



# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **240B / 7M0516-7020C**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 23, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-024B

Revision No.:

5

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### PARTS:

1. Black tape
2. Assy parts

JIG: n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Wire taping	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <p><b>MEASURING TAPE</b></p>	<p><b>Wire alignment tolerance</b></p> <p>0 - 1 mm</p> <ol style="list-style-type: none"><li>1. No deformed terminal.</li><li>2. No loose tape</li><li>3. No peel-off tape</li><li>4. No wrong dimension</li></ol> <p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p>

### Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Established Date:	Prepared by	Reviewed by	Approved by	Noted by
4/23/21	5	Change effective date and remove validity date	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes					
09/30/20	4	Removal of cycle time; Apply some improvements	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes					
04/21/20	3	Change effective and validity date; Added total cycle time	J. Loterte	A. Shimamura	A. Arañes	n/a					
03/06/18	n/a	Previously established Engineering instruction (EI-ENG-PDE-022). Initial issue.	J. Loterte	R. Alcantara		n/a					
								J. Loterte	C. Villanueva	A. Shimamura	A. Arañes

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PARTS:		1. Black tape 2. Assy parts	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Taping COT w/slit to wire	<div><p>1. Hold the corrugated tube using left hand, get Black tape and start pre-taping using right hand.</p></div> <div><p>2. Measure from COT up to the hotmelted wire <b>126mm</b>. Continue the taping process. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<b>MEASURING TAPE</b> 	<p>1.No flip out tape. 2.No peel-off tape 3.No loose tape 4. No wrong dimension</p> <p><b>Note:</b> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p>

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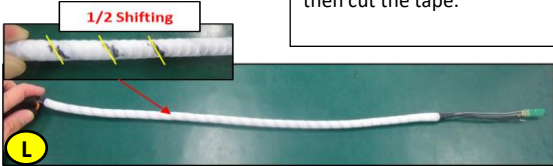
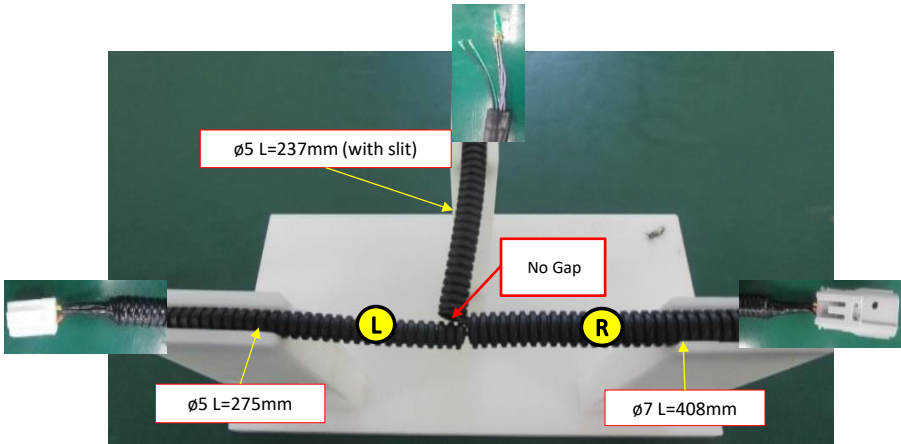
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PARTS:		1. Black tape 2 Assy parts		JIG	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Half wrap taping	<div></div> <div></div> <div><p>1. Hold the corrugated tube using left hand and begin taping using right hand.</p></div> <div></div> <div><p>2. Make 1/2 winds. Repeat the process until the end of corrugated tube. Make 3 winds and then cut the tape.</p></div>	N/A	<p><b>Note:</b> Used <b>White</b> tape to easily visualize the tape shifting. But actual should be <b>Black</b>.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4.No exposed wire</p>
4		T-Taping	<div></div> <div><p>1. Arrange the 3 corrugated tube to form inverted T using left and right hand.</p></div>	n/a	<p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No gap between the COT 5.No exposed wire</p>

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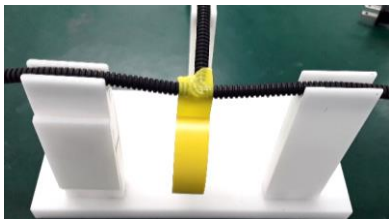

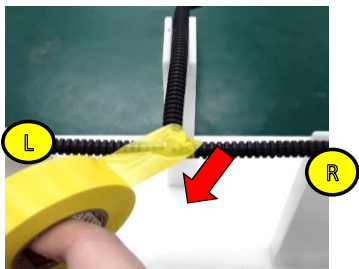
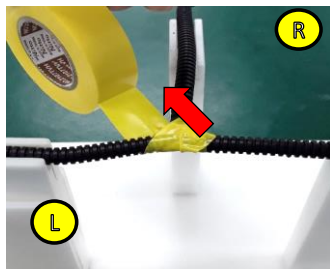
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P2	T-Taping (continuation)	 2. Start taping at the middle to fix the 3 corrugated tubes using both hands.	 3. Wind the tape from front to back at the right side.	N/A	<p>Used Yellow tape to easily visualize the tape shifting, but actual should be <b>BLACK</b>.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No gap between the COT 5.No exposed wire</p>
			 4. Wind the tape from back to front (cross pattern)	 5. Wind the tape from front to back at the left side		

