



WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/ Part Number: 220D / 7L0134-7020

Customer: TRQSS

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

January 12, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-446B

Revision No.:

4

Page No.:

1 of 6

PARTS:

1. Assy parts; Green tape; Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

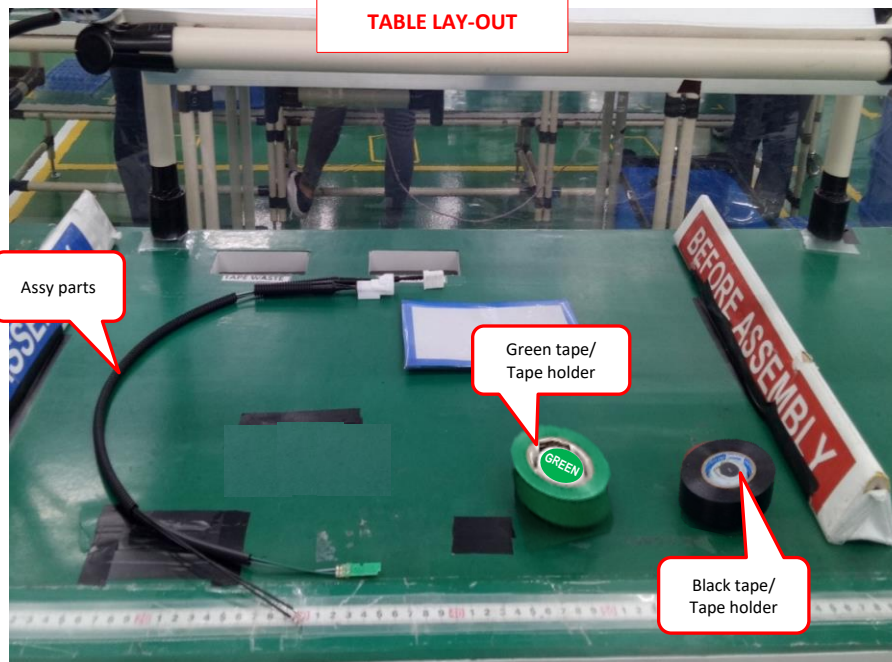
TOOLS/PPE

QUALITY POINTERS

1

P2

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 in assy parts
2. No excess tape/tape holder
3. No wrong position of tape holder

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
01/12/24	4	Additional Important reminders/Note/s in Process 2 (Page 2) due to customer claim countermeasure. Change term from sunprene tube to VM tube (Sunprene)	D.Castillo	C.Villanueva	A. Arañes	n/a				
04/24/23	3	Inclusion of quality checkpoints	J.Loterte	C.Villanueva	A. Arañes	n/a				
09/23/22	2	Improve Quality pointers; Reminders/Notes on pg. no. 2, 3,4 and 5	M.Ariola	J.Loterte	C.Villanueva	A. Arañes				
Est. Date:							D. Castillo	C. Villanueva	A. Arañes	n/a
								March 09, 2022		

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

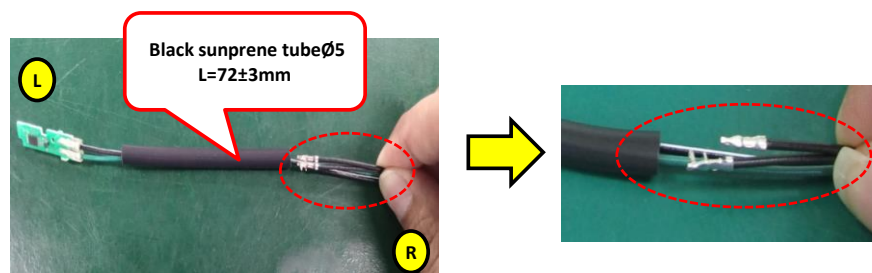
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

Wire Insertion to assy parts



4

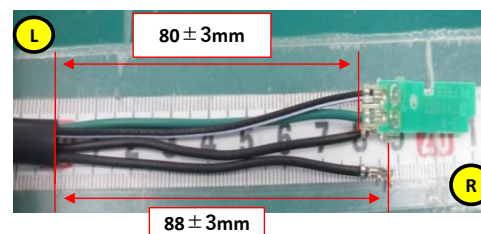
1. Hold the Black VM tube (Sunprene) **Ø5 L=72±3mm** using left hand then continue to insert the assy parts using right hand.

n/a

1. No wrong usage of parts
2. No wrong insertion

3

Taping 1 VM tube (Sunprene) to wire near terminal and hotmelted wire



1. Hold sunprene tube using left hand. Measure from VM tube (Sunprene) to end of hotmelted wire **80±3mm** and Sunprene tube to terminal tip **88±3mm**.

