

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 24, 2023

Model Code/Part Number:

011B / 7M0365-7021

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-418B

Revision No.:

3

Page No.:

1 of 7

PARTS:

1. All parts: Assy parts; Black Sunprene tube Ø9 L=120±3mm; Black COT (no slit) Ø5 L=435±4mm; Black tape [1pc.]

JIG:

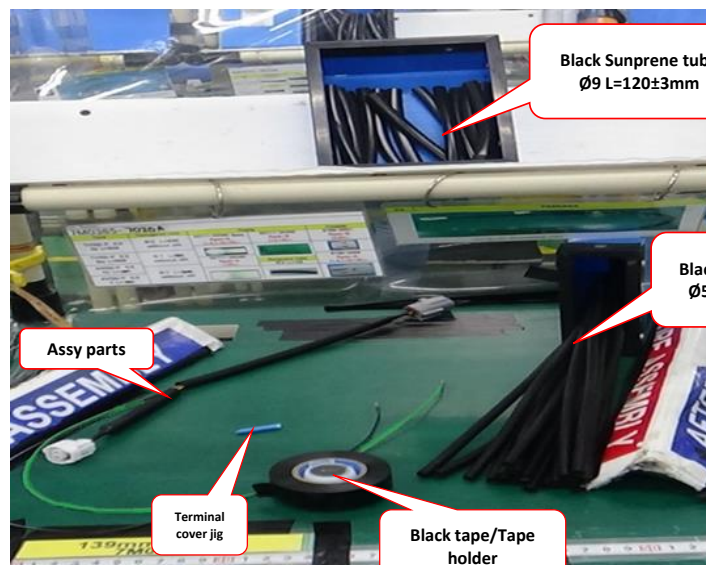
1. Terminal cover jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P2

Table Lay-out

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/tools
2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
04/24/23	3	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a					
11/07/22	2	Improve quality pointers, notes reference in process no.3,4 and 6 as document improvement.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
03/31/22	1	Change Y-taping measurement from 'tape width' to '30mm' due to encountered minimum dimension.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
02/22/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
								J. Loterte	C. Villanueva	A. Arañes	n/a

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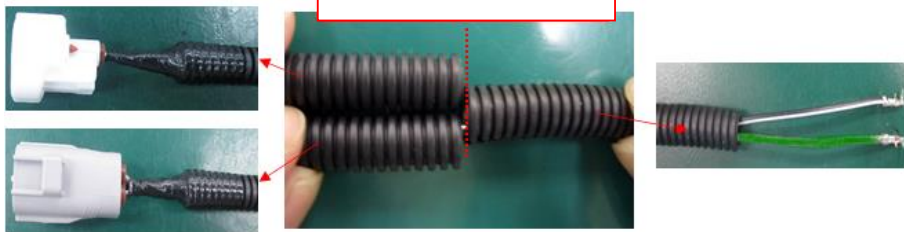
1. Assy parts

2. Black corrugated tube (no slit) Ø5 L=435±4mm

3. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Wire insertion to Black corrugated tube (no slit) Ø5 L=435±4mm	 1. Get the terminal cover jig using right hand then insert to both terminals (G-B/W wires) using right hand.  2. Hold the COT Ø5 L=435±4mm using right hand then insert the G-B/W wires using left hand.  3. After insertion, remove the cover jig using right hand.	TERMINAL COVER JIG 	1. No wrong usage of parts 2. No deformed terminal
3	Y-Taping	 1. Fix the 3 corrugated tube using both hands.	n/a	1. No wrong facing of connector

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Y-Taping (Continuation)	<p>Note: Do not exert excessive force during pulling & winding of tape</p> <p>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side.</p> <p>3. Confirm 30±3mm measurement from end of tape up to end of corrugated tube then continue the taping process using both hands.</p> <p>4. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width).</p>	<p>MEASURING TAPE</p>	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">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. <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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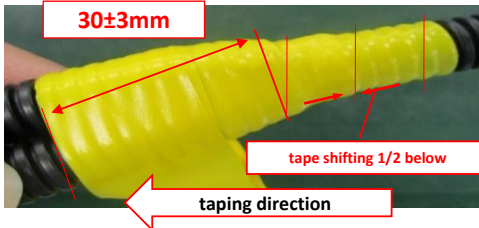
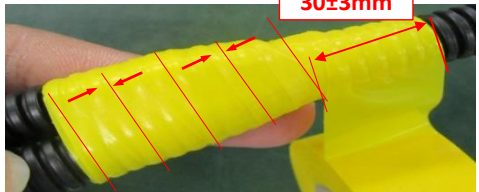
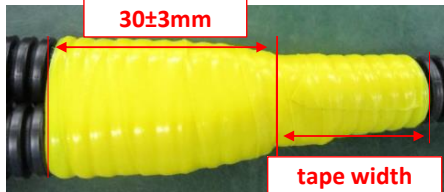

