

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

Effectivity Date:

December 09, 2022Model Code/Part Number: **920B / 7R0117-7020A**Customer: **TRMX**

Validity Date:

n/aPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-551B

Revision No.:

1

Page No.:

1 of 5**PARTS:**

1. Assy parts: Black tape

JIG:

n/a

NO.**PROCESS NAME****1 WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****1 QUALITY POINTERS**

1

P2

Table Lay-out

Table Lay-out**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.

1. No missing parts/tools
2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
12/09/22	1	Additional table lay-out ; Quality checkpoints - as improvement of documentation and process. Improve work procedure/illustration/quality pointers in all process.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
06/21/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	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:

December 09, 2022

Process Name/Title:

Model Code/Part Number:

920B / 7R0117-7020A

Customer:

TRMX

Validity date

n/a

Document No.:

WI-ENG-PDE-551B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

2 of 5

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

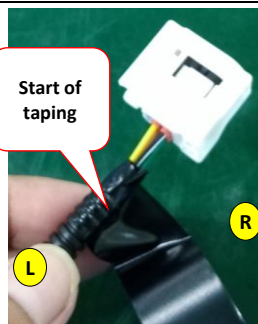
1 QUALITY POINTERS

2

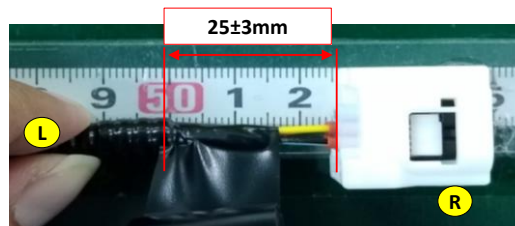
P2

Taping 1
COT to wire near
connector

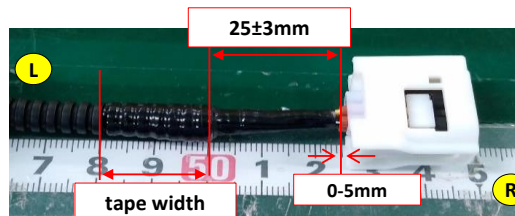
1 WORK PROCEDURE/ ILLUSTRATION



1. Hold the COT then get **Black tape** using right hand then start taping process using both hands.



2. Measure from end of COT up to edge of connector **25±3mm** then continue the taping process using both hands.



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

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.

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

Effectivity Date:

December 09, 2022

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity date

n/a

Model Code/Part Number: **920B / 7R0117-7020A**

Customer:

TRMX

Document No.:

WI-ENG-PDE-551B

Purpose:



PROTOTYPE



PRE-LAUNCH



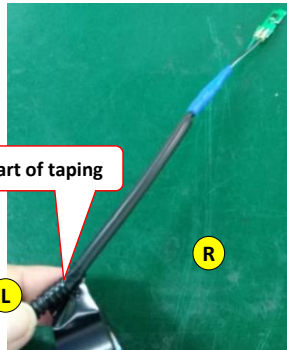

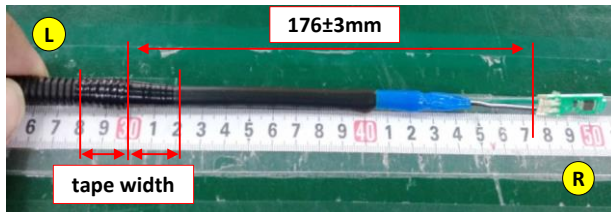

MASSPRO

Revision No.:

1

Page No.:

3 of 5

PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 2 COT to sunprene tube near PCB	<div><div>1</div><div></div><div><p>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div></div> <div><div>2</div><div></div><div><p>2. Measure from end of COT up to PCB 176±3mm then continue the taping process using both hands.</p></div></div> <div><div>3</div><div></div><div><p>3. After taping, check the measurement and taping condition.</p></div></div>	<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>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</p>

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

Effectivity Date:

December 09, 2022

Model Code/Part Number:

920B / 7R0117-7020A

Customer:

TRMX

Document No.:

WI-ENG-PDE-551B

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

4 of 5

PARTS:	1. Assy parts 2. Black tape			JIG	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
4	P2	<div data-bbox="309 719 349 762">1</div> <div data-bbox="409 871 495 892">Y-Taping</div> <div data-bbox="589 459 853 549"></div> <div data-bbox="815 416 1097 440">No gap in between tubes</div> <div data-bbox="1151 539 1402 560">1. Fix the corrugated tube .</div> <div data-bbox="589 611 902 847"></div> <div data-bbox="920 675 1043 775">Note: Do not exert excessive force during pulling & winding of tape</div> <div data-bbox="602 871 1028 943">2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side, width must be same with tape (19mm)</div> <div data-bbox="589 979 1048 1246"></div> <div data-bbox="779 1150 920 1171">tape shifting 1/2</div> <div data-bbox="613 1270 947 1294">4. Wind the tape backward 1/2 shifting</div> <div data-bbox="1135 643 1485 879"></div> <div data-bbox="1218 815 1312 863">tape shifting 1/3 below</div> <div data-bbox="1352 831 1458 852">tape width</div> <div data-bbox="1151 900 1458 975">3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)</div> <div data-bbox="1104 1011 1496 1206"></div> <div data-bbox="1173 1007 1379 1027">Tape shifting 9mm below</div> <div data-bbox="1173 1174 1279 1195">Tape width</div> <div data-bbox="1330 1174 1435 1195">Tape width</div> <div data-bbox="1066 1238 1503 1310">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.</div>		n/a	<div data-bbox="1800 587 2119 695">Important reminders/Note/s: 1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</div> <div data-bbox="1783 807 2007 959">1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div>

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:

December 09, 2022

Process Name/Title:

Model Code/Part Number:

920B**/****7R0117-7020A**

Customer:

TRMX

Validity date

n/a

Document No.:

WI-ENG-PDE-551B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

5 of 5**PARTS:**

1. Assy parts

JIG**n/a****1 QUALITY CHECKPOINTS****P2****7R0117-7020A****1 2 3** No **MISSING TAPE****4** Correct Facing of Y-taping

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