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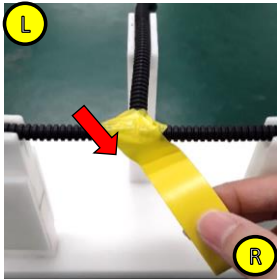
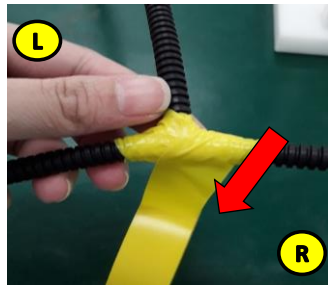
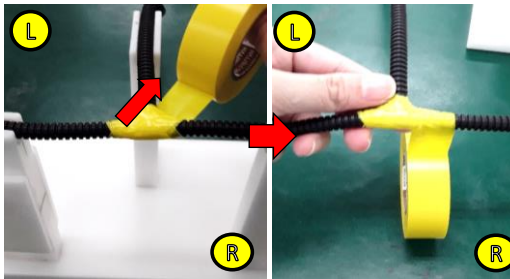
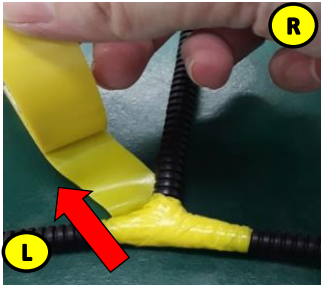
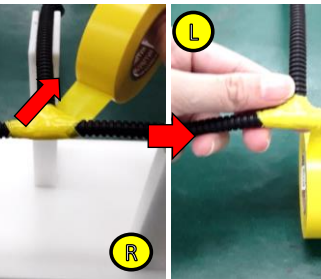
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 T-Taping (continuation)	<div></div> <div>6. Wind the tape from back to front (cross pattern)</div> <div></div> <div>7. Repeat the process from ③~⑥ 3 times</div> <div></div> <div>8. Remove the harness for T-taping jig then tape the right side corrugated tube (3 winds), width must be same as tape (19mm)</div> <div></div> <div>9. From the right side, wind the tape 2/3 shifting going to center</div> <div></div> <div>10. Wind the tape from front to back side (cross pattern)</div>		N/A	<p>Used Yellow tape to easily visualize the tape shifting, but actual should be <b>BLACK</b>.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No gap between the COT 5.No exposed wire</p>

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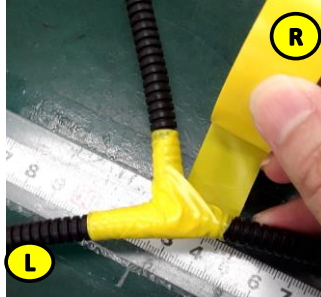
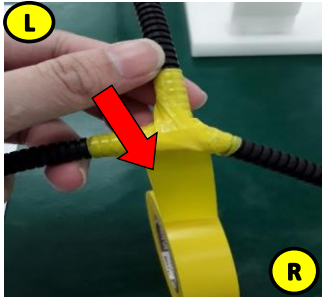
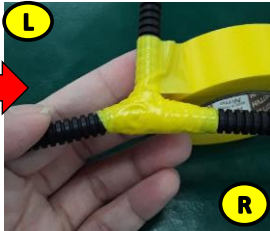

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### PARTS:

1. Black tape
2. Assy parts

JIG

N/A

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2 T-Taping (Continuation)	<div><p>11. Tape the top side corrugated tube (3 winds), width must be same as tape (19mm)</p><p>12. From the top side, wind the tape 2/3 shifting going to center</p><p>13. Wind the tape going to front side (cross pattern)</p><p>14. Wind the tape from front to back side (cross pattern)</p></div>	N/A	<p>Used Yellow tape to easily visualize the tape shifting, but actual should be <b>BLACK</b>.</p> <ol style="list-style-type: none"><li>1. No peel-off tape</li><li>2. No flip out tape</li><li>3. No loose tape</li><li>4. No gap between the COT</li><li>5. No exposed wire</li></ol>

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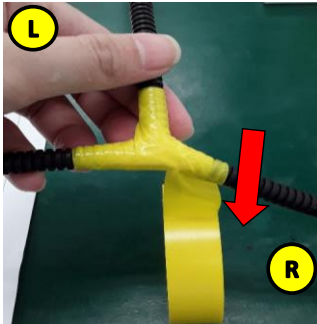
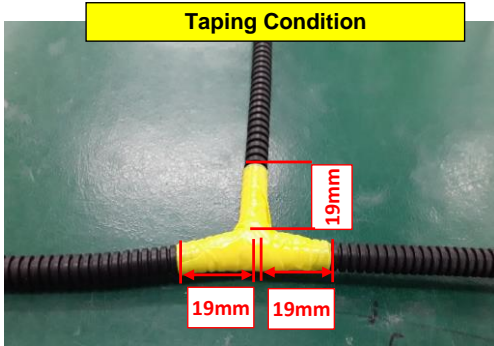


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PARTS:		JIG		
1. Black tape 2. Black Sunprene tube $\phi 10$ L=73 $\pm$ 3mm		3. Assy parts		
1. Terminal cover jig				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	T-Taping (Continuation)  P2	  <p>15. Tape the right side corrugated tube (3 winds), width must be same as tape (19mm)</p> <p>16. After taping, check the measurement and condition of tape.</p>	N/A	<p>Used Yellow tape to easily visualize the tape shifting, but actual should be <b>BLACK</b>.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No gap between the COT 5. No exposed wire</p>
5	Wire insertion to Sunprene tube $\phi 10$ L=73 $\pm$ 3mm	 <p>1. Hold the wires using left hand and insert the terminal cover jig using right hand.</p> <p>2. Hold the wires using left hand and insert the sunprene tube <math>\phi 10</math> L=73<math>\pm</math>3mm using right hand. Remove the terminal cover jig after insertion.</p>	 <p><b>TERMINAL COVER JIG</b></p>	<p>1. No wrong use of parts</p>

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