MEASURING TAPE



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

Important reminder/Note/s:

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

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PARTS:

1. Assy parts
2. Green tape

JIG

n/a

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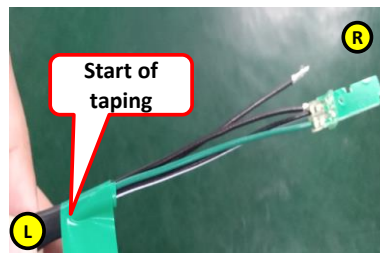
TOOLS/PPE

QUALITY POINTERS

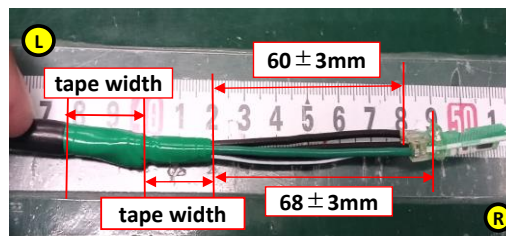
4

P2

Taping 1
VM tube (Sunprene) to
wire
near terminal and
hotmelted wire
(Continuation)



2. Get **Green tape** using right hand, hold the VM tube (Sunprene) ($\phi 5 L=72 \pm 3mm$) using left hand. Fold the sunprene tube and start taping using right hand.



3. After taping check the measurement, wire alignment and taping condition.

MEASURING TAPE



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

Important reminders/Note/s:

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

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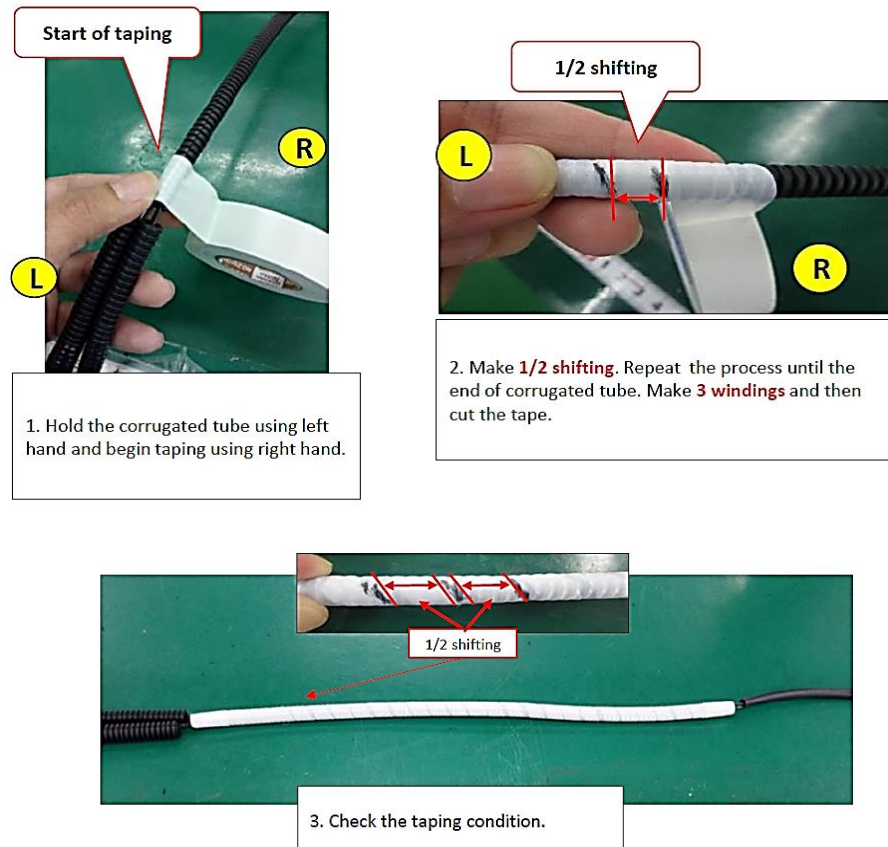
TOOLS/PPE

QUALITY POINTERS

5

P2

Half- wrap taping



Measuring tape



Important reminders/Note/s

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

2. Used WHITE TAPE to easily visualize the tape shifting, but actual should be BLACK TAPE.

3. Internal tolerance for halfwrap taping shifting should be 0~14mm only.

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2. Black tape

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n/a

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6

P2

Y-Taping

**NO GAP BETWEEN
CORRUGATED TUBES**

1. Fix the corrugated tube .

taping direction

tape shifting 1/3
below

tape width



tape shifting 1/2

4. Winding the tape backward 1/2 shifting.

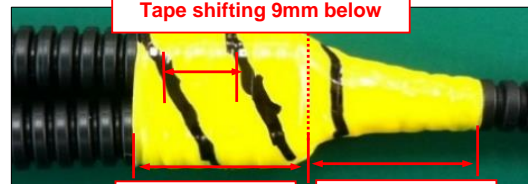


27±3mm

2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be 27±3mm.

3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be 20mm.

Tape shifting 9mm below



27±3mm

20±3mm

5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.

MEASURING TAPE



Important reminders/Notes:

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

2. Do not exert excessive force during pulling & winding of tape.

3. Used YELLOW TAPE to easy visualize the tape shifting, but actual should be BLACK TAPE.



Connector Orientation

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PARTS:

n/a

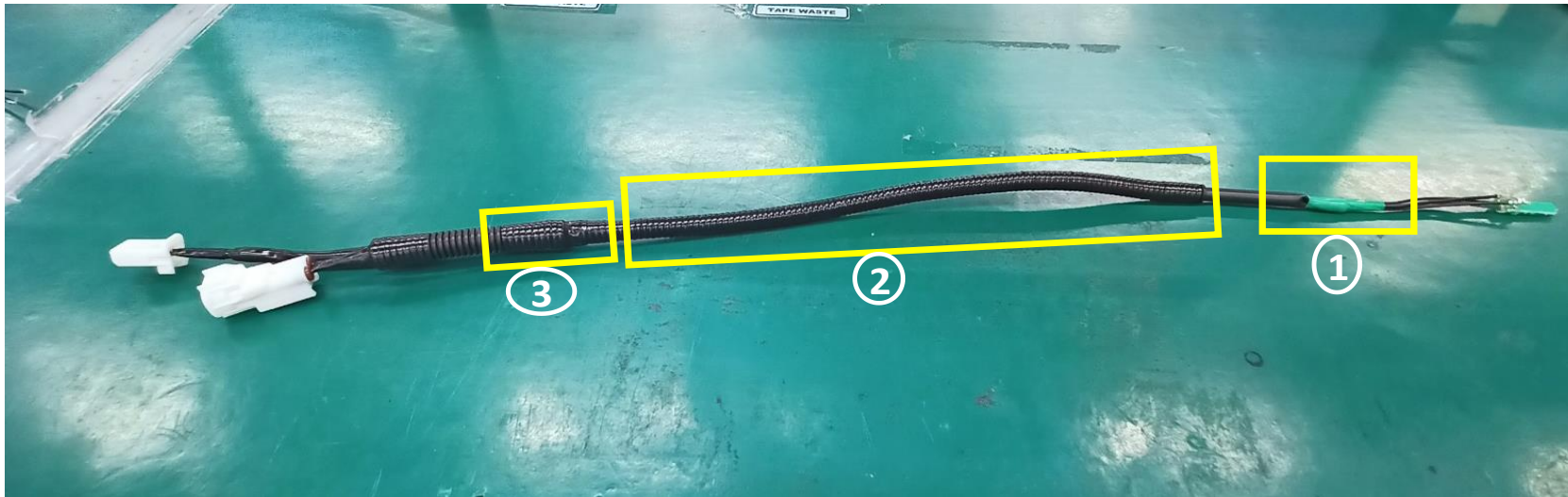
JIG

n/a

QUALITY CHECKPOINTS

P2

7L0134-7020



① ② ③ No MISSING TAPE

Proper alignment of
B/B wires and

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