



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

GC7(FHI)/ 15G060-0010

Customer: TRP

Car Model: SUBARU-LEGACY

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

March 21, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-016B

Revision No.:

6

Page No.:

1 of 2

PARTS:

1. Black Tesa Tape No.51618
2. Assy parts

JIG:

1. Cutter jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P2

△
6
Taping 1
SV tube (Vinyl) to wire
near connector

1. Hold the SV tube (Vinyl) using left hand and measure the SV tube (Vinyl) up to the connector 35mm.

2. Fold the SV tube (Vinyl) then conduct taping, 1 wind before shifting.

3. Make 1/2 shifting, 3 winds going to right direction.

4. 1 wind before end of tape.

5. Cut the tape using the provided cutter then press the end tape

6. Press the end tape using left hand.

7. After taping, check the measurement and taping condition.

8. Check the measurement from SV tube (Vinyl) to connector

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 work place is prohibited. Keep it in your locker.

Alert level

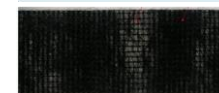
For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

MEASURING TAPE

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong dimension
5. No damage parts

Important reminders/Note/s:

1. Pleaser use calibrated/verified measuring tape when getting the measurement.
2. The dimension from tube to connector (11±3) must be controlled based on the drawing. if encountered out of specification, STOP the process, CALL the attention of the Leader and WAIT for instruction then continue the process.

TESA TAPE CONDITION

Whitish appearance of Tesa Tape due to thickness variation
Judgement: GOOD


Revision History


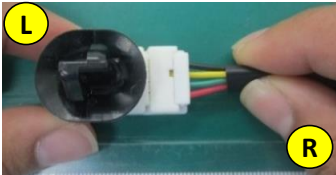
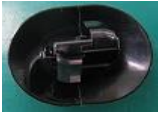

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
03/21/24	6	Change from 1 piece to 3 piece flow. Change term from Vinyl tube to SV tube (Vinyl).	D.Castillio	C.Villanueva	A. Arañes	n/a				
08/08/23	5	Update template; Inclusion of CAR MODEL "SUBARU-LEGACY". (Refer to ENGDRR-144 for Document revision request)	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
11/17/22	4	Correction of Process number from P1 to P2 on page no.1.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
							D. Castillo	C. Villanueva	A. Arañes	n/a

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION				Effectivity Date:	March 21, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: GC7(FHI) / 15G060-0010		Customer: TRP	Car Model: SUBARU-LEGACY	Document No.:	WI-ENG-PDE-016B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	6	Page No.:	2 of 2

PARTS:	1. Clip type clamp B001200839 (B) 2. Assy parts			JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Clamp attachment (Clip type Clamp B001200839 (B))	<div><div>1. Get clamp using right hand then Hold the connector using left hand. Insert the clamp and slightly push into connector using right hand. Click sound will be heard if insertion was OK.</div></div> <div><div>2. Make sure clamp is fully inserted by 1x pushing downward.</div></div> <div></div>		n/a	1. No loose attachment of clamp 2. No damage parts Important reminders/Note/s: 1. Only one side of the clamp can be inserted to connector.
3		Pass WIP to P3	<div><div>1. Put WIP to WIP holder.</div></div>		n/a

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp