



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 18, 2023

Process Name/Title:

Model Code/Part Number:

382D / 7N0175-7020

Customer:

TRJ

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-632B

Revision No.:

1

Page No.:

1 of 5

PARTS:

1. Assy parts
2. Black tape

3. Black VM tube (Sunprene) $\phi 9$ L= 89 \pm 3mm

JIG:

1. Spot taping jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

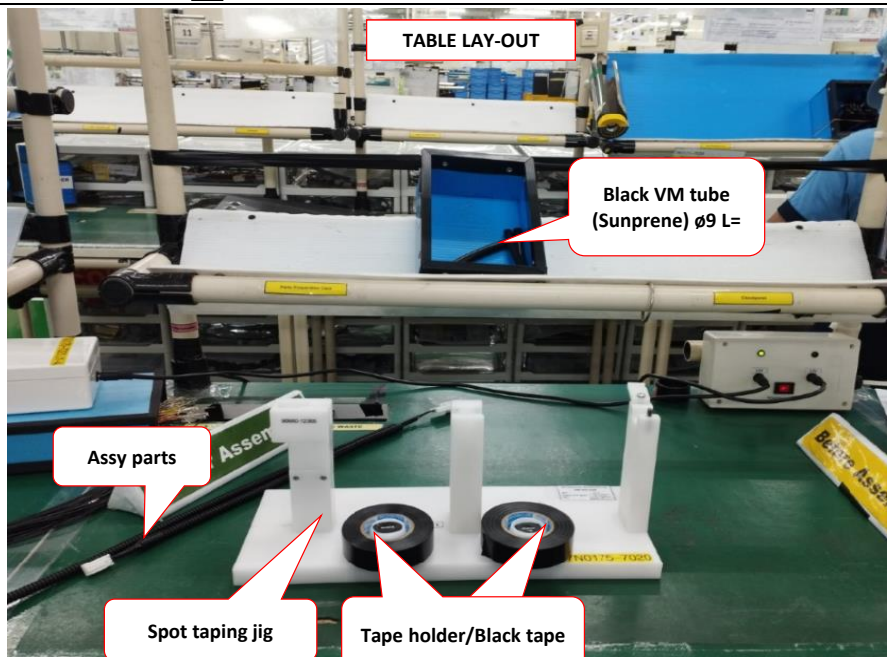
TOOLS/PPE

QUALITY POINTERS

1

P2

Table Lay-out

**Safety Instruction**

Be sure to wear required 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	Prepared	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/18/23	1	Change purpose from Pre-launch to Masspro. Additional table lay-out. Inclusion of Quality Checkpoint on page 5. Improve Work procedure/Illustration on process no.5-Spot taping process. Standardized tube description: VM tube (Sunprene)	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
01/31/23	0	Initial issue.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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PARTS:

1. Assy parts
2. Black VM tube (Sunprene) $\varnothing 9$ L= 89 \pm 3mm

3. Black tape

JIG

n/a

NO.

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TOOLS/PPE

QUALITY POINTERS

2

Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ L= 89 \pm 3mm



1. Get the Black VM tube (Sunprene) $\varnothing 9$ L=89 \pm 3mm using right hand then insert the assy parts using left hand.

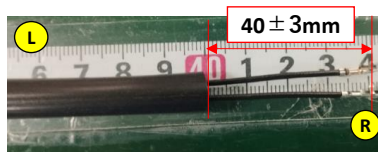
n/a

1. No wrong use of parts

3

P2

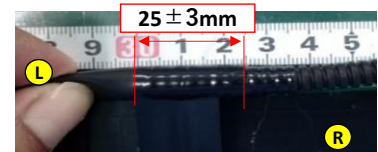
Taping 1
Black Corrugated tube to
Black VM (Sunprene)



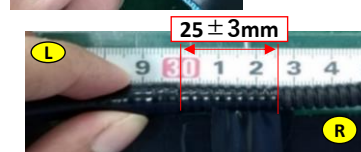
1. Measure from end of tube up to terminal pointed tip 40 \pm 3mm using both hands.



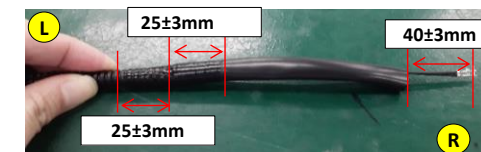
2. Hold the Assy parts using left hand, get the Black tape using right hand then start pre-taping using both hands.



3. Confirm measurement of 25 \pm 3mm from end of tape up to end of tube then continue the taping process using both hands.



4. Confirm measurement of 25 \pm 3mm from end of tube up to end of tape then continue the taping process using both hands.



5. After taping, check the measurement, terminal appearance and taping condition.

MEASURING TAPE



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

Important reminders/Note/s:

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

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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

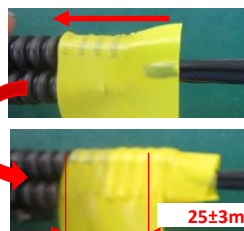
P2

Y-taping



No gap between tubes

1. Fix the corrugated tube and vinyl tube. Follow the correct connector orientation.

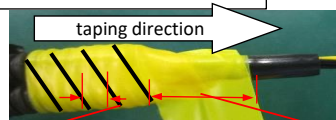


Note: Do not exert excessive force during pulling & winding of tape

25±3mm

2. Start taping at the middle of combined COT & SV tube (Vinyl), then wind the tape going to 2 corrugated tubes (2 windings), width must be same with tape (19mm)

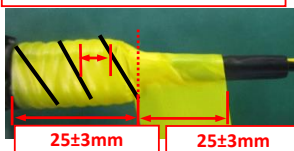
3. Wind the tape 1/3 shifting until it reach the vinyl tube (must be tape width)



tape shifting 1/3 below

25±3mm

Tape shifting 9mm below

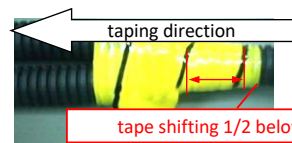


25±3mm

25±3mm

tape shifting 1/3 below

25±3mm



tape shifting 1/2 below

4. Wind the tape backward 1/2 shifting

25±3mm



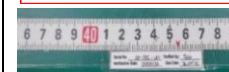
25±3mm

0 ~ 5mm

5. Wind the tape 1/2 shifting going to SV tube (Vinyl). Cover the SV tube (Vinyl) & wire 1/3 shifting. Measure SV tube (Vinyl) up to connector 25±3mm then make 3 winds on wire before cutting of tape.

6. Check the tape condition.

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

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. Used yellow tape to easily visualize the tape shifting but actual should be **BLACK TAPE**

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PARTS:

1. Assy parts
2. Black tape [2pcs]

JIG

1. Spot taping jig

NO.

PROCESS NAME



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TOOLS/PPE

QUALITY POINTERS

5

P2

Spot taping

Receiver base 1

COT GUIDE 1

COT GUIDE 2 w/ LOCK

1. Get the assy parts and set into spot taping jig using both hands. (See above picture for correct setting). First, set the connector 6098-3802 (W) in Receiver base 1. 2nd, Combine the 2 COT then set to COT guide 1 and COT guide 2 then lock.

2. Fix the 2 Corrugated tube. Get the black tape and start spot taping on **location 1 (left side) using right hands**. Make **2 windings** of tape (**Must be Tape width**) then cut the tape. Proceed to **location 2** then continue the process

3. Hold the black tape on **location 2 (right side)** and start spot taping using both hands. Make **2 windings** of tape (**Must be Tape width**) then cut the tape.

4. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.

1. No peel-off
2. No wrong location
3. No missing tape
4. Check the offset spot tape

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PARTS:

n/a

JIG**QUALITY CHECKPOINTS****P2****7N0175-7020**

1 No Missing Tape
on Y-taping and VM tube (Sunprene)

2 No Missing Spot Tape
(Conduct point checking for spot taping)

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