



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: **RE7 / 15F856-0020**

Customer: **TRP**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

October 28, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-023B

Revision No.:

5

Page No.:

1 of 2

PARTS:

1. Tesa Tape No.51618
2. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P2

Taping 1
Vinyl tube to wire near
connector

1. Hold the vinyl tube using left hand and measure the vinyl tube up to the connector 35mm.

2. Fold the vinyl tube 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

6. Press the end tape using left hand.

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

8. Check the measurement from tube to connector

35 ± 3mm

Tape width

1/2

1 2 3

tape width

10 ± 3mm

0~3 mm

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.

MEASURING TAPE



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

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.

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
10/28/22	5	Improve Quality pointers on page no.1 due to document improvement.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
04/12/22	4	Removal of validity date. Improve quality pointers in taping process.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
01/09/21	3	Remove cycle time; Add picture of Tesa tape as reference for Good condition; Improve the tape windings on taping procedure; Update effective and validity date	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				

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****TAPING ASSEMBLY PROCESS**

Effectivity Date:

October 28, 2022

Process Name/Title:

Model Code/Part Number:

RE7 / 15F856-0020

Customer:

TRP

Validity Date:

n/a

Document No.:

WI-ENG-PDE-023B

Purpose:


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

2 of 2

PARTS:		1. Assy parts			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P2	Pass WIP to P3	 <div>Put WIP to WIP holder. Note: One Piece Flow</div>	n/a	1. No WIP overflow	

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