

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 27, 2021

Product Name/Code:

241B / 7L0049-7021A

Customer:

TRQSS

Document No.:

WI-ENG-PDE-176C

Purpose:


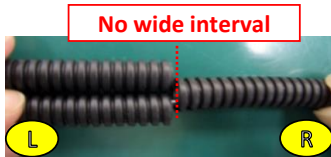


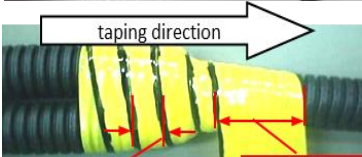





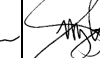
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Black tape 2. Assy parts				JIG:	n/a						
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS				
1	P3	Y-taping	<div><div></div><div></div><div><div>1. Fix the corrugated tube .</div><div></div><div><div>Note: Do not exert excessive force during pulling & winding of tape</div><div></div><div>25±3mm</div></div></div><div><div>taping direction</div><div></div><div>tape shifting 1/3 below</div><div>tape width</div></div><div><div>2. Start taping at the middle of combined Corrugated tubes, then wind the tape going to 2 corrugated tubes, width must be 25±3mm.</div><div>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)</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 workplace is prohibited. Keep it in your locker.</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>NOTE:</div><div>USED YELLOW TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL SHOULD BE BLACK.</div></div> <div><div>1. No tape peeling</div><div>2. No flip out of tape</div><div>3. No wide interval between the COT</div><div>4. No exposed wire</div><div>5.Y taping should be same facing</div></div> <div><div>Proper facing of Y taping</div><div><div>NG</div><div></div><div><div>GOOD</div><div></div></div></div></div>				
Revision History													
04/27/21	2	Change clamp colors in accordance with color standardization for plastic parts refer to GL-COM-003; Put assy parts on pg 2 parts section; Add tape qty on pg. 3 parts section; rephrase band cut instruction; put measuring tape illustration and instruction in measurment				J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	Prepared by	Reviewed by	Approved by	Noted by
09/30/20	1	Changed process owner from Production (WI-PRO-ASY-114B) to Engineering (WI-ENG-PDE-176B); Apply some improvements; Update some pictures				J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
03/16/18	0	Previously established Engineering Instruction (EI-ENG-PDE-026). Initial issue.				S. Manalo	R. Alcantara	A. Arañes	n/a	J. Loterte	C.Villanueva	A.Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change				Revise	Check	Approve	Noted	Est. Date:	November 8, 2018		

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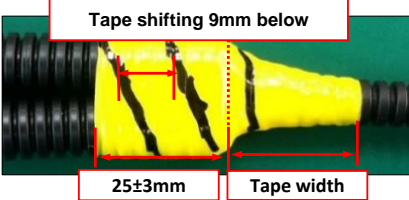
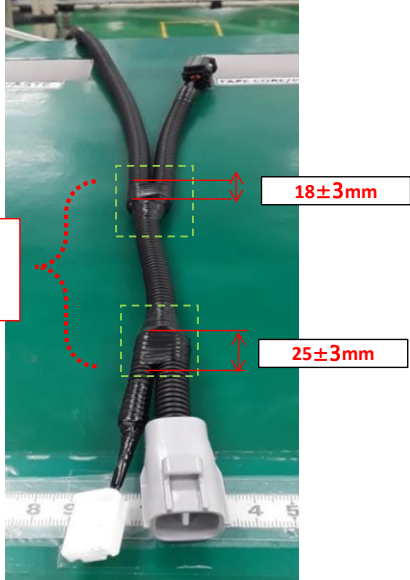




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PARTS:

1. Black tape
2. Assy parts

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3 Y-taping (continuation)	<div><p>taping direction</p><p>tape shifting 1/2</p></div> <div><p>Tape shifting 9mm below</p><p>25±3mm</p><p>Tape width</p></div> <div><p>4. Wind the tape backward 1/2 shifting.</p></div> <div><p>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.</p></div> <div><p>18±3mm</p><p>25±3mm</p><p>Check the proper Y taping orientation</p></div>	<div><p>MEASURING TAPE</p></div> <div><p> Note: Please use calibrated/verified measuring tape when getting the measurement.</p></div>	<p>NOTE: USED YELLOW TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL SHOULD BE BLACK.</p> <ol style="list-style-type: none">1. No tape peeling2. No flip out of tape3. No wide interval between the COT4. No exposed wire5. Y taping should be same facing <p>Proper facing of Y taping</p> <div><p>NG</p></div> <div><p>GOOD</p></div>

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PARTS:**2**

1. Clamp 82711-52090 (W) [2pcs]
2. Clamp 82711-16820 (BR) [2pcs]

2

3. Black tape [2pcs]

JIG

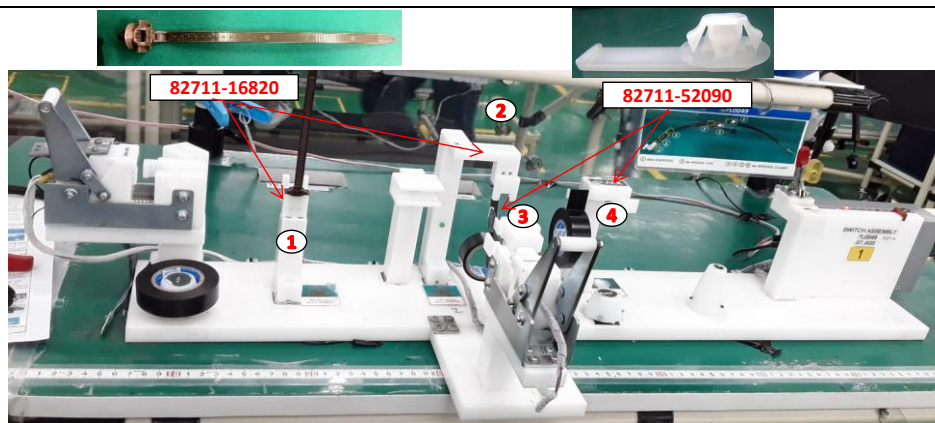
1. Clamp assembly jig

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

2

P3

Clamp assembly setting



1. Get 2pcs of clamp **82711-16820 (BR)** using right hand then set to jig location **1 & 2** using both hands.

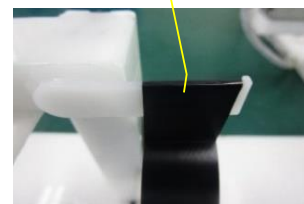
2

2. Get 2pcs of clamp **82711-52090 (W)** using right hand then set to jig location **3 & 4** using both hands.

3. Get Black tape and conduct pre-taping on location **3** and **4** using both hands.

STANDARD TAPING FOR CLAMP

One side tape under clamp



n/a

1. No damaged clamp
2. No wrong use of clamp
3. No wrong use of tape

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PARTS:

1. Assy parts

JIG

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

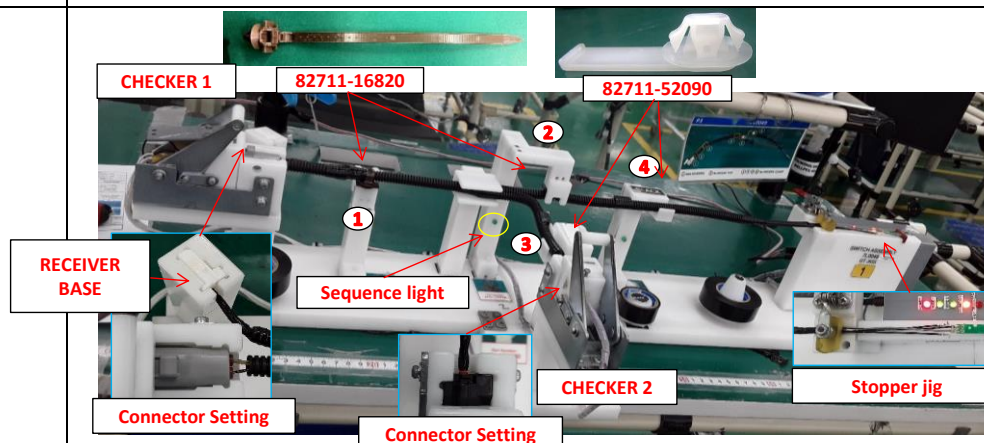
TOOLS/PPE

QUALITY POINTERS

3

P3

Clamp assembly



1. Get the assy parts using right hand and set to jig. Put the Gray connector on checker 1, White connector on receiver base, Black connector on checker 2 and put the wires on toggle clamp using both hands.

2. Check the LED light for **POWER, CLAMP, WIRE 1** and **WIRE 2** and **SEQUENCE LIGHT** was **ON**. If encountered abnormality, **STOP** the process, **CALL** the leader and **WAIT** for instruction.

3. Initially tighten the band clamp on location **1** and **2** using both hands.

4. Get the Bando gun using right hand and cut the band clamp on location **1** and **2**. Press the SW button after cutting.



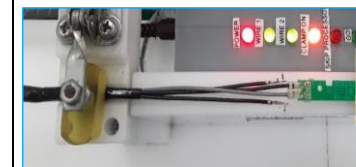
5. Tape the clamp on location **3** using both hands. Make **3 winds** and cut the tape. Press the SW button after taping. Repeat the process for location **4**.

6. Conduct **POINT CHECKING** before removal from jig.

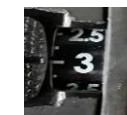
BANDO GUN



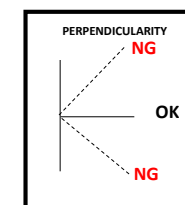
Note:
Make sure no clearance between PCB and stopper jig



1. No wrong setting of clamp
2. No wrong use of clamp
3. No Loose attachment of clamp
4. No wrong setting of Bando gun
5. No wrong use of tape
6. No peel off tape
7. No missing tape



BANDO GUN ALIGNMENT



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PARTS:

n/a

JIG

n/a

NO.

PROCESS NAME

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TOOLS/PPE

QUALITY POINTERS

4

Visual/By two's inspection

1. Check the terminal appearance.

2. Check the clamp attachment, alignment and taping condition.

3. Check the connector if properly locked.

4. Using steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.

0 - 2 mm

5. Compare to Master sample.
Refer to GL-PRO-ASY-007 for By two's inspection of sub-assy.

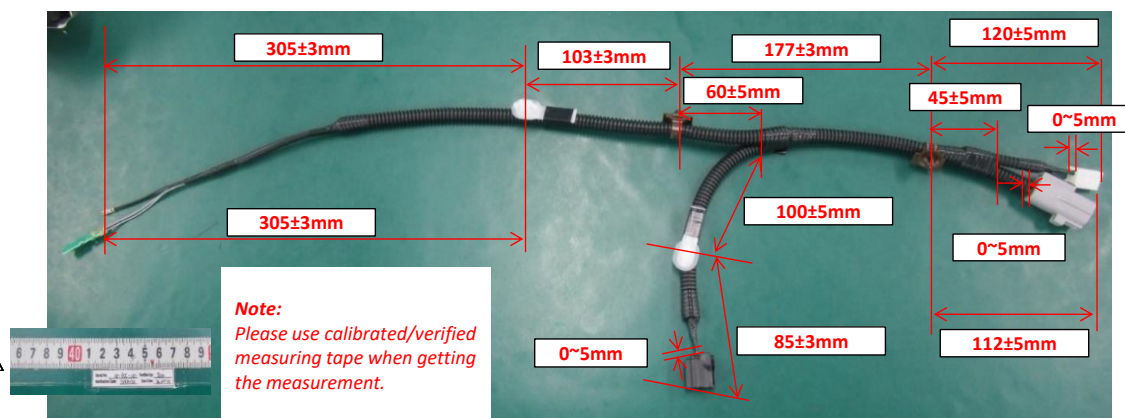
MASTER SAMPLE



P3

5

Measurement



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