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Y-Taping (Continuation)	 <p>30±3mm</p> <p>tape shifting 1/2 below</p> <p>taping direction</p> <p>5. Make 2 windings of tape then wind 1/2 shifting going to other side.</p>  <p>30±3mm</p> <p>6. Make 2 windings of tape then wind the tape 1/2 shifting going to other side of corrugated tube then make 3 windings of tape and cut.</p>  <p>30±3mm</p> <p>tape width</p> <p>7. After taping, check the measurement and tape condition.</p>		<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">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. <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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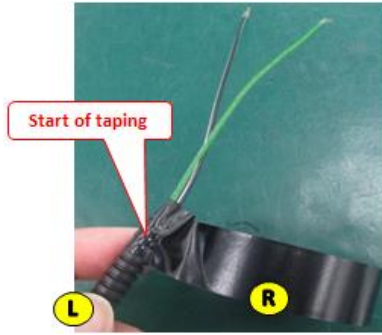
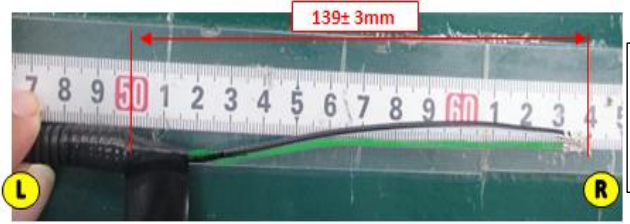
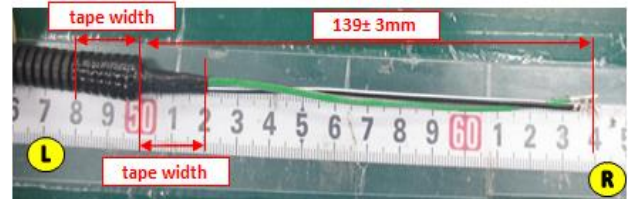

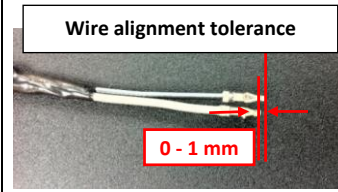
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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2 Taping 1 Black corrugated tube to wire near terminal	 <p>Start of taping</p> <p>1. Hold the corrugated tube using left hand and start taping using right hand.</p>  <p>139±3mm</p> <p>2. Measure from end of the corrugated tube up to terminal tip 139±3mm and then continue the taping process.</p>  <p>tape width</p> <p>139±3mm</p> <p>tape width</p> <p>3. After taping, check the measurement, wire alignment and taping condition.</p>	 <p>MEASURING TAPE</p>	 <p>Wire alignment tolerance</p> <p>0 - 1 mm</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 <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.

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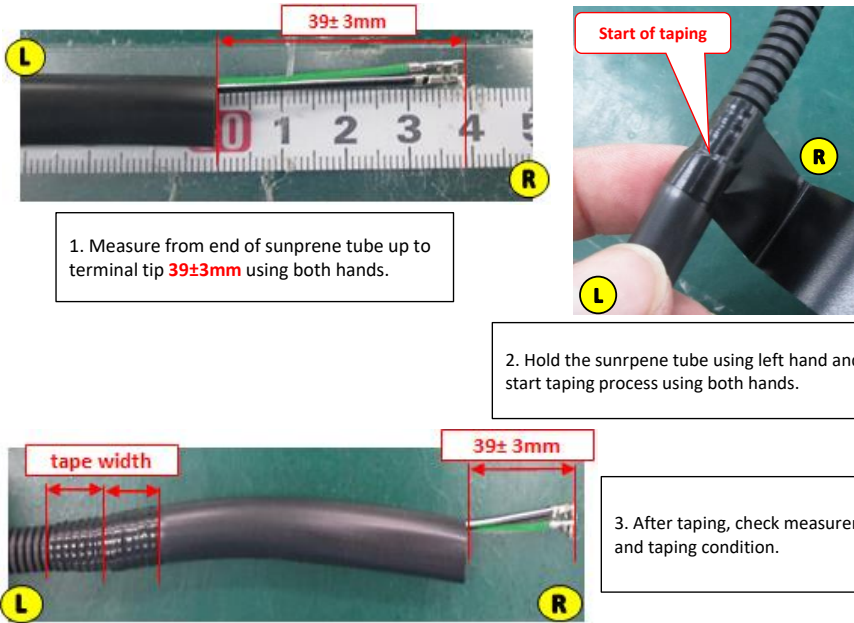

