

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Process Name/Title:

Model Code/Part Number:

**240B/ 7M0514-7020B**

Customer:

**TRJ**

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Effectivity Date:

**November 04, 2021**

Validity Date:

n/a

Document No.:

**WI-ENG-PDE-356A**

Revision No.:

0

Page No.:

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**PARTS:**

1. Assy parts
2. Black tape

JIG:

n/a

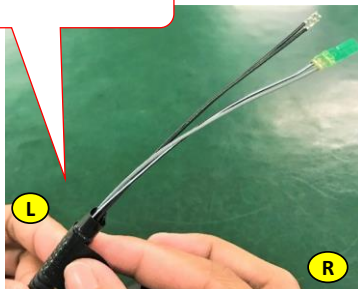
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

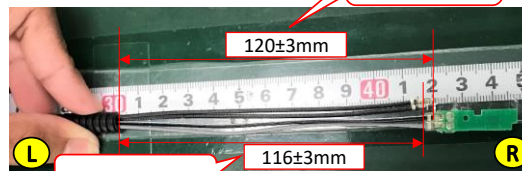
P1

Taping 1  
Black Corrugated tube  
to wire near terminal

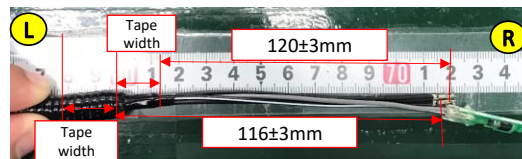
Start of taping



1. Hold the COT using left hand, get the **Black tape** using right then start pre-taping at the middle of COT and wires using both hands.



2. Measure from end of COT up to terminal **120±3mm** and PCB **116±3mm** then continue the taping process using both hands.



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

**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.

**MEASURING TAPE**

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

**Note:**

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

**Revision History**

Eff. Date	Rev. No	Details of Change	Prepared	Checked	Approved	Noted	Prepared by:	Reviewed by:	Approved by:	Noted by:
11/04/21	0	Initial issue	K. Doria	J. Loterte	C. Villanueva	A. Arañes	K. Doria	J. Loterte	C. Villanueva	A. Arañes

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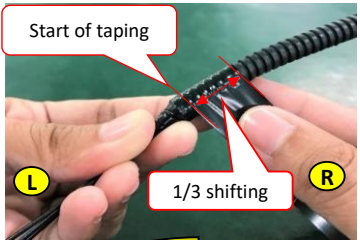
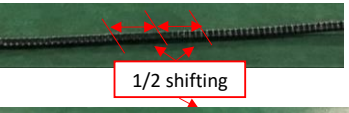


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PARTS:					JIG	
		1. Assy parts 2. Black sunprene tube Ø9 L=73±3mm	3. Black tape			n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P1 Half wrap taping	 <div>1. Hold the Corrugated tube using left hand and begin taping using right hand. Make <b>1/2 shifting</b>. Repeat the process until the end of corrugated tube. Make <b>3 windings</b> and then cut the tape.</div>  				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
3	Wire insertion to Black sunprene tube φ9 L=73±3mm	 <div>1. Get the <b>Sunprene tube φ9 L= 73±3mm</b> using right hand and insert the wires using left hand.</div>			n/a	1. No wrong use of parts 2. No deformed terminal

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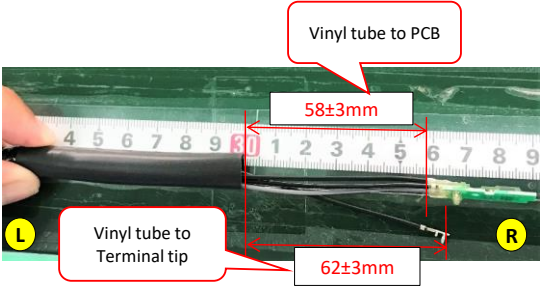




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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 2 Black Corrugated tube to sunprene tube	<div><p>1. Hold the assy parts using left hand. Measure from Sunprene tube to terminal pointed tip <b>62±3mm</b> and PCB <b>58±3mm</b>.</p></div> <div><p>2. Hold the assy parts using left hand. Get the Black tape and start taping using right hand. <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>	<b>MEASURING TAPE</b> 	 <p>1. Check the tape from COT to Vinyl (Conduct bending for verification) 2.No flip out tape. 3.No tape peeling. 4.No loose tape</p> <p><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></p>

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