

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 13, 2022

Model Code/Part Number:

100B / 7M0592-7021

Customer:

TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-423C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 7

PARTS: 1. Assy parts; Black tape [2pcs.]

JIG:

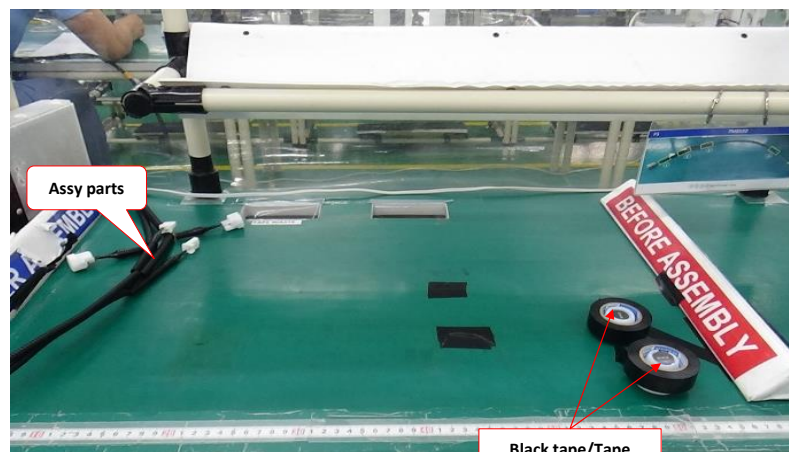
n/a

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

1

P3

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
12/13/22	1	Improve quality pointers: Reminders/notes and references. Inclusion of Quality checkpoints	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
02/24/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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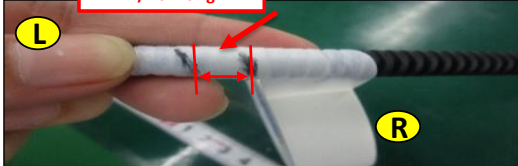
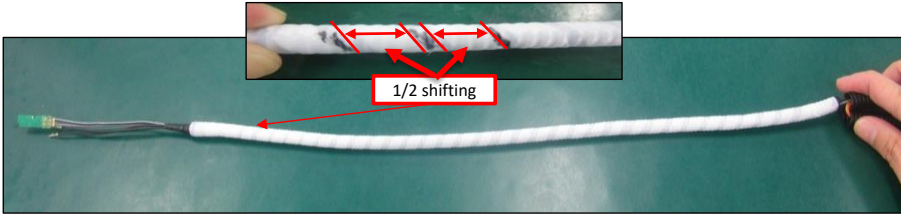

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	1 QUALITY POINTERS
2	P3 Taping 1 Half-wrap taping	<div><p>Start of taping</p><p>1. Hold the corrugated tube using left hand and begin taping using right hand.</p></div> <div><p>1/2 shifting</p><p>2. Make 1/2 shifting. Repeat the process until the end of corrugated tube. Make 3 windings and then cut the tape.</p></div> <div><p>3. Check the taping condition.</p></div>	<p>MEASURING TAPE</p> 	<p>Important reminders/Note/s:</p> <p>1. Use WHITE TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. 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 dimension 6. No wrong use of tape</p>

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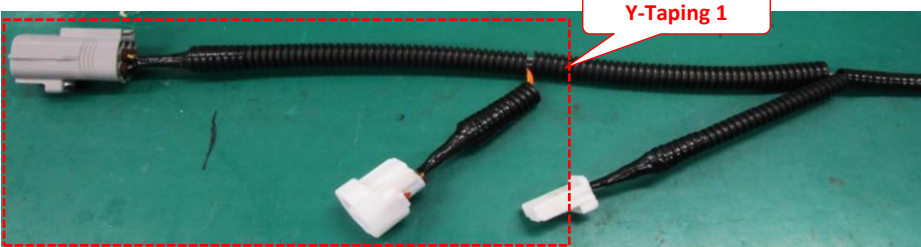

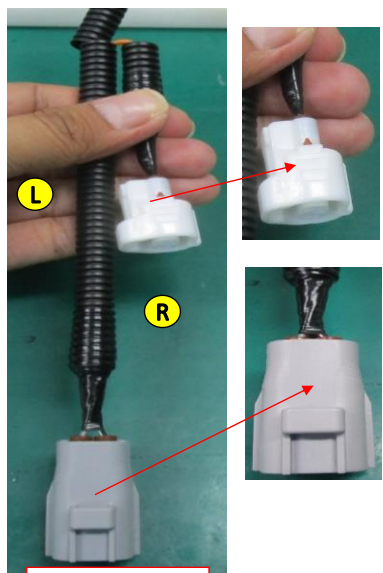

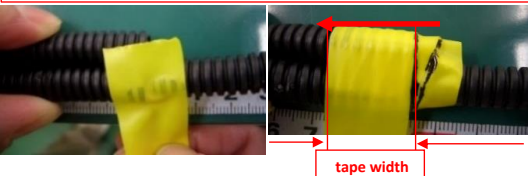

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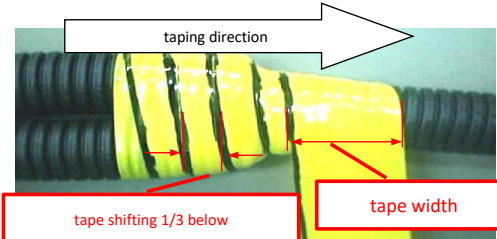
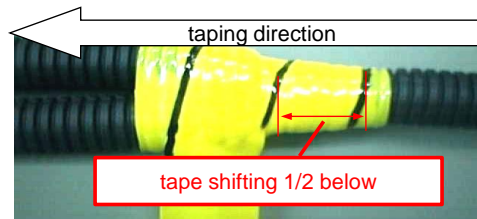
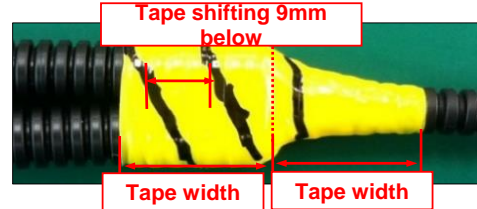
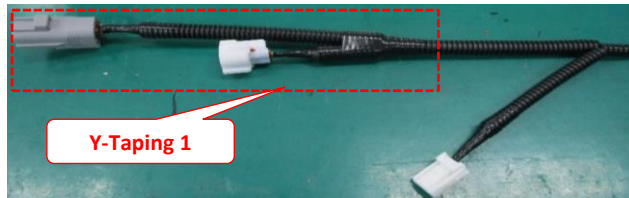

PARTS:		1. Assy parts 2. Black tape		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
3	P3 Taping 2 Y- Taping (1)	<div></div> <div></div> <div></div> <div></div> <div><p>1. Fix the corrugated tube . Follow the correct orientation of connectors.</p><p>Note: Do not exert excessive force during pulling & winding of tape</p></div> <div><p>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side , width must be same with tape (19mm)</p></div>			<p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape

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PARTS:		1. Assy parts 2. Black tape		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
3	P3 Taping 2 Y- Taping (1) (Continuation)	 <p>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)</p>  <p>4. Wind the tape backward 1/2 shifting</p>  <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> 			<p>Important reminders/Note/s:</p> <p>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. 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 dimension 6. No wrong use of tape</p>

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

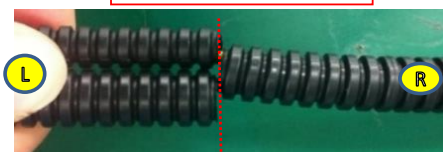
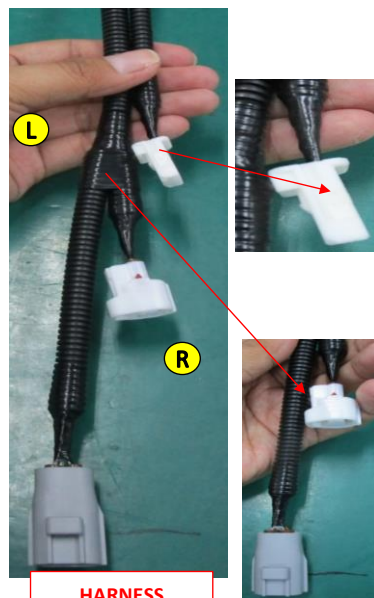
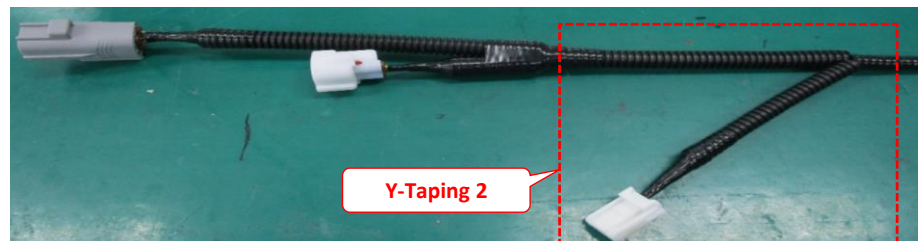
TOOLS/PPE

1 QUALITY POINTERS

4

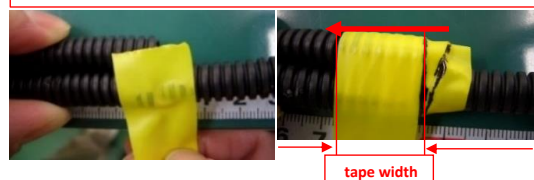
P3

**Taping 3
Y- Taping (2)**



1. Fix the corrugated tube . Follow the correct orientation of connectors.

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



2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side , width must be same with tape (19mm)

MEASURING TAPE



Important reminders/Note/s:
1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.
2. Please use calibrated/verified measuring tape when getting the measurement.

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

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1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

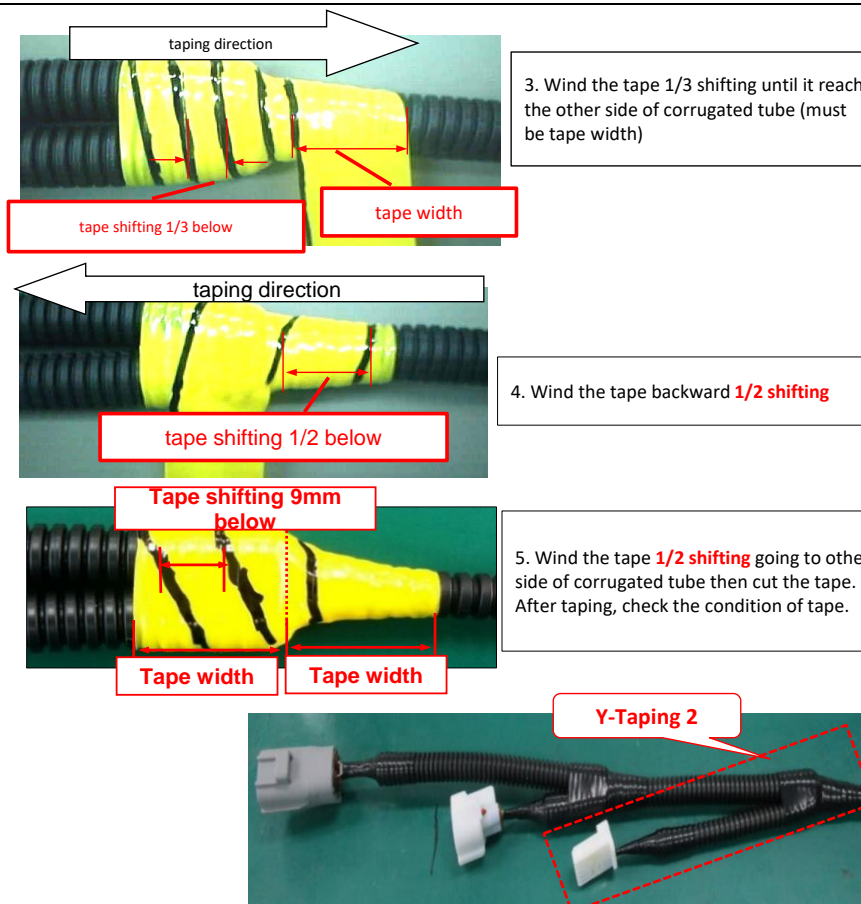
TOOLS/PPE

1 QUALITY POINTERS

4

P3

Taping 3
Y- Taping (2)
(Continuation)



3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)

4. Wind the tape backward 1/2 shifting

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.

MEASURING TAPE



Important reminders/Note/s:
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PARTS:

1. Assy parts

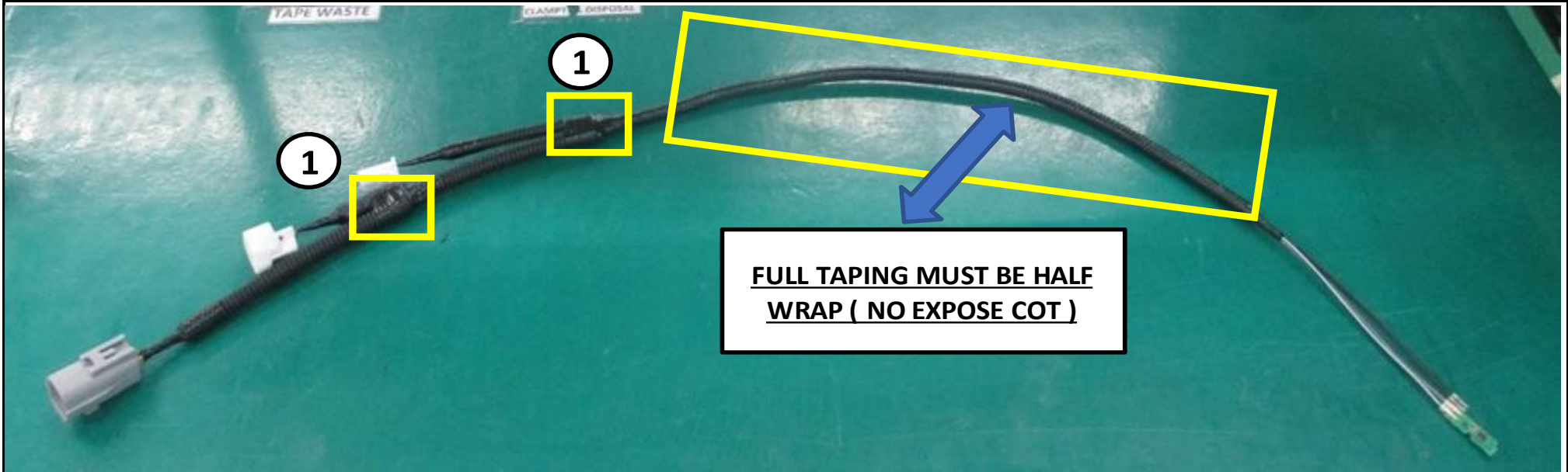
JIG

n/a

1 QUALITY CHECKPOINTS

P3

7M0592-7021



1 NO Missing Tape
CORRECT FACING OF Y-TAPING

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