

	<b>WORK INSTRUCTION</b>						Effectivity Date:		April 26, 2023	
	<b>TAPING ASSEMBLY PROCESS</b>						Validity Date:		n/a	
	Process Name/Title:				Model Code/Product Number: <b>780B / 7R0102-7023A</b>		Customer: <b>TRMX</b>		Document No.: <b>WI-ENG-PDE-553B</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		3	Page No.:

<b>PARTS:</b>	1. Assy parts 2. Black tape	JIG	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out  	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	<div>           1. No peel-off tape            2. No flip out tape            3. No loose tape            4. No wrong use of tape         </div> <div style="margin-top: 20px;"> <b>Important reminders/Note/s:</b>             1. Please use calibrated/verified measuring tape when getting the measurement.         </div>

Revision History						Prepared by		Reviewed by	Approved by	Noted by
04/26/23	3	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A.Arañes	n/a	 J. Loterte	 C. Villanueva	 A. Arañes	n/a
11/10/22	2	Improve Quality pointers: Reminders/notes and references on page no.1 to 4 due to document improvement.	M.Ariola	J. Loterte	C. Villanueva	A.Arañes				
07/22/22	1	Change from Pre-launch to Masspro.	M.Ariola	J. Loterte	C. Villanueva	A.Arañes				
07/20/22	0	Initial Issue. QR code 7V4010-0020 label direction	M.Ariola	J. Loterte	C. Villanueva	A.Arañes				
Eff.Date	Rev.No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:
								July 20, 2022		

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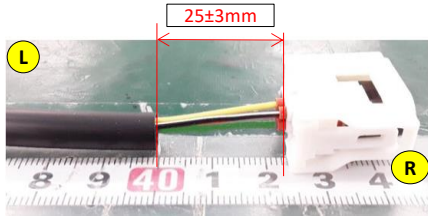
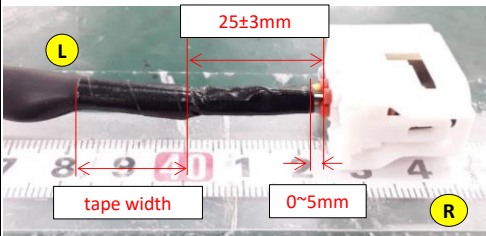


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**PARTS:**

1. Black tape
2. Assy parts

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 Vinyl tube to wire near connector	<div></div> <div><p>1. Hold the Vinyl tube using left hand. Measure the end of Vinyl up to the connector <b>25±3mm</b> using right hand.</p></div> <div></div> <div><p>tape width</p><p>0~5mm</p></div> <div></div> <div><p>2. Hold the Vinyl tube using left hand. Get the Black tape using right hand and start taping. <i>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>	<p><b>MEASURING TAPE</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 wrong use of tape</li></ol> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please use calibrated/verified measuring tape when getting the measurement.</li></ol>

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PROTOTYPE



PRE-LAUNCH



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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

P2

Taping 2  
COT to Sunprene

1. Hold the COT using left hand. Measure the end of COT up to the edge of hotmelted wire **176±3mm** using right hand.



2. Hold the COT using left hand. Get the Black tape using right hand and start taping.



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

**MEASURING TAPE****Important reminders/Note/s:**

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

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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

Y-taping

**No gap between tubes**

**1. Fix the corrugated and Vinyl tube.**

**2. Start taping at the middle of combined Corrugated tube and vinyl tube Make 1 wind pre-tape before shifting then wind the tape going to corrugated tube and vinyl tube, width must be same with tape (19mm).**

**3. Wind the tape 1/3 shifting until it reach the other side of Vinyl tube (must be tape width)**

**4. Wind the tape backward 1/2 shifting.**

**5. Wind the tape 1/2 shifting going to other side of Vinyl tube then cut the tape. After taping, check the condition of tape.**

**Note: Do not exert excessive force during pulling & winding of tape.**

**taping direction**

**tape width**

**tape shifting 1/3 below**

**tape shifting 1/2 below**

**tape width**

**tape width**

**tape width**

MEASURING TAPE



1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wide interval between the COT
5. No wrong use of tape

#### Important reminders/Note/s:

1. Used Yellow tape to easily visualize the tape shifting. But actual should be Black.
2. Please use calibrated/verified measuring tape when getting the measurement.



Connector Orientation

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PARTS: 1. Assy parts

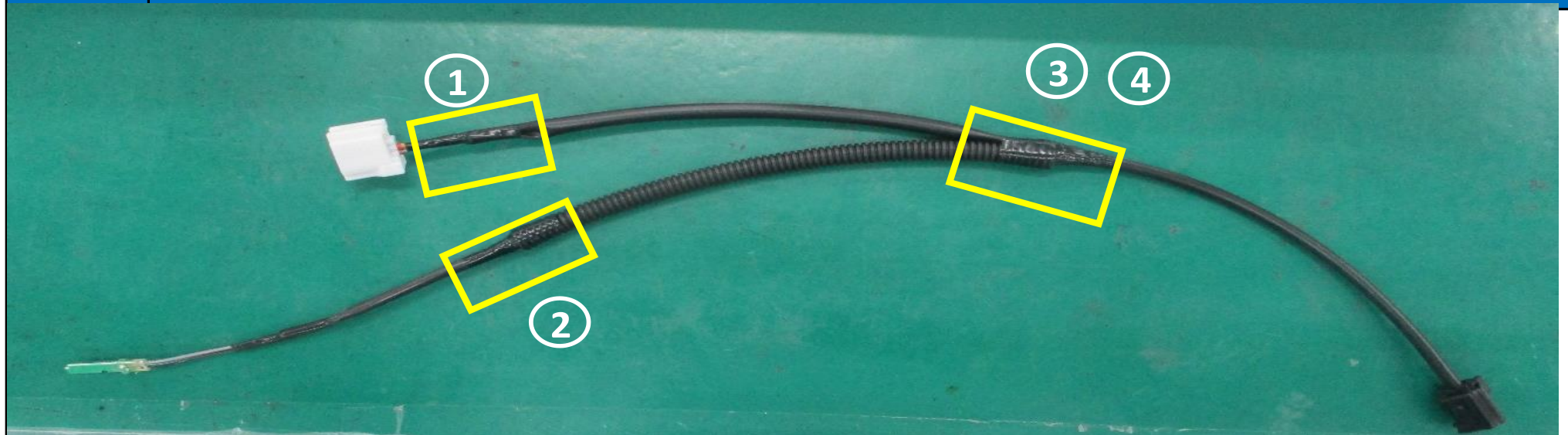
JIG n/a



## QAULTY CHECKPOINTS

P2

7R0102-7023A



① ② ③ **No MISSING TAPE**

④ **Correct Facing of Y-taping**

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