



WORK INSTRUCTION

Process Name/Title: TAPING ASSEMBLY PROCESS

Product Name/Code: 948B / 7L0097-7021

Customer: TRQSS

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

March 20, 2021

Validity Date:

-

Document No.:

WI-ENG-PDE-069B

Revision No.:

3

Page No.:

1 of 4

PARTS:		<div>3</div> 1. Clamp 82711-52090 (W) 2. Black tape		<div>3</div> 3. White tape 4. Assy parts		<div>3</div>		JIG:		1. Clamp assembly jig							
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS							
1		Clamp Setting		<div><div><div><div><div><div>1</div><div>2</div></div><div><div>82711-52090</div></div></div><div><div><div>1</div><div>2</div></div><div><div>1. Get the clamp 82711-52090 and set to clamp location <div>2</div> using right hand.</div></div><div><div>2. Get Black tape using right hand. Conduct pre-taping on clamp location <div>2</div> using both hands.</div></div></div><div><div>Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div></div></div></div></div>				<div><div><div><div><div>Safety Instruction</div><div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div></div><div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</div></div></div></div></div>		<div><div><div><div>One side tape under clamp</div><div><div><div>1.No flip out tape</div><div>2.No tape peeling</div><div>3. No loose tape</div><div>4. No wrong use of tape</div><div>5. No wrong dimesion</div></div></div></div></div></div>							
2		Taping 1 Corrugated tube to vinyl tube		<div><div><div><div><div><div>120±3mm</div><div>L</div></div><div><div>1. Measure the end of corrugated tube up to the end of termina tip of Violet wires <div>120mm.</div></div></div></div><div><div><div><div>Tape width</div><div>120±3mm</div><div>L</div></div><div><div>3. After taping, check the measurement, alignment and tape condition.</div></div></div></div></div><div><div><div><div>L</div><div>R</div></div><div><div>2. Hold the corrugated tube using left hand and get White tape using right hand then begin taping process. Note: Refer to WI-PRO-ASY-001 for taping procedure.</div></div></div></div></div></div>				<div><div><div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div><div><div>MEASURING TAPE</div><div><div></div></div></div></div></div>		<div><div><div><div>Note:</div><div>Please use calibrated/verified measuring tape when getting the measurement.</div></div><div><div><div>1.No flip out tape</div><div>2.No tape peeling</div><div>3. No loose tape</div><div>4. No wrong use of tape</div><div>5. No wrong dimesion</div></div></div></div></div>							
Revision History										Prepared by		Reviewed by		Approved by		Noted by	
03/20/21		3		Remove cycle time; Put assy parts on parts section of pg. 1~3; Add additional information on Y-taping process Change clamp colors in accordance with color standardization for plastic parts (Please refer to GL-COM-003) Put measuring tape illustration and instruction on measurement				J. Loterte		C. Villanueva		A. Shimamura		A. Arañes			
07/30/20		2		Updated cycle time; Changed effective and validity date;				J. Loterte		R. Peñaloza		A. Shimamur		A. Arañes			
05/20/20		1		Installed connector checker for continuity and changed cycle time.				D. Castillo		J. Loterte		A. Shimamura		A. Arañes			
Eff. Date		Rev. No		Details of Change				Prepared		Checked		Approved		Noted		Est. Date:	
																April 25, 2020	

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

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Product Name/Code: **948B / 7L0097-7021**

Customer: **TRQSS**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

March 20, 2021

Validity Date:

-

Document No.:

WI-ENG-PDE-069B

Revision No.:

3

Page No.:

2 of 4

PARTS:

3

1. Black tape
2. Assy parts

JIG

N/A

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P2

Y-taping

No wide interval

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

tape width

1. Fix the corrugated tube .

2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side ,width must be same with tape (19mm).

taping direction

Tape shifting 1/3 below

Tape width

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

taping direction

Tape shifting 1/2 below

4. Wind the tape backward 1/2 shifting.

Tape shifting 9mm below

Note: Used Yellow tape for easy visualization of shifting lines , but actual should be **BLACK**.

Tape width

Tape width

N/A

- 1.No flip out tape
- 2.No tape peeling
3. No loose tape
4. No wrong use of tape
5. No wrong dimesion

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:

March 20, 2021

Process Name/Title:

Product Name/Code: **948B / 7L0097-7021**

Customer:

TRQSS

Validity Date:

-

Document No.:

WI-ENG-PDE-069B

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

3

Page No.:

3 of 4

PARTS:

1. Black tape
2. White tape



3. Assy parts

JIG

1. Clamp Assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P2

Clamp Assembly

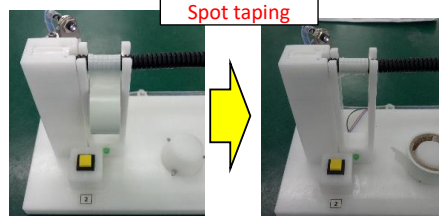
Connector
Setting



1. Put the assy. First, set the connector to Checker then pull the checker fixture for continuity checking. Second, set the **Black wires** with terminal end together within the stopper then press by **Toggle clamp**. Last, set the **Violet wires** with terminal end together within the stopper. Make sure that the sensor detect the **White tape** then press by **Toggle clamp**. Continue if the sequence light of location ① was on.
Note: Terminal should touch the aluminum to check the continuity.

