

	WORK INSTRUCTION				Effectivity Date:		May 05, 2022		
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a		
	Process Name/Title:				Document No.:		WI-ENG-PDE-493F		
	Product Name/Code: 014B / 17J924-7051Y		Customer: NBS		Revision No.:		1	Page No.: 1 of 4	
Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							

PARTS:		1. Assy parts 2. Black TESA Tape No 51036		JIG:		1. Taping jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
1	P6 Taping 3 Wire taping (Tesa)	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> BEFORE PRESSING </div> <div style="text-align: center;"> AFTER PRESSING </div> </div> <div style="border: 1px solid black; padding: 5px; margin: 5px;"> 1. Set the connector 1827842-1 (W) then push the guide lock using right index finger. </div> <div style="text-align: center; margin: 10px 0;"> </div> <div style="border: 1px solid black; padding: 5px; margin: 5px;"> 2. Continue to set the harness on Jig 2. (See picture for the correct setting). </div> <div style="display: flex; justify-content: space-around; margin-top: 10px;"> <div style="text-align: center;"> GOOD </div> <div style="text-align: center;"> NG OVERLAP </div> </div>				<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction 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;"> Housekeeping 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;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1. No wrong setting of harness 2. No wrong orientation of connector

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
05/05/22	1	Change document purpose from pre-launch to masspro	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
04/28/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted	Est. Date:		April 28, 2022			

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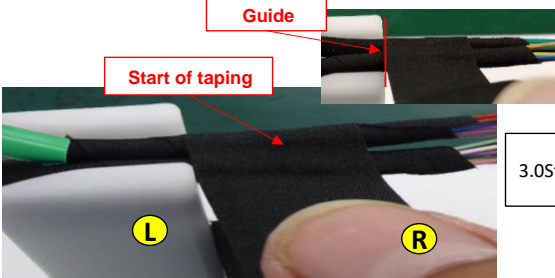
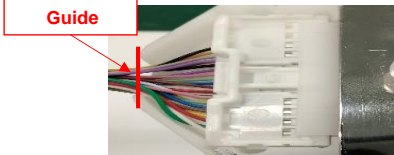
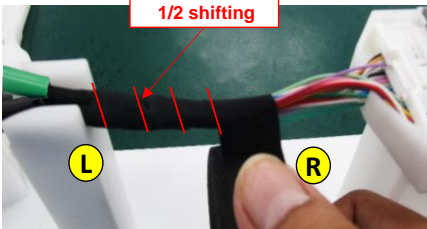
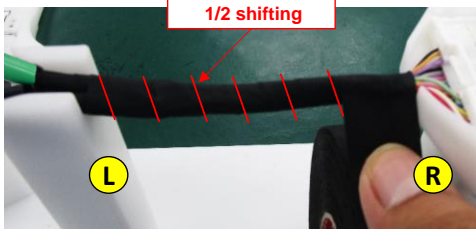

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PARTS:

1. Assy parts

JIG

1. Taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P6 Taping 3 Wire taping (Tesa) (Continuation)	 <p>3.0 Start taping using guide 1 1/2 winding.</p>   <p>4. Make 1/2 shifting or 6-7 windings going to the right side until it reach the guide near connector.</p>  <p>5. Make 2 windings of tape before cut.</p>	 <p>Use only this cutter</p>	<ol style="list-style-type: none">1. No loose tape2. No excessive tape winding3. No damage on parts4. No peel off tape5. No bend wire6. No NG of end tape

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PARTS:

1. Assy parts

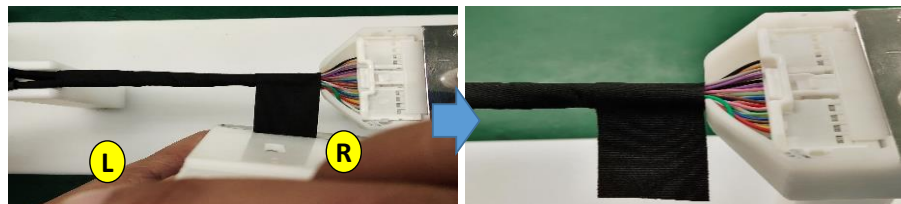
JIG

1. Taping jig

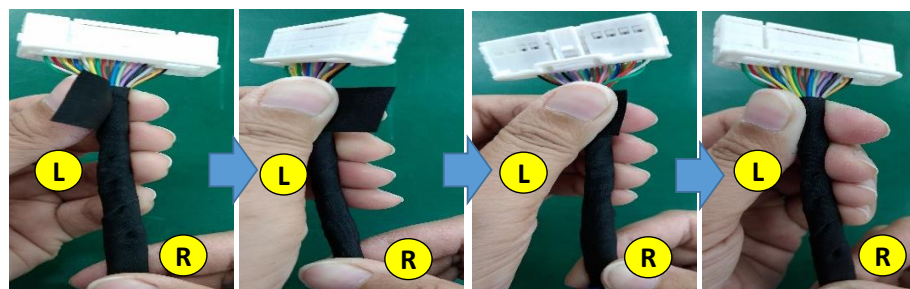
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P6

Taping 3
Wire taping (Tesa)
(Continuation)

6. Using the provided cutter, cut the tape using both hands.



7. Press the end tape using left hand. Do not touch the adhesive

Use only this
cutter

1. No loose tape
2. No excessive tape winding
3. No damage on parts
4. No peel off tape
5. No bend wire
6. No NG of end tape

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n/a

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P6

Taping 3
Wire taping (Tesa)
(Continuation)



8. After taping, check the alignment and condition of tape.

9. Proceed to **Continuity checking**, refer to **EI-ENG-PDE-123** if encountered problem, refer to **Treatment on Levercon continuity checker NG WI-ENG-PDE-001**.

10. Refer to **WI-ENG-PDE-096 End Tape Pressing**.

11. Refer to **IS-QAD-QAC-006 Inspection Standard**

n/a

1. No loose tape
2. No excessive tape winding
3. No damage on parts
4. No peel off tape
5. No bend Wire

Note:
Refer to Work instruction of
Continuity checking, End Tape
Pressing and Inspection Guide for
their separate cycle time.

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