

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

April 4, 2023Model Code/Part Number: **895B / 7N0092-7020**Customer: **TRJ**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

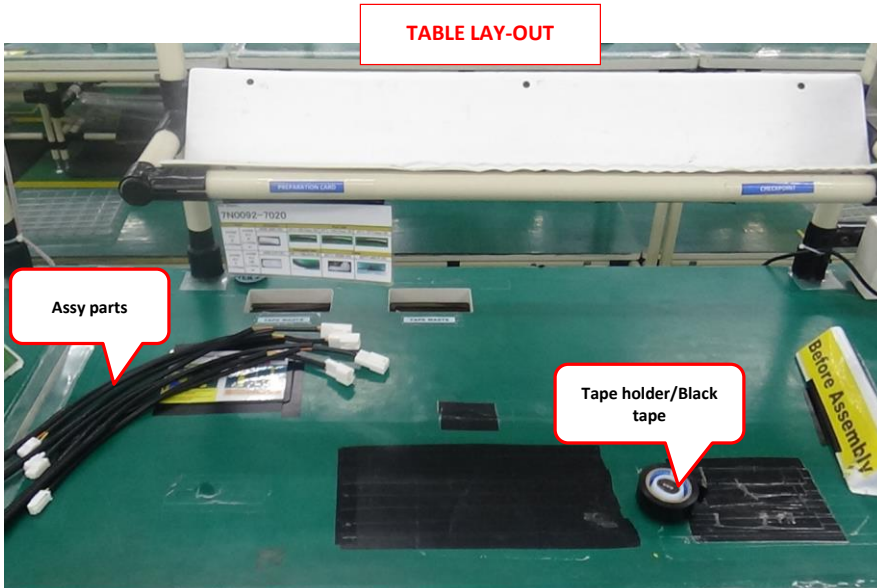
WI-ENG-PDE-500C

Revision No.:





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Page No.:

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| | | | | | |
|---------------|---------------------------|-------------------------------------|---|---|---|
| PARTS: | 1. Assy parts; Black tape | | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 1 | P3 | Table lay-out |  | <div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div> | 1. No missing parts/tools. 2. No excess parts/tools. |

Revision History

| Revision History | | | | | | | Prepared by | Reviewed by | Approved by | Noted by |
|------------------|---------|--|-------------|------------|---------------|-----------|--|---|--|--|
| 04/04/23 | 3 | Inclusion of Quality checkpoints on page no. 5 as document process improvement. | M. Ariola | J. Loterte | C. Villanueva | A. Arañes |  M. Ariola |  J. Loterte |  C. Villanueva |  A. Arañes |
| 03/30/23 | 2 | Merge from 3MP to 4 MP;Transfer process of Taping 1; Taping 1 Black SV tube to wire near connector from P1; Y-taping from P2 to P3; Tranfer process of clamp setting and Clamp Assembly to P4 due to new process distribution. | M. Ariola | J. Loterte | C. Villanueva | A. Arañes | | | | |
| 11/18/23 | 1 | Additional process, press the lock of connector to confirm if properly locked. Judgement will be NG once locked upon pressing | D. Castillo | J. Loterte | C. Villanueva | A. Arañes | | | | |
| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | Est. Date: | September 23, 2022 | | |

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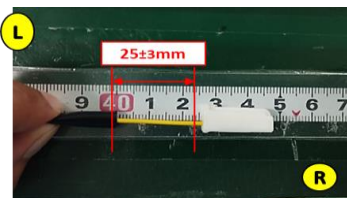
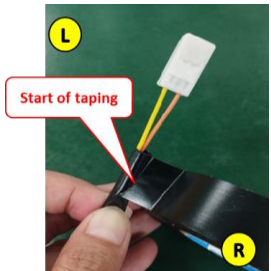
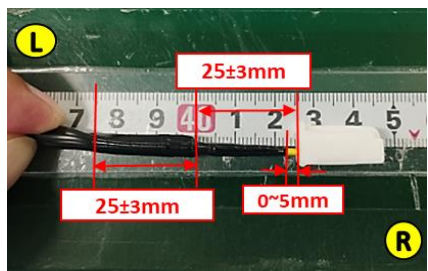

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PARTS:

1. Assy parts
2. Black Tape

JIG

n/a

| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|-----|---|---|--|--|
| 2 | P3 Taping 1 Black SV tube (Vinyl) to Wire near connector | <div><p>1. Measure from end of SV tube (Vinyl) up to end of connector 25±3mm using both hands.</p></div> <div><p>2. Get the Black tape using right hand then start taping process using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div> | <div>MEASURING TAPE</div>  | <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</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 |

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PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

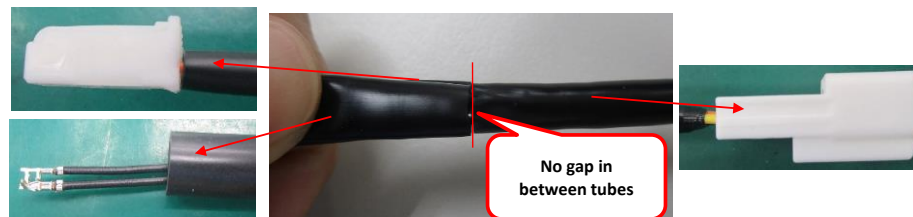
TOOLS/PPE

QUALITY POINTERS

3

P3

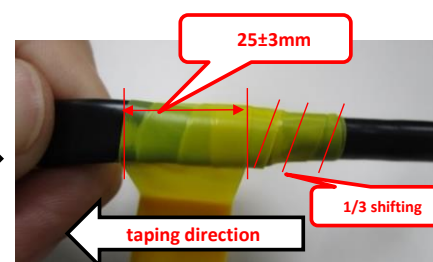
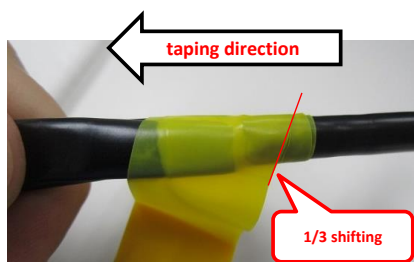
Y-Taping



1. Fix the vinyl tube using both hands.



2. Start taping at the middle of combined vinyl tubes, then wind the tape to left side (width must be 25mm)



3. After pre-taping, make 1/3 shifting to the left until tape width. Wind the tape 2x before shifting to the right side.

MEASURING TAPE



Important reminders/Note/s:
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.

