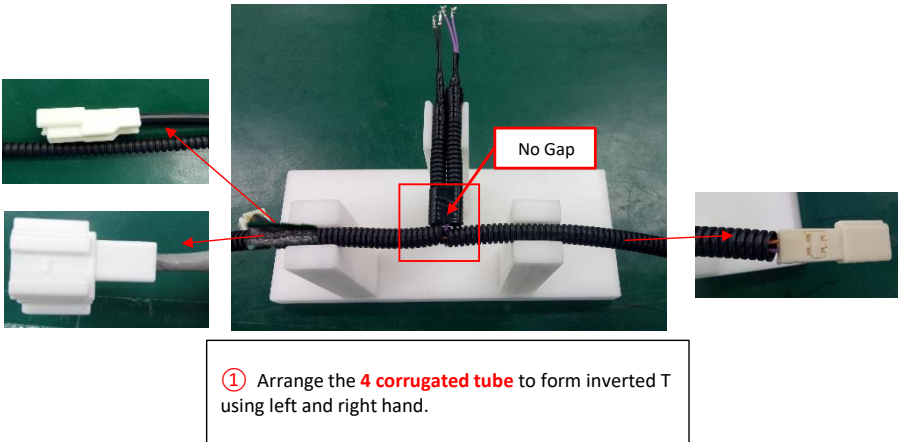
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PARTS:		1. Assy parts 2. Black tape			JIG	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	Pre-tape	 <p>Combined the 2 corrugated tube near terminal then tape 2 winds using right hand.</p>			n/a	1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No exposed wire
4	T-taping	 <p>① Arrange the 4 corrugated tube to form inverted T using left and right hand.</p>			n/a	1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wide interval between COT 6. No exposed wire

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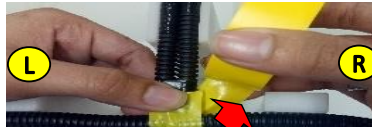



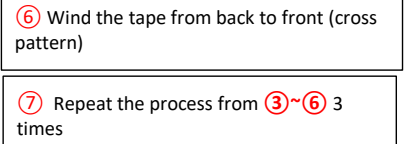



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PARTS:		1. Assy parts 2. Black tape			JIG	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P3 T-taping (Continuation)	<div><p>② Start taping at the middle to fix the 4 corrugated tubes using right hand.</p></div> <div><p>③ Wind the tape from front to back at the right side</p></div> <div><p>④ Wind the tape from back to front (cross pattern)</p></div> <div><p>⑤ Wind the tape from front to back at the left side</p></div> <div><p>⑥ Wind the tape from back to front (cross pattern)</p></div> <div><p>⑦ Repeat the process from ③~⑥ 3 times</p></div> <div><p>⑧ Tape the right side corrugated tube (3 winds), width must be same as tape (19mm)</p></div> <div><p>⑨ From the right side, wind the tape <u>2/3</u> shifting going to center</p></div> <div><p>⑩ Wind the tape from front to back side (cross pattern)</p></div>			n/a	<p>7</p> <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.2. Please use calibrated/verified measuring tape when getting the measurement. <ol style="list-style-type: none">1.No flip out tape2.No tape peeling3. No loose tape4. No wrong use of tape5. No wrong dimesion

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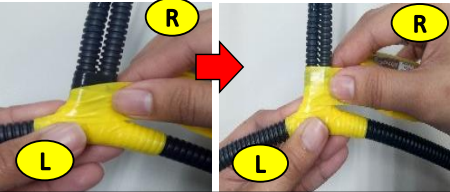




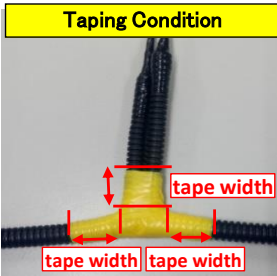
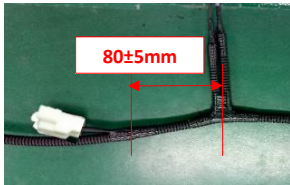

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3 T-taping (Continuation)	<div><p>⑪ Tape the top side corrugated tube (3 winds), width must be same as tape (19mm)</p></div> <div><p>⑫ From the top side, wind the tape 2/3 shifting going to center</p></div> <div><p>⑬ Wind the tape going to front side (cross pattern)</p></div> <div><p>⑭ Wind the tape from front to back side (cross pattern)</p></div> <div><p>⑮ Tape the right side corrugated tube (3 winds), width must be same as tape (19mm).</p></div> <div><p>Taping Condition</p></div> <div><p>⑯ After taping, check the measurement and condition of tape.</p></div>		<div><p>MEASURING TAPE</p></div>	<p>7</p> <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.2. Please use calibrated/verified measuring tape when getting the measurement. <ol style="list-style-type: none">1.No flip out tape2.No tape peeling3. No loose tape4. No wrong use of tape5. No wrong dimesion

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