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PARTS:

1. Assy parts
2. Black sunprene tube Ø9 L=120±3mm
3. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to Black sunprene tube Ø9 L=120±3mm	 <p>1. Hold the sunprene tube Ø9 L=120±3mm using right hand then insert the G-B/W wires using left hand.</p>	n/a	<ol style="list-style-type: none">1. No wrong use of parts2. No damaged terminal
6	Taping 2 Black corrugated tube to Black sunprene tube	 <p>1. Measure from end of sunprene tube up to terminal tip 39±3mm using both hands.</p> <p>2. Hold the sunprene tube using left hand and then start taping process using both hands.</p> <p>3. After taping, check measurement and taping condition.</p>	 <p>MEASURING TAPE</p>	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement. <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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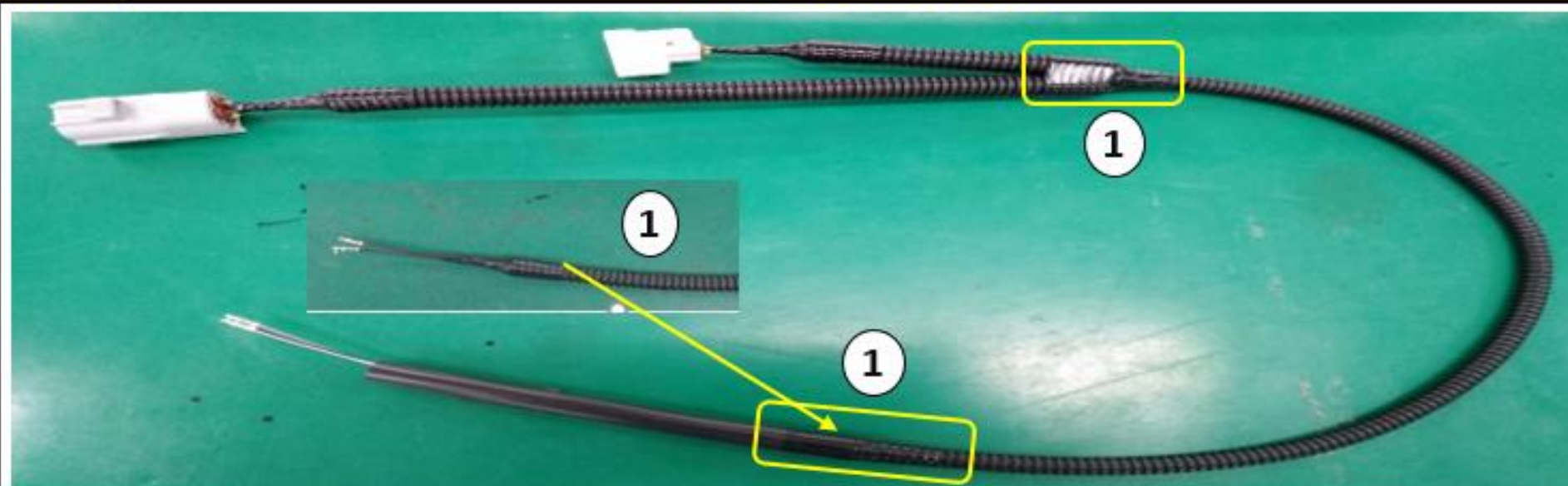
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PARTS:

n/a

JIG

n/a

3 QUALITY CHECKPOINTS**P2****7M0365-7021**

- 1 No Missing Tape**
(y-taping,inside taping(COT-wire) and taping to
sunprene tube)

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