

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**Model Code/ Part Number: **780B / 7R0102-7022**Customer: **TRMX**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

February 19, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-417B

Revision No.:

0

Page No.:

1 of 4

PARTS:

1.All parts; Assy parts; Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out	<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i> 1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape

Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by:	Reviewed by:	Approved by:	Noted by:
02/19/22	0	Initial Issue	M.Ariola	J. Loterte	C.Villanueva	A. Arañes				

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PARTS:

1. Black tape
2. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

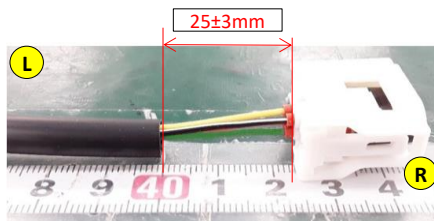
TOOLS/PPE

QUALITY POINTERS

2

P2

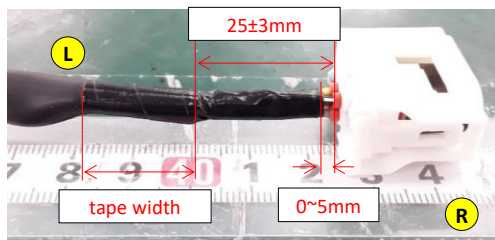
Taping 1
Vinyl tube to wire near
connector



1. Hold the Vinyl tube using left hand. Measure the end of Vinyl up to the connector **25±3mm** using right hand.



2. Hold the Vinyl tube using left hand. Get the Black tape using right hand and start taping.
Refer to WI-PRO-ASY-001 for taping procedure.



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

MEASURING TAPE



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

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

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PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Black tape
2. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P2

Taping 2
COT to Sunprene



1. Hold the COT using left hand. Measure the end of COT up to the edge of hotmelted wire **176±3mm** using right hand.



2. Hold the COT using left hand. Get the Black tape using right hand and start taping.
Refer to WI-PRO-ASY-001 for taping procedure.



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

MEASURING TAPE



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

Note:

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

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PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Y-taping	MEASURING TAPE	<p>Note: Used Yellow tape to easily visualize the tape shifting. But actual should be Black.</p> <ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wide interval between the COT5. No wrong use of tape <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Connector Orientation</p>

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