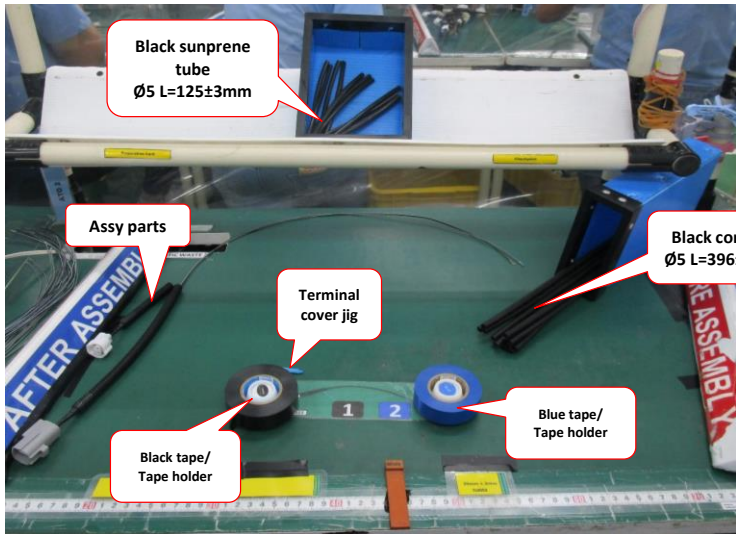
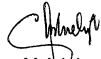



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	Process Name/Title: TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Model Code/Part Number: 150B / 7L0059-7023				Customer: TRQSS		Document No.:		WI-ENG-PDE-435B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		2 Page No.: 1 of 6	

PARTS:			1. Assy parts; Black sunprene tube Ø5 L=125±3mm; Black corrugated tube Ø5 L=396±3mm (no slit); Black tape; Blue tape				JIG:		1. Terminal cover jig		
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1		P2		<div style="border: 1px solid red; padding: 5px; text-align: center;"> TABLE LAY-OUT </div> 				<div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>		<div style="border: 1px solid black; padding: 5px;"> <p>1. No missing parts/tools 2. No excess parts/tools</p> </div>	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
12/17/22 2 Improve Quality pointers: Reminders/notes and references on pages no. 2,3,4 and 5. Inclusion of Quality checkpoints															
05/23/22 1 Change from Pre-Launch to Masspro.								M. Ariola		J. Loterte		C. Villanueva		A. Arañes	
Eff. Date Rev. No Details of Change								Revised Reviewed Approved Noted		Est. Date:		February 24, 2022			

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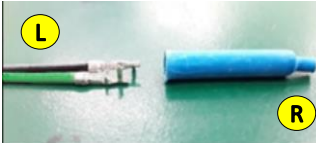

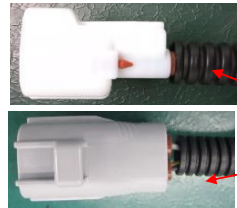


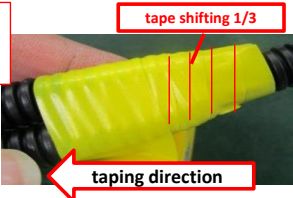
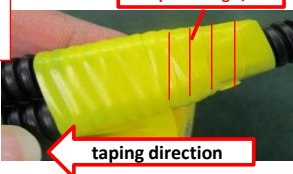
PARTS:

1. Assy parts
2. Black corrugated tube (no slit) Ø5 L=396±3mm

3. Black tape

JIG

1. Terminal cover jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black corrugated tube (no slit) Ø5 L=396±3mm	<div><p>1. Get the terminal cover jig using right hand then insert the G and B/W wires.</p></div> <div><p>2. Get the Corrugated Ø5 L=396±3mm (no slit) using right hand and insert the G and B/W wires</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>	<div>TERMINAL COVER JIG</div> 	<ol style="list-style-type: none">1. No wrong usage of parts2. No deformed terminal
3	Y-Taping	<div><p>1. Fix the corrugated tube</p></div> <div><p>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side.</p></div> <div><p>Note: Do not exert excessive force during pulling & winding of tape</p></div> <div><p>tape shifting 1/3</p></div> <div><p>taping direction</p></div>	n/a	<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 <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.2. Please use calibrated/verified measuring tape when getting the measurement.

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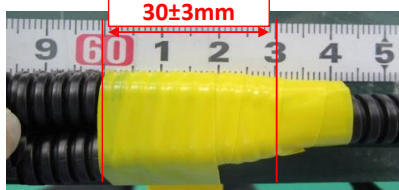
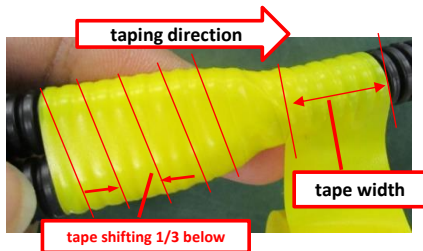
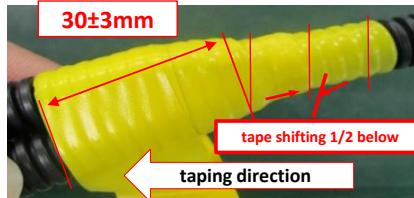
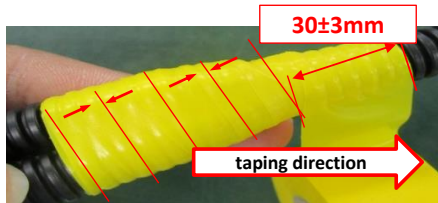
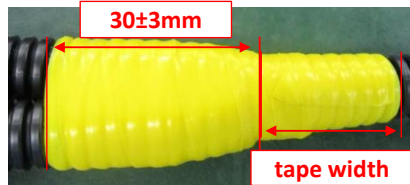

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Y-Taping (Continuation)	<div><p>30±3mm</p></div> <div><p>taping direction</p><p>tape width</p><p>tape shifting 1/3 below</p></div> <div><p>3. Confirm 30±3mm measurement from end of tape up to end of corrugated tube then continue the taping process using both hands.</p></div> <div><p>30±3mm</p><p>tape shifting 1/2 below</p><p>taping direction</p></div> <div><p>4. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width).</p></div> <div><p>5. Make 2 windings of tape then wind 1/2 shifting going to other side.</p></div> <div><p>30±3mm</p><p>taping direction</p><p>tape width</p></div> <div><p>30±3mm</p><p>tape width</p></div> <div><p>6. Make 2 windings of tape then wind the tape 1/2 shifting going to other side of corrugated tube then make 3 windings of tape and cut.</p></div> <div><p>7. After taping, check the measurement and tape condition.</p></div>	<div>MEASURING TAPE</div> 	<div>2 Important reminders/Note/s:</div> <ol style="list-style-type: none">1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.2. Please use calibrated/verified measuring tape when getting the measurement.

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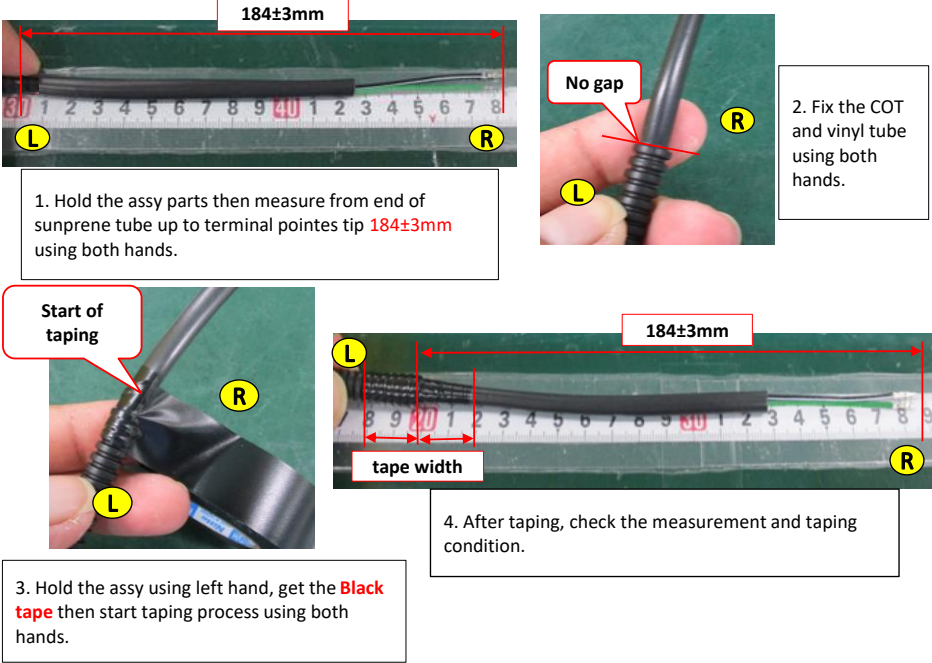


PARTS:

1. Assy parts
2. Sunprene tube Ø5 L=125±3mm

3. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black sunprene tube Ø5 L=125±3mm	 <p>1. Get the sunprene tube Ø5 L=125±3mm using right hand and then insert the G-B/W wires using left hand.</p>	n/a	<ol style="list-style-type: none">1. No deformed terminal2. No wrong usage of parts.
5	Taping 2 Black COT to Black sunprene tube	 <p>1. Hold the assy parts then measure from end of sunprene tube up to terminal point tip 184±3mm using both hands.</p> <p>2. Fix the COT and vinyl tube using both hands.</p> <p>3. Hold the assy using left hand, get the Black tape then start taping process using both hands.</p> <p>4. After taping, check the measurement and taping condition.</p>	 <p>MEASURING 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 <p>Important reminders/Note/s: </p> <ol style="list-style-type: none">1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.2. Please use calibrated/verified measuring tape when getting the measurement.

