



# WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 5, 2022

Model Code/Part Number:

724W

/

7H0350W7020D

Customer:

NBS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

WI-ENG-PDE-475

Revision No.:

1

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## PARTS:

1. Assy parts; Black vinyl tube  $\phi 5$  L=130 $\pm$ 3mm; Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

n/a

Table Lay-out

Assy parts

TABLE LAY-OUT

Black vinyl tube  $\phi 5$   
L=130 $\pm$ 3mm

Black tape

### 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 work place 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             | Revise   | Check      | Approve       | Noted     | Prepared by | Reviewed by    | Approved by | Noted by |
|-----------|---------|-------------------------------|----------|------------|---------------|-----------|-------------|----------------|-------------|----------|
| 05/5/22   | 1       | Change Pre-launch to Masspro. | K. Doria | J. Loterte | C. Villanueva | A. Arañes |             |                |             |          |
| 04/19/22  | 0       | Initial Issue.                | K. Doria | J. Loterte | C. Villanueva | A. Arañes |             |                |             |          |
| Eff. Date | Rev. No | Details of Change             | Revise   | Check      | Approve       | Noted     | Est. Date:  | April 19, 2022 |             |          |

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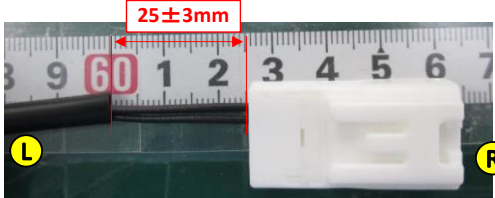

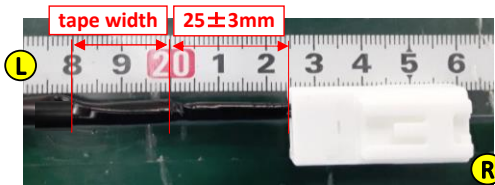

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|               |   |   |  |   |  |
|---------------|---|---|--|---|--|
| <b>PARTS:</b> | 1. Assy part<br>2. Black vinyl tube $\phi 5$ L=130 $\pm$ 3mm<br>3. Black tape |   |  | <b>JIG</b>  | n/a  |
| <b>NO.</b>    | <b>PROCESS NAME</b>   | <b>WORK PROCEDURE/ ILLUSTRATION</b>   |  | <b>TOOLS/PPE</b>  | <b>QUALITY POINTERS</b>  |
| 2             | Wire insertion to Black vinyl tube $\phi 5$ L=130 $\pm$ 3mm                   |  <p>1. Get the black vinyl tube <math>\phi 5</math> L=130<math>\pm</math>3mm using right hand then insert the <b>B-B wires</b> using left hand.</p>   |  | n/a   | 1. No wrong usage of parts<br>2. No deformed terminal  |
| 3             | Taping 1<br>Black vinyl tube to wire near terminal                            |  <p>1. Hold the black vinyl tube using left hand then measure from end of the tube up to connector <b>25<math>\pm</math>3mm</b> using both hands.</p>  <p>2. Get the <b>Black tape</b> using right hand then start taping process using both hands.<br/><i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>3. After taping, check the measurement, wire alignment and taping condition.</p> |  |  <p><b>MEASURING TAPE</b></p> | <p><i>Note:</i><br/>Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip-out tape<br/>2. No peel-off tape<br/>3. No loose tape<br/>4. No missing tape<br/>5. No wrong dimension<br/>6. No wrong use of tape</p> |

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n/a

**JIG**

n/a

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

4

Visual/  
By two's inspection

1. Check the connector lock and taping condition.

2. Check the terminal appearance. Make sure no deformed terminal.



3. Compare to Master Sample

*Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy***MASTER SAMPLE**

5

Measurement

**MEASURING TAPE***Note:**Please use calibrated/verified measuring tape when getting the measurement.***NOTE: FOR HATSUMONO AND OWARIMONO**

1. No wrong dimension

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