



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

April 20, 2021

Process Name/Title:

Validity Date:

n/a

Product Name/Code: 310B / 7M0521-7020A

Customer:

TRJ

Document No.:

WI-ENG-PDE-164B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

1 of 4

PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

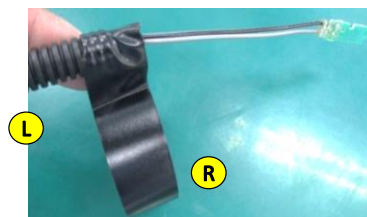
TOOLS/PPE

QUALITY POINTERS

1

P2

Taping 1
Black corrugated tube to
wire near hotmelt

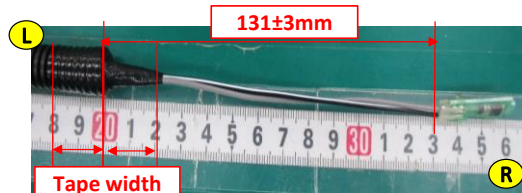


1. Hold the corrugated tube $\phi 7$ $L=460\pm 4mm$ using left hand then start taping between COT and wire using right hand.



2. Measure from end of the corrugated tube up to edge of hotmelt $131\pm 3mm$ then continue the taping process.

Note: Refer to WI-PRO-ASY-001 for taping procedure



3. After taping, check the measurement and tape 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**Note:**

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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/20/21	3	Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
10/10/20	2	Changed effectivity and validity date. Remove cycle time	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
07/02/18	n/a	Initially established as Engineering instruction (EI-ENG-PDE-043) . Initial issue.	S. Manalo	R. Alcantara	A. Arañes	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

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PARTS:

1. Assy parts
2. Black sunprene tube $\phi 11$ L=120 \pm 3mm
3. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

Taping 1
Black corrugated tube to
wire near hotmelt



1. Get the sunprene tube $\phi 11$ L=120 \pm 3mm using right hand then insert the GR-B/W wire using left hand.

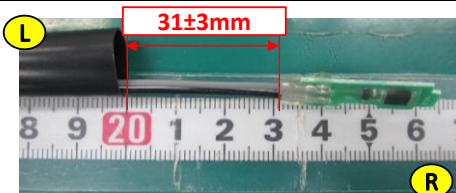
n/a

1. No wrong use of parts

3

P2

Taping 2
Black Sunprene tube to
Black Corrugated tube



1. Measure from end of the sunprene tube up to edge of hotmelt 31 ± 3 mm.



2. Hold the sunprene tube using left hand then start taping using right hand.
Note: Refer to WI-PRO-ASY-001 for taping procedure

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



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

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TOOLS/PPE

QUALITY POINTERS

4

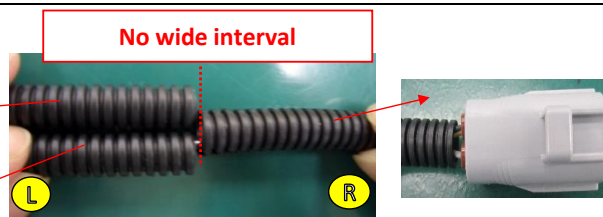
P2

Y-taping

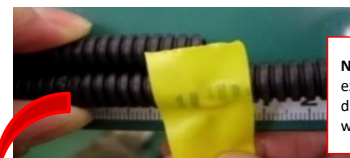
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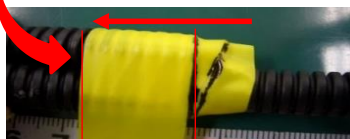
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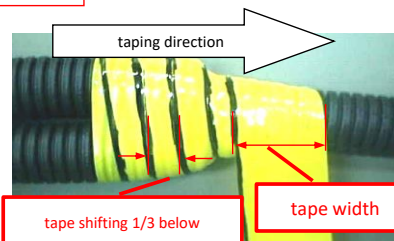
1. Fix the corrugated tube .



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)



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

n/a

NOTE:
USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES BUT ACTUAL SHOULD BE BLACK 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

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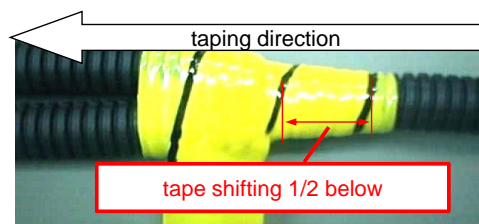
TOOLS/PPE

QUALITY POINTERS

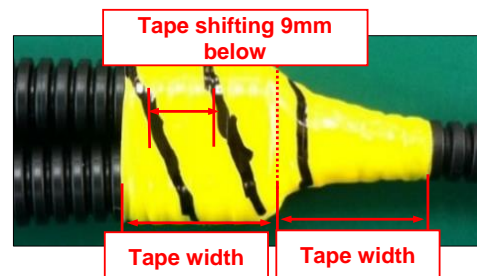
4

P2

Y-Taping
(Continuation)



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.

3

MEASURING TAPE



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2. No peel-off tape
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