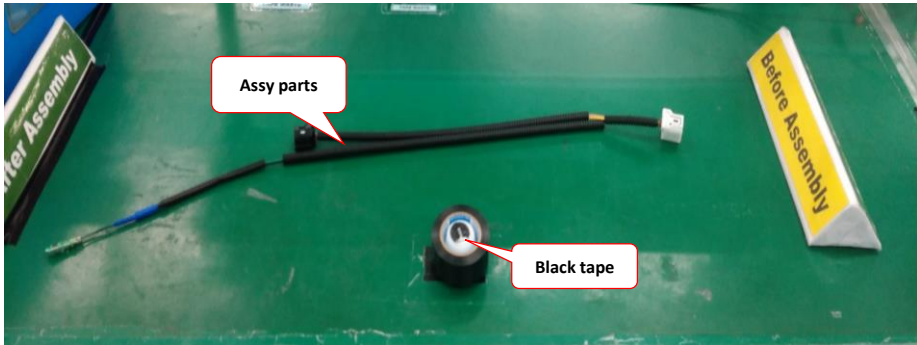
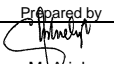
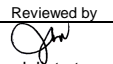
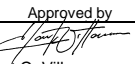
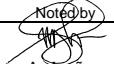
	WORK INSTRUCTION				Effectivity Date:		March 10, 2023	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model Code/Part Number: 920B / 7R0117-7021		Customer: TRMX		Document No.:		WI-ENG-PDE-646B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO		Revision No.:		0		Page No.: 1 of 5	

PARTS:		1. Assy parts: Black tape		JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P2	<div style="text-align: center;"> Table Lay-out </div> 		<div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping</p> <ol style="list-style-type: none"> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>		<ol style="list-style-type: none"> 1. No missing parts/tools 2. No excess parts/tools 	

Revision History								Prepared by	Reviewed by	Approved by	Noted by		
03/10/23	0	Initial issue. Clamp 82711-12A60 (W) quantity from [2pcs] to [1pc] . Clamp 82711-3A640 (B); Wire length B/W and G wires from L=624±3mm to L=645±3mm; COT length from 350mm to 371mm				M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	March 10, 2023		

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 10, 2023

Process Name/Title:

Validity date

n/a

Model Code/Part Number: 920B / 7R0117-7021

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PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

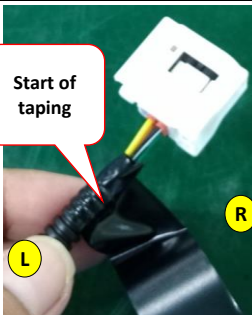
TOOLS/PPE

QUALITY POINTERS

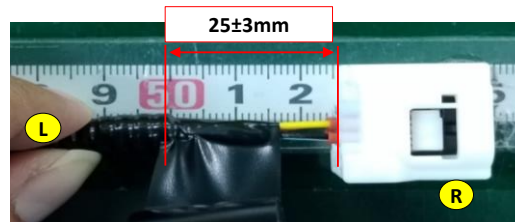
2

P2

Taping 1
COT to wire near
connector



1. Hold the COT then get **Black tape** using right hand then start taping process using both hands.

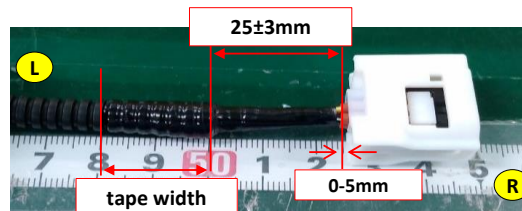


2. Measure from end of COT up to edge of connector **25±3mm** then continue the taping process using both hands.

MEASURING TAPE



1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension



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

Important reminders/Note/s:

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

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

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Model Code/Part Number: **920B / 7R0117-7021**

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☐ PROTOTYPE

☒ PRE-LAUNCH

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P2

Taping 2
COT to Black VM tube
(Sunprene) near PCB

Start of taping

L

R

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

176±3mm

L

R

2. Measure from end of COT up to PCB **176±3mm** then continue the taping process using both hands.

MEASURING TAPE

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

L

176±3mm

R

tape width

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

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PROTOTYPE



PRE-LAUNCH



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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	n/a	<p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</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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☐ PROTOTYPE

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PARTS:

n/a

JIG

n/a

QUALITY CHECKPOINTS

P2

7R0117-7021



① ② ③ No MISSING TAPE

④ Correct Facing of Y-taping

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