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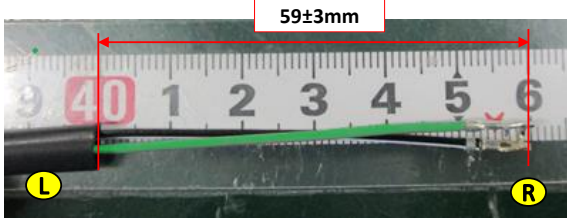
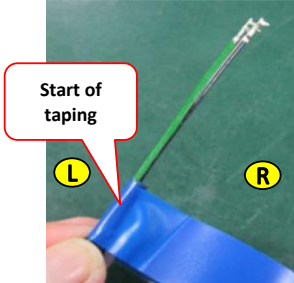
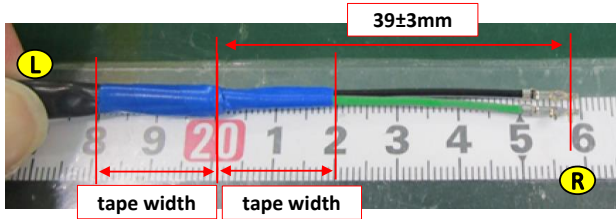

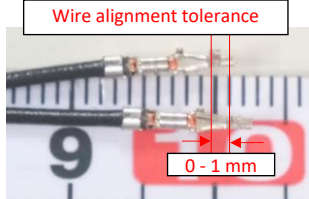
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PARTS:

1. Assy parts
2. Blue tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2 Taping 3 Black COT to wire near terminal	<div></div> <div></div> <div></div> <div><p>1. Hold the assy parts using left hand, measure from end of sunprene tube up to end of terminal pointed tip 59±3mm using both hands.</p><p>2. Hold the sunprene tube using left hand, get the Blue tape then start taping process using both hands.</p><p>3. After taping, check the measurement, wire alignment and taping condition.</p></div>	<div></div>	<div><p>1. No flip-out tape</p><p>2. No peel-off tape</p><p>3. No loose tape</p><p>4. No missing tape</p><p>5. No wrong dimension</p><p>6. No wrong use of tape</p></div> <div><p>2 Important reminders/Note/s:</p><p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p><p>2. Please use calibrated/verified measuring tape when getting the measurement.</p><p>3. Use BLUE TAPE only.</p></div> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div>

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PARTS:

n/a

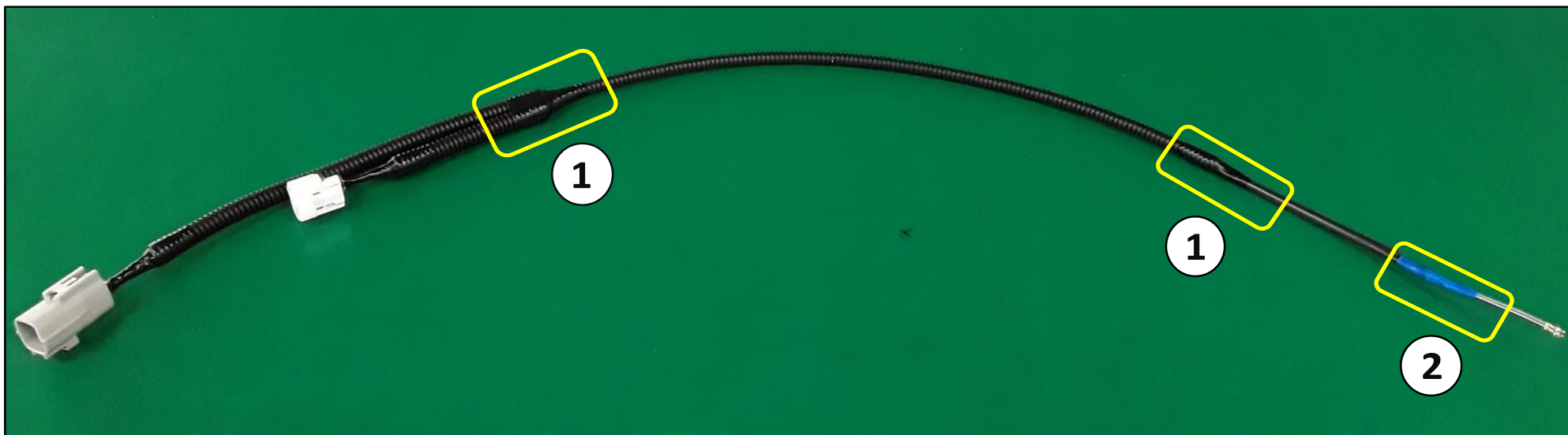
JIG

n/a

2 QUALITY CHECKPOINTS

P2

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1

No Missing Tape
(y-taping)

2

No Wrong Used of tape
(blue tape)

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