



# WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 19, 2022

Model Code/Part Number:

715W

/

7H0332W7020A

Customer:

NBS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

WI-ENG-PDE-510

Revision No.:

1

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## PARTS:

1. Assy parts; Black corrugated tube  $\phi 5$ , L=40 $\pm$ 3mm (w/slit L=25 $\pm$ 5mm); Black vinyl tube  $\phi 5$  L=22 $\pm$ 3mm; Black tape

## JIG:

1. Terminal Cover jig

## NO.

## PROCESS NAME



## WORK PROCEDURE/ ILLUSTRATION

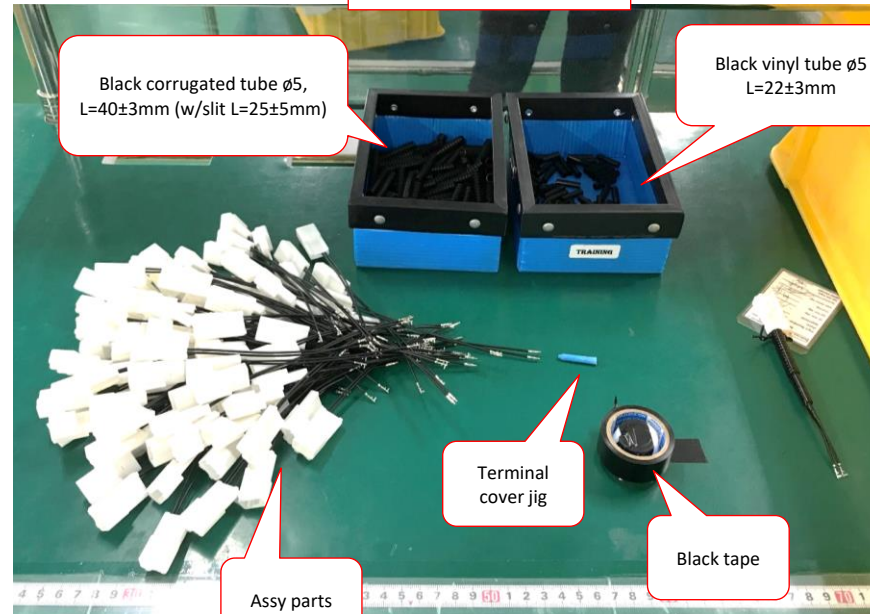
## TOOLS/PPE

## QUALITY POINTERS

1

n/a

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 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.

1. No missing parts/ tools.
2. No excess parts/tools.

## Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/19/22	1	Change Pre-launch to Masspro. Additional Table Lay-out.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
04/29/22	0	Initial Issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				

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PARTS:		1. Assy parts 2. Black corrugated tube ø5, L=40±3mm (w/slit L=25±5mm)	3. Black vinyl tube ø5 L=22±3mm	JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to Black corrugated tube ø5, L=40±3mm (w/slit L=25±5mm)	<div><p>1. Get the terminal cover jig using right hand and insert the <b>B-B wires</b> using left hand.</p><p>2. Get the <b>Black corrugated tube ø5, L=40±3mm (w/slit L=25±5mm)</b> using right hand and insert the wires using left hand.</p><p>3. Remove the terminal cover jig after insertion using right hand.</p></div>	<div><p><b>with slit</b></p><p><b>TERMINAL COVER JIG</b></p></div>	1. No wrong usage of parts 2. No deformed terminal
3		Wire insertion to Black vinyl tube ø5 L=22±3mm	<div><p>1. Get the <b>Black vinyl tube ø5 L=22±3mm</b> using right hand then insert the <b>B-B wires</b> using left hand.</p></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	P1 Taping 1 From wire near connector to corrugated tube and from corrugated tube to vinyl tube	<div><p>1. Hold the connector using left hand and attach the <b>black tape</b> on wires using right hand (<i>see picture for illustration</i>) then make <b>3 winds</b>, do not cut the tape. <b>Note: Attachment of tape to wire must be from 0~5mm.</b></p></div> <div><p>2. After taping, insert the COT w/slit into <b>black tape</b> using right hand.</p></div> <div><p>3. After insertion, conduct <b>2x winding</b> of tape then make <b>1/2 shifting</b> going to right side until it covers the COT with slit.</p></div> <div><p>1/2 Shifting visual reference</p></div>	 <p><b>MEASURING TAPE</b></p>	<ul style="list-style-type: none"><li>1. No loose tape</li><li>2. No peel-off tape</li><li>3. No flip-out tape</li><li>4. No wrong use of tape</li><li>5. No wrong dimension</li></ul> <p><b>Note:</b> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p>