2. Check if all LED light for **POWER ON**, **WIRE1** and **WIRE2** and **CLAMP ON** was **ON**. Check also if clamp location ① sequence light is **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.

Spot taping

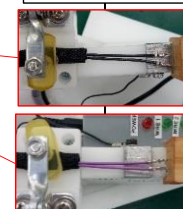


3. Get the **White tape** and start taping. Make **2 winds** before cut the tape. Press the sequence light button after cutting. Continue to location ② if light was on.
Note: You will heard sound if the sensor detect the White tape.

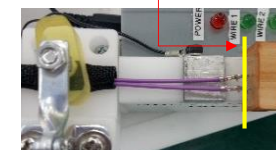
4. Hold the tape on clamp location ② and start taping (**3 winds**) using both hands. Press the sequence light button **Go** buzzer will be heard.

5. **CONDUCT POINT CHECKING** before removing from jig.

Stopper



Make sure no gap between terminal and stopper jig.



1. No damaged clamp
2. No missed tape
3. No missing clamp

NOTE: YOU WILL HEAR THE NG BUZZER IF THE SENSOR DETECT WRONG USE OF TAPE AND MISSING TAPE.

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**Process Name/Title: **TAPING ASSEMBLY PROCESS**Product Name/Code: **948B / 7L0097-7021**Customer: **TRQSS**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

March 20, 2021

Validity Date:

-

Document No.:

WI-ENG-PDE-069B

Revision No.:

3

Page No.:

4 of 4

PARTS:

N/A

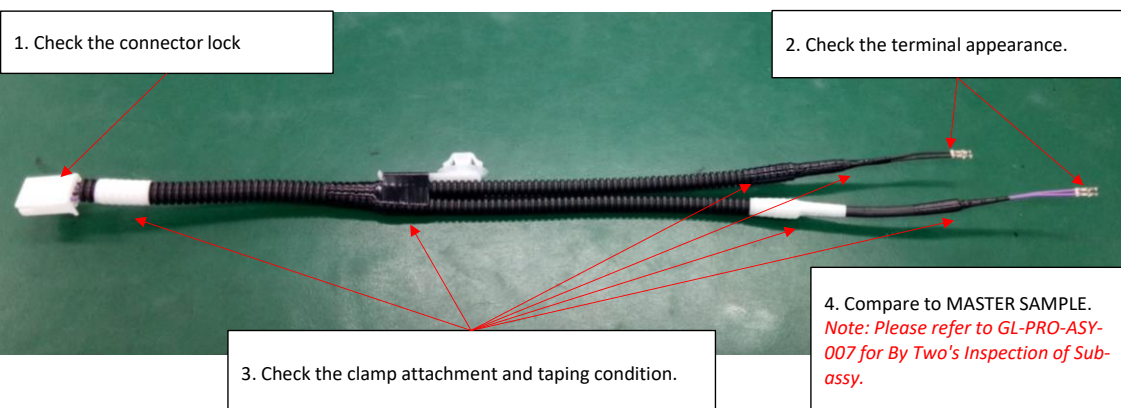
JIG

N/A

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

5

3

Visual Inspection/By
Two's inspection**Master Sample**

P2

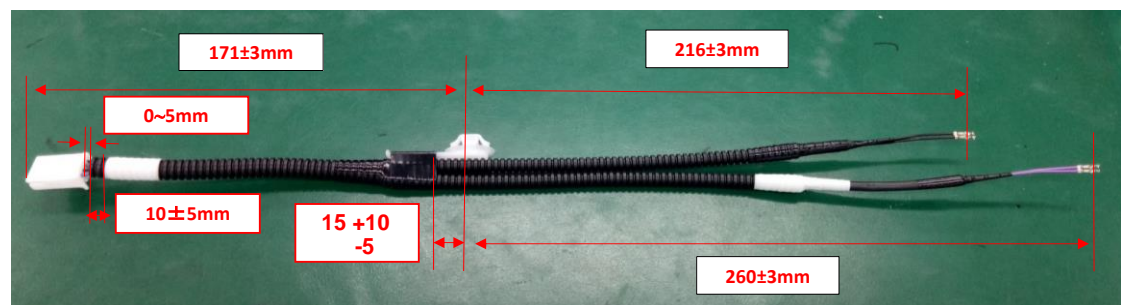
3

Measurement

3



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



*NOTE: HATSUMONO AND
OWARIMONO*

1. No wrong dimension

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