

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 26, 2022

Model Code/Part Number:

N/A / 7H0399W7021

Customer:

NBS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-470B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 4**PARTS:**1. Assy parts: Black sunprene tube $\varnothing 9$ L=96 \pm 3mm; Black tape [1pc.]

JIG:

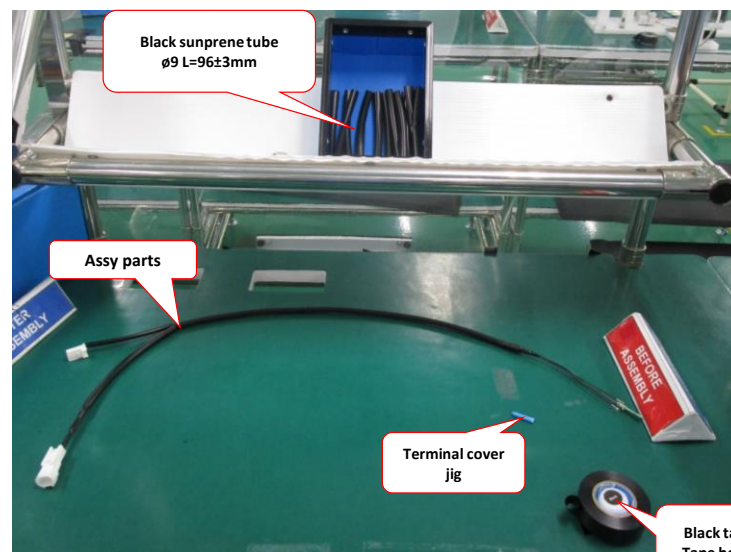
1. Terminal cover jig

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

1

P2

Table Lay-out

Table Lay-out**Safety Instruction**

Be sure to wear required 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	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/21/22	1	Change document purpose from pre-launch to masspro. Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
04/08/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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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	P2 Y-taping	<p>Note: Do not exert excessive force during pulling & winding of tape.</p> <p>1. Fix the two Vinyl tubes and COT using both hands. <i>See illustration for correct facing of connector.</i></p> <p>2. Hold two vinyl tube using left hand and fix to COT. Make 1 winding for pre-tape before shifting then winding the tape down to vinyl tube until tape width.</p> <p>3. From vinyl tube, make 1/3 shifting to COT until tape width. Winding the tape 1 time before shifting.</p> <p>4. From COT, winding the tape down to vinyl tube (1/2 shifting) until tape width.</p> <p>5. From vinyl tube, winding the tape (1/2 shifting) going to side of corrugated tube then cut the tape after 2 windings. After taping, check the condition of tape.</p>	<p>MEASURING TAPE</p> 	<p>NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</p> <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 <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Y-TAPING ORIENTATION</p> 

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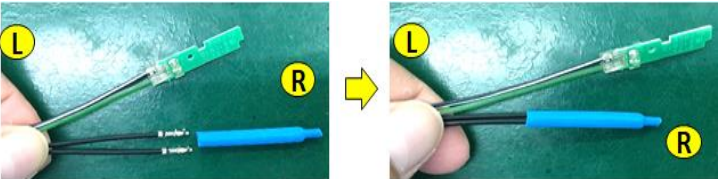
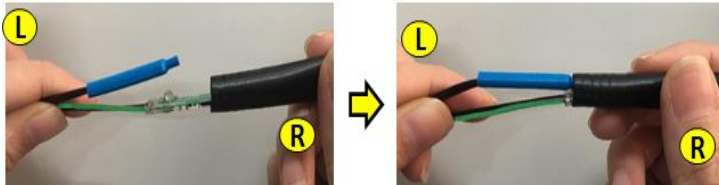
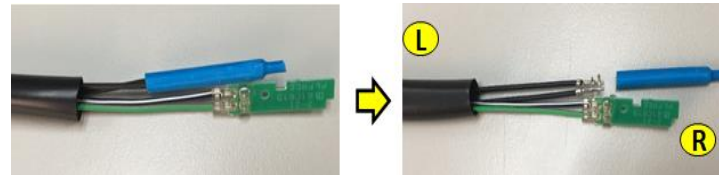

☒ MASSPRO

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PARTS:	1. Assy parts 2. Black tape 3. Black sunprene tube $\varnothing 9$ L=96 \pm 3mm			JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Wire insertion to Black sunprene tube $\varnothing 9$ L=96 \pm 3mm	<div data-bbox="683 480 1400 659"></div> <div data-bbox="734 678 1384 730"><p>1. Get the terminal cover jig using right hand then insert the terminal B-B wires using left hand.</p></div> <div data-bbox="683 756 1400 941"></div> <div data-bbox="734 960 1384 1045"><p>2. Hold the Black Sunprene tube $\varnothing 9$ L=96\pm3mm using right hand then Insert first the hotmelted wires and then next the B-B wires with cover jig using left hand.</p></div> <div data-bbox="683 1078 1400 1252"></div> <div data-bbox="768 1272 1377 1308"><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>		<div data-bbox="1556 863 1758 885">TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No deformed terminal

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P2

Taping 1
Black sunprene tube to Black
COT near PCB and terminal

50 ± 3mm

57 ± 3mm

25 ± 3mm

25 ± 3mm

25 ± 3mm

50 ± 3mm

57 ± 3mm

1. Measure from end of tube up to terminal pointed tip **57±3mm**; and tube up to PCB **50±3mm** using both hands.

2. Hold the tubes using left hand, get the **Black tape** using right hand then start pre-taping using both hands.

3. Confirm measurement of **25±3mm** from end of tape up to end of tube then continue the taping process using both hands.

4. Confirm measurement of **25±3mm** from end of tube up to end of tape then continue the taping process using both hands.

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

MEASURING TAPE



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

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

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