



WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Product Name/Code: **100B / 7M0593-7020B** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

April 17, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-154C

Revision No.:

3

Page No.:

1 of 6

PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

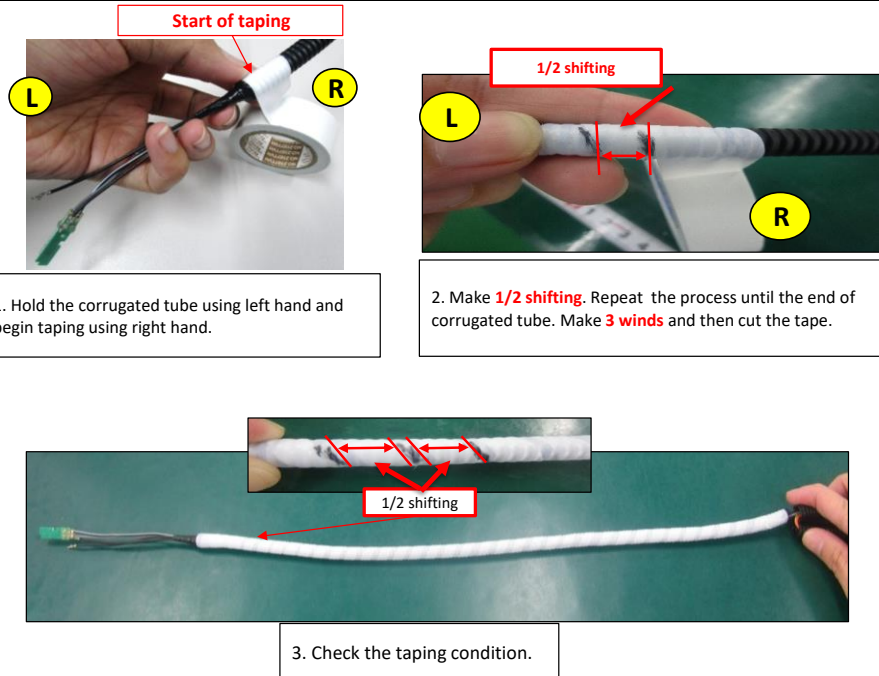
TOOLS/PPE

QUALITY POINTERS

1

P3

Half-wrap taping



1. Hold the corrugated tube using left hand and begin taping using right hand.

2. Make **1/2 shifting**. Repeat the process until the end of corrugated tube. Make **3 winds** and then cut the tape.

3. Check the taping condition.

Safety Instruction

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace 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 peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape
5. No exposed COT

NOTE: USE WHITE TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/17/21	3	Apply some improvements. Put assy parts in parts section.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
09/30/20	2	Changed effectivity and validity date. Remove cycle time.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
04/10/18	0	Previously established as Engineering instruction. Initial issue	J. Loterte	R. Alcantara	A. Arañes	n/a	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **100B / 7M0593-7020B**

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

April 17, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-154C

Revision No.:

3

Page No.:

2 of 6**PARTS:****3**

1. Assy parts
2. Black tape

JIG

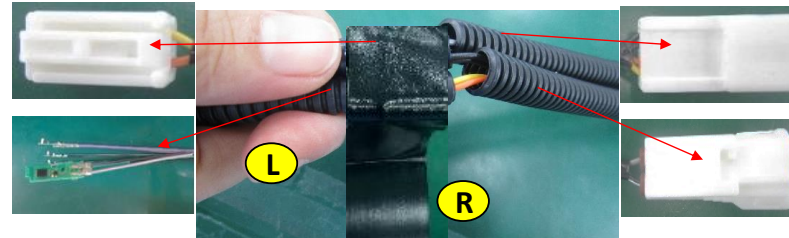
1. T-Taping jig

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

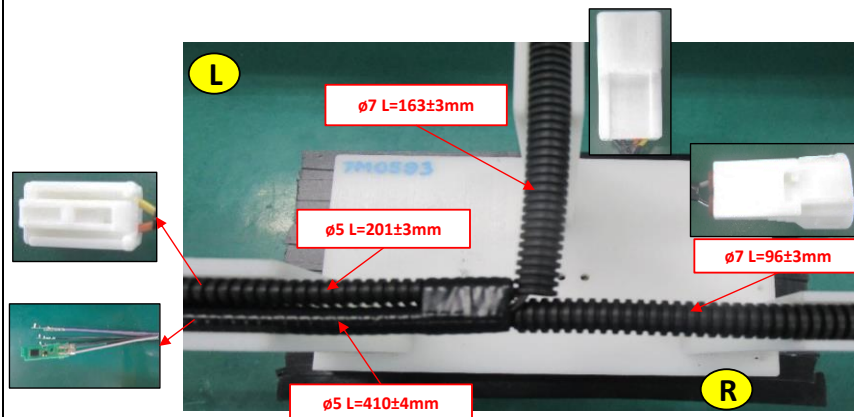
2

P3

T-taping



1. Align both COT $\phi 5$. (Follow the correct orientation of connector). Tape 2 winds using black tape then cut the tape.



2. Arrange the 4 corrugated tube to form inverted T into jig using left and right hand.

T-TAPING JIG

1. No flip out tape
2. No tape peeling
3. No loose tape
4. No wrong use of tape

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 17, 2021

Process Name/Title:

Product Name/Code:

100B / 7M0593-7020B

Customer:

TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-154C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

3 of 6

PARTS:

3

1. Assy parts
2. Black tape

JIG

1. T-Taping jig

NO.

PROCESS NAME

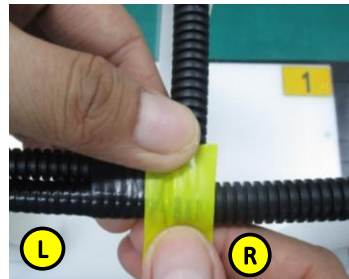
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

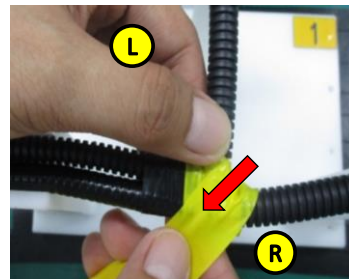
P3

T-taping
(Continuation)

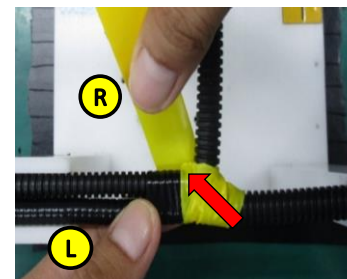
3. Start taping at the middle to fix the 4 corrugated tubes using right hand.



4. Wind the tape from front to back at the right side



5. Wind the tape from back to front (**cross pattern**)



6. Wind the tape from front to back at the left side

T-TAPING JIG



1. No flip out tape
2. No tape peeling
3. No loose tape
4. No wrong use of tape
5. No wrong dimension

3

NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **100B / 7M0593-7020B**

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

April 17, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-154C

Revision No.:

3

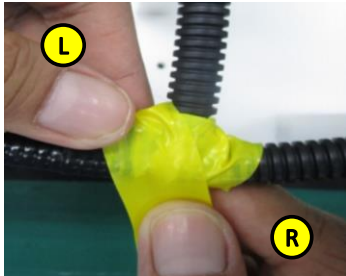
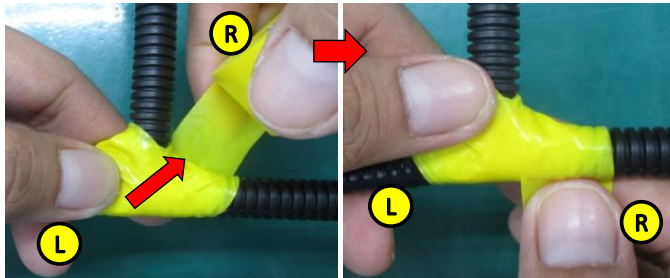
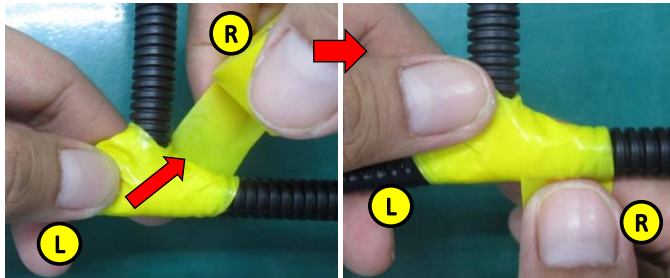
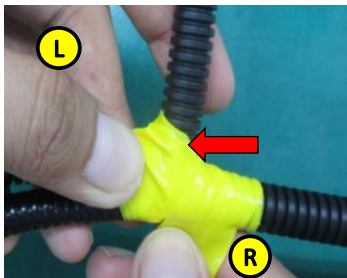
Page No.:

4 of 6**PARTS:****3**

1. Assy parts
2. Black tape

JIG

1. T-Taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3 T-taping (Continuation)	<div><p>7. Wind the tape from back to front (cross pattern)</p></div> <div><p>8. Repeat the process from 4-6, 3 times then remove from jig.</p></div> <div><p>9. Tape the right side corrugated tube (3 winds), width must be same as tape (19mm)</p></div> <div><p>10. From the right side, wind the tape 2/3 shifting going to center</p></div>	n/a	<div>3</div> <div>NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</div> <div><ol style="list-style-type: none">1. No flip out tape2. No tape peeling3. No loose tape4. No wrong use of tape5. No wrong dimension</div>

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Product Name/Code: **100B / 7M0593-7020B**

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

April 17, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-154C

Revision No.:

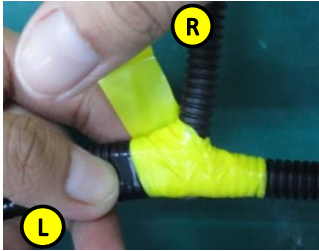
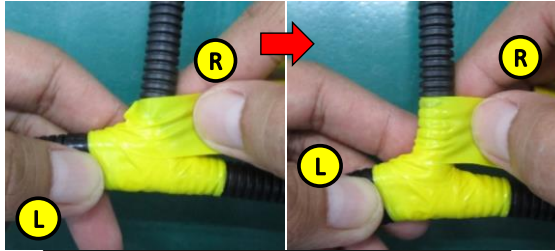
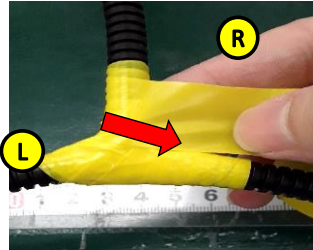
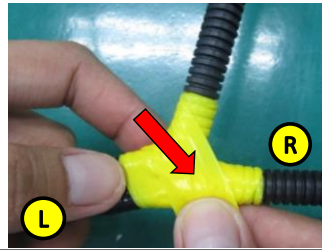
3

Page No.:

5 of 6**PARTS:****3**

1. Assy parts
2. Black tape

JIG**n/a**

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3 T-taping (Continuation)	<div><p>11. Wind the tape from front to back side (cross pattern)</p></div> <div><p>12. Tape the top side corrugated tube (3 winds), width must be same as tape (19mm)</p></div> <div><p>13. From the top side, wind the tape 2/3 shifting going to center</p></div> <div><p>14. Wind the tape going to front side (cross pattern)</p></div>	n/a	<div>3</div> <div>NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</div> <div><ol style="list-style-type: none">1. No flip out tape2. No tape peeling3. No loose tape4. No wrong use of tape5. No wrong dimension</div>

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Product Name/Code: **100B / 7M0593-7020B**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 17, 2021

Validity Date:

n/a

Document No.:

WI-ENG-PDE-154C

Revision No.:

3

Page No.:

6 of 6

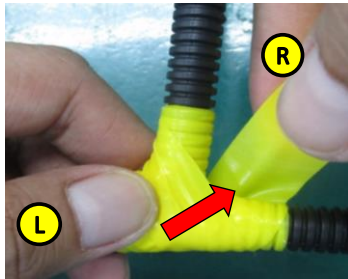
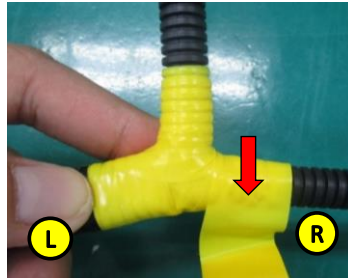
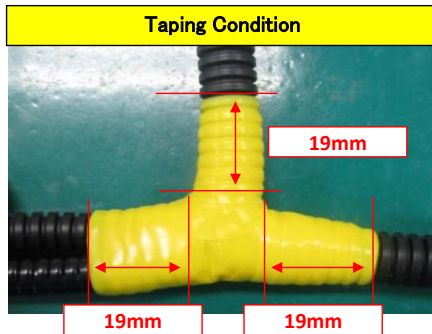

PARTS:

3

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3 T-taping (Continuation)	<div><p>15. Wind the tape from front to back side (cross pattern)</p></div> <div><p>16. Tape the right side corrugated tube (3 winds), width must be same as tape (19mm)</p></div> <div><p>Taping Condition</p><p>19mm</p><p>19mm</p><p>19mm</p></div> <p>17. After taping, check the measurement and condition of tape.</p>	<p>MEASURING TAPE</p> 	<p>NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</p> <p>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</p> <p><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></p>

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)
MASTER COPY**

DCC Stamp