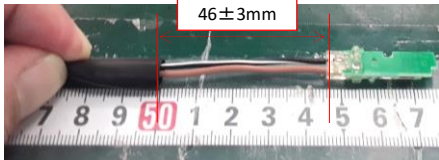
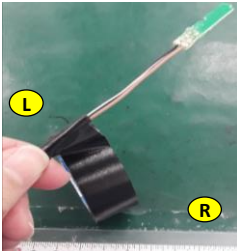
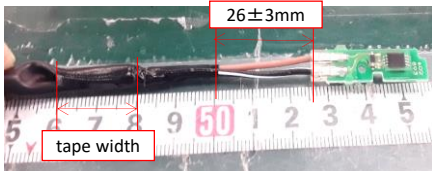

	WORK INSTRUCTION		Effectivity Date:	October 13, 2021	
	Process Name/Title: TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model Code/Part Number: ES1 / 7M0508-7020B	Customer: TRJ	Document No.:	WI-ENG-PDE-039A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE -LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	7	Page No.

PARTS:	1. Pre-assy parts from Kitting (MR SW CP consist of AVSSf wires BR/BW L=740; Black Vinyl tube Ø5 L= 38±3; Connector 7C83-5524-70 (Y); Black COT Ø7 L= 619±4 (no slit)	2. Black tape	JIG:	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Taping 1 Vinyl tube to wire	 <p>1. Measure from vinyl tube to edge of hotmelt 46mm.</p>  <p>2. Hold the vinyl tube using left hand and start taping using right hand. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>3. After taping, check the dimension and taping condition.</p>	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <p>MEASURING TAPE</p>  <p><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></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

Revision History								Prepared by:	Reviewed by:	Approved by:	Noted by:
10/13/21	7	Removal of pushing process.	K. Doria	J. Loterte	C. Villanueva	A. Arañes					
04/29/21	6	Remove validity date	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes					
10/23/20	5	Remove cycle time; Apply some improvements; update pictures	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes					
03/06/18	n/a	Previously established Engineering instruction (EI-ENG-PDE-020). Initial issue.	S. Manalo	R. Alcatara	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change				Revise	Check	Approve	Noted	Established Date:	September 24, 2018

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

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n/a

Document No.:

WI-ENG-PDE-039A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


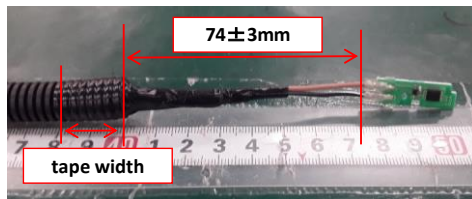
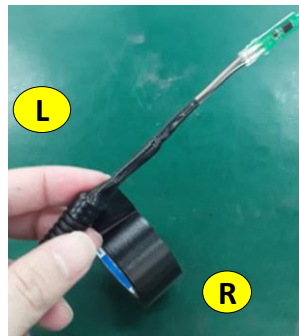

☒ MASSPRO

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PARTS:		1. Black tape 2. Assy parts		JIG	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div><div><p>1. Measure the COT up to the edge of hotmelt 74±3mm using both hands.</p></div><div><p>3. After taping, check the dimension and taping condition.</p></div><div><p>2. Hold the corrugated tube using left hand and begin taping using right hand. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure</i></p></div></div> <div><p>MEASURING TAPE</p></div> <div><p><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p><p>1. No loose tape 1. No flip-out ape 3. No peel-off tape</p></div>			

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