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

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PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

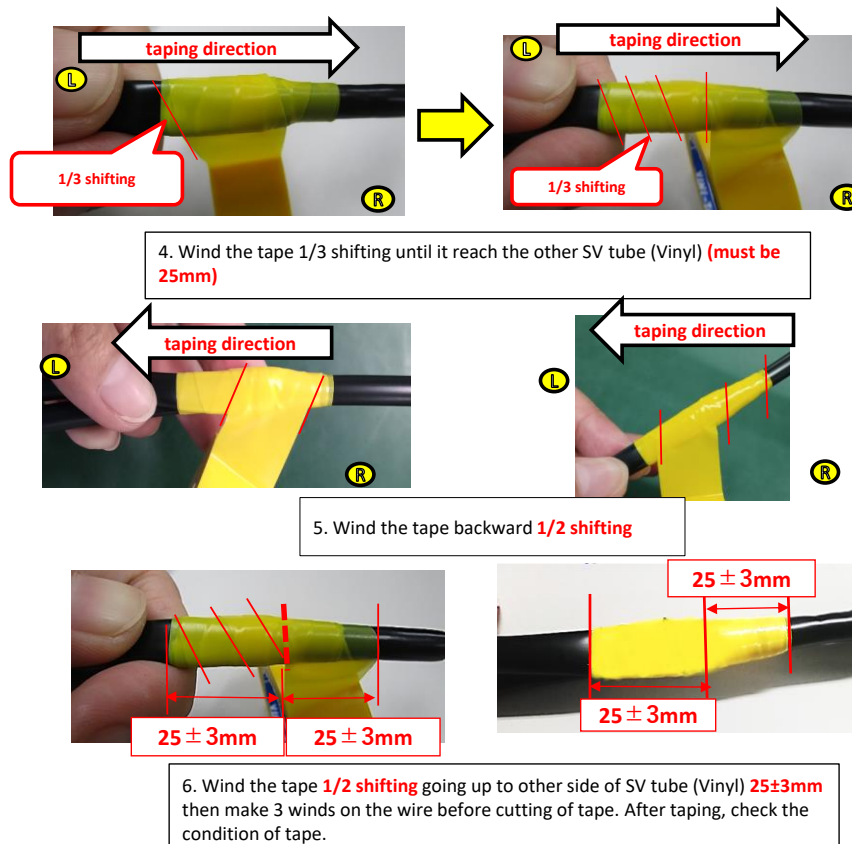
TOOLS/PPE

QUALITY POINTERS

3

P3

Y-Taping
(Continuation)



MEASURING TAPE



Important reminders/Note/s:
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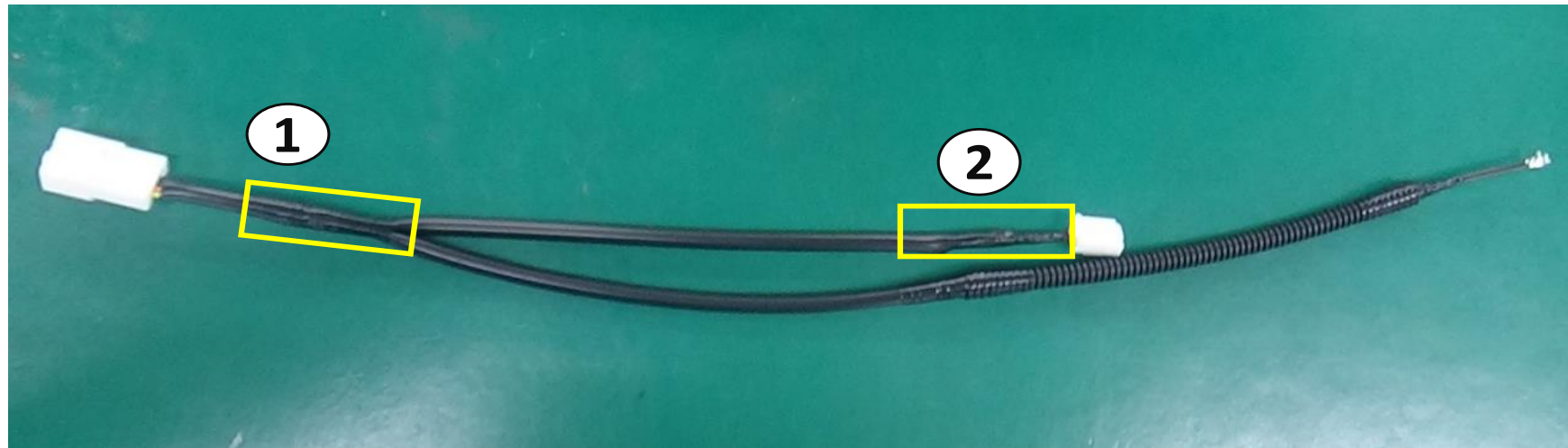
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5 of 5**PARTS:**

n/a

JIG

n/a

**QUALITY CHECKPOINTS****P3****7N0092-7020****① ② No Missing tape**

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