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### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

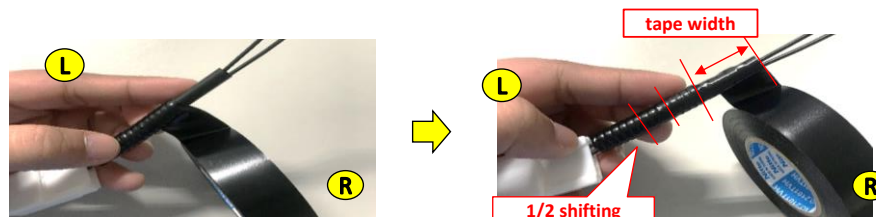
TOOLS/PPE

QUALITY POINTERS

5

P1

Taping 1  
From wire near connector  
to corrugated tube and from  
corrugated tube to vinyl  
tube  
(continuation)



4. Fix the vinyl tube to COT and continue the taping process using both hands. Make **3 winds** then cut the tape.



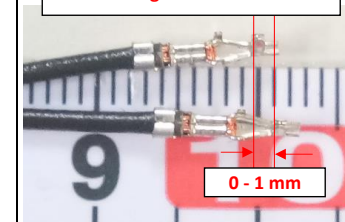
5. After taping, check measurement, taping condition and wire alignment.

### MEASURING TAPE



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

### Wire alignment tolerance



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### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

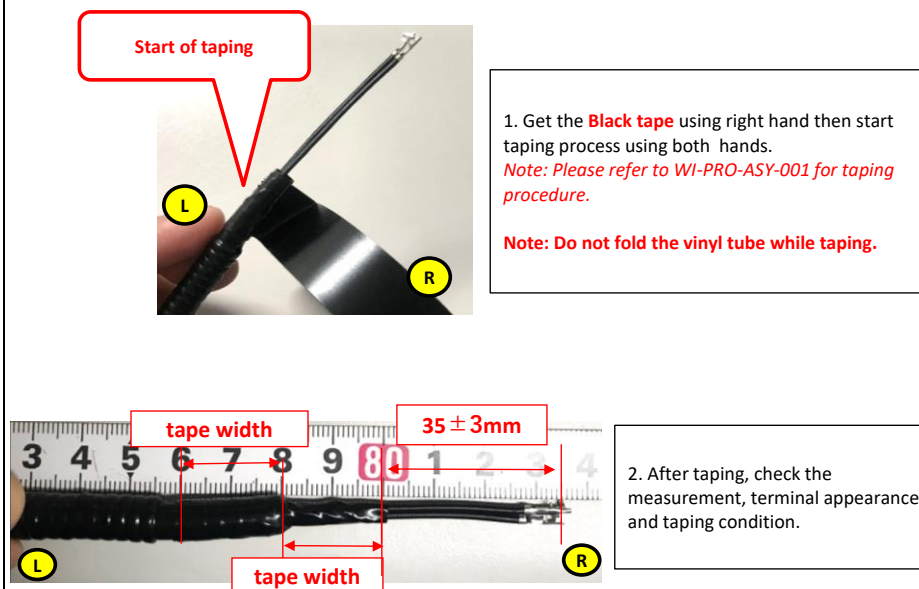
TOOLS/PPE

QUALITY POINTERS

6

P1

Taping 2  
Black Vinyl tube to wire  
near terminal



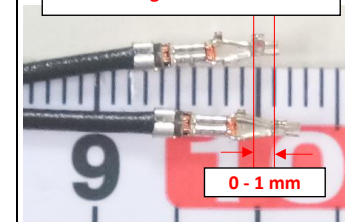
MEASURING TAPE



*Note:  
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

Wire alignment tolerance



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<b>PARTS:</b>	n/a			<b>JIG</b>	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
7	P1 Visual/By Two's inspection	<div>1. Check the connector lock.</div> <div>2. Check the taping condition.</div> <div>3. Check the terminal appearance. Make sure no deformed terminal.</div>  <div>4. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></div>		<div><b>MASTER SAMPLE</b></div> 	
8	Measurement	<div><b>MEASURING TAPE</b></div>  <div><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</div> 		<div><b>NOTE: FOR HATSUMONO AND OWARIMONO</b></div> <div>1. No wrong dimension</div>	

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