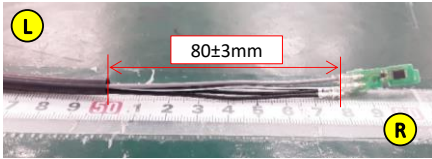
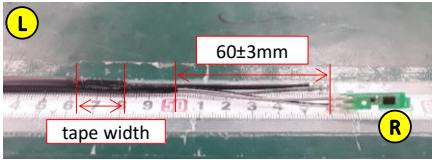

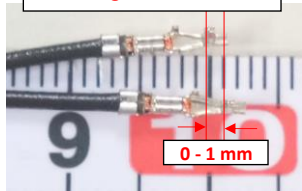
	<b>WORK INSTRUCTION</b>				Effectivity Date:		July 7, 2021	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Product Name/Code: <b>241B / 7L0048-7021</b>		Customer: <b>TRQSS</b>		Document No.:		WI-ENG-PDE-217B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.: 1 of 3

<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 Taping 1 Sunprene to wire near terminal and PCB	 <p>1. Hold the Sunprene tube using left hand. Measure from end of Sunprene tube to terminal pointed tip and edge of Hot melted wire <b>80±3mm</b>.</p>  <p>2. Hold the Sunprene tube using left hand. Get the Black tape using right hand and start taping using both hands. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p> <p>3. After taping, check the measurement, wire alignment and taping condition.</p>	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <p><b>MEASURING TAPE</b></p> 	<p><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape</p> <p><b>Wire alignment tolerance</b></p> 

Revision History						Prepared by	Reviewed by	Approved by	Noted by
07/07/21	3	Removal of validity date.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes			
12/15/20	2	Transfer process owner from Production (WI-PRO-ASY-090B) to Engineering (WI-ENG-PDE-217B); Apply some improvements; Update all pictures	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes			
06/24/19	1	Include process distribution	E. Resurreccion	W. Carbillon	O. Merin	n/a			
03/13/18	n/a	Previously established Engineering Instruction (EI-ENG-PDE-023). Initial Issue.	S. Manalo	R. Alcantara	A. Arañes	n/a	J. Loterte	C. Villanueva	A. Shimamura
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	July 19, 2018	

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## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

July 7, 2021

Process Name/Title:

Validity Date:

n/a

Product Name/Code:

241B / 7L0048-7021

Customer:

TRQSS

Document No.:

WI-ENG-PDE-217B

Purpose:

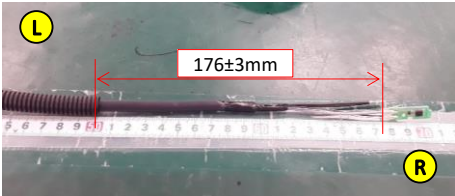

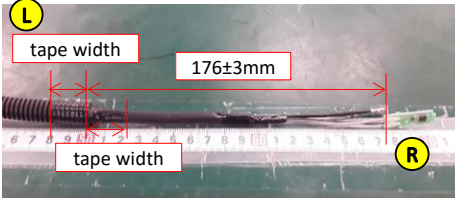

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

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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	P2 Taping 2 COT to Sunprene	<div><p>1. Hold the COT using left hand. Measure from end of COT to terminal pointed tip and edge of Hot melted wire <b>176±3mm</b>.</p></div> <div><p>2. Hold the COT using left hand. Get the Black tape using right hand and start taping using both hands. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p></div> <div><p>3. After taping, check the measurements and taping condition.</p></div>			<p><b>MEASURING TAPE</b></p> 	<p><b>Note:</b> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape</p>

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **241B / 7L0048-7021**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

July 7, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-217B

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### PARTS:

1. Assy parts
2. Black tape

### JIG

n/a

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

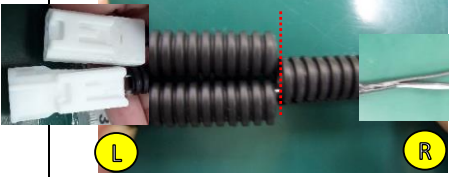
### QUALITY POINTERS

3

P2

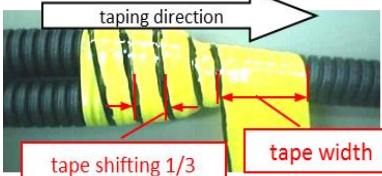
Y-Taping

**No wide interval**



1. Fix the corrugated tube .

**taping direction**



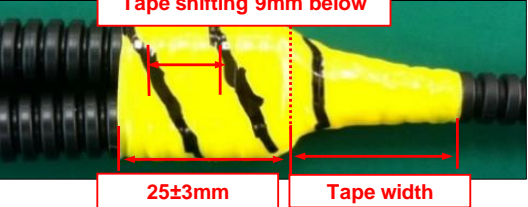
**tape shifting 1/3 below**

**tape width**

2. Start taping at the middle of combined Corrugated tubes, then wind the tape going to 2 corrugated tubes, width must be **25mm**.

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

**Tape shifting 9mm below**



**25±3mm**

**Tape width**

4. Wind the tape backward 1/2 shifting.

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

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

### MEASURING TAPE



**NOTE:**  
**USED YELLOW TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL SHOULD BE BLACK.**

**Note:**  
*Please use calibrated/verified measuring tape when getting the measurement.*

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



**Connector Orientation**

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