



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

May 04, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: 014B / 17J796-7051Y

Customer:

NBS

Document No.:

WI-ENG-PDE-492E

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:


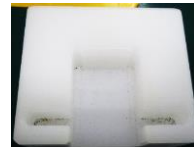
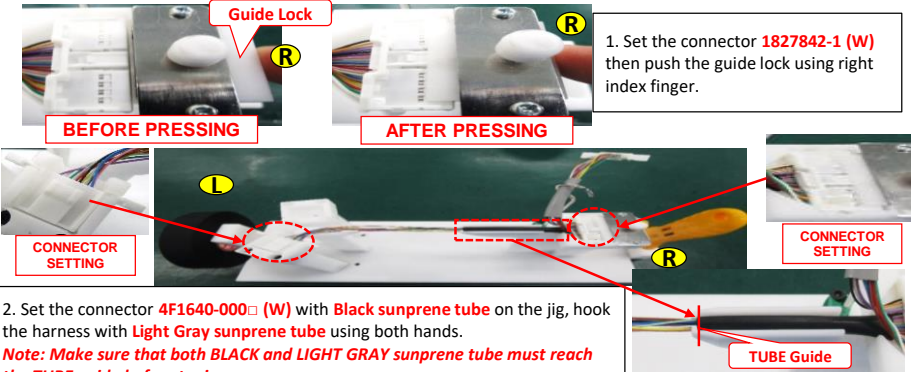
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PARTS:

1. Assy parts
2. Tesa tape 51036

JIG:

1. Locking jig
2. Taping jig

| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|-----|------------------------------------|--|---|--|
| 1 | Connector Lock |  <ol style="list-style-type: none">1. Put the connector to locking jig using right hand then press down the connector to locking jig 2x using right thumb.2. Touch the connector lock after locking. <p><i>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</i></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> | <ol style="list-style-type: none">1. No damaged double lock.2. No halfed lock connector  <p>LOCKING</p> <p><i>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK.</i></p> |
| 2 | Taping 1 & 2 Wire taping (Tesa) |  <ol style="list-style-type: none">1. Set the connector 1827842-1 (W) then push the guide lock using right index finger.2. Set the connector 4F1640-000 (W) with Black sunprene tube on the jig, hook the harness with Light Gray sunprene tube using both hands. <p><i>Note: Make sure that both BLACK and LIGHT GRAY sunprene tube must reach the TUBE guide before taping process.</i></p> | <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> | <ol style="list-style-type: none">1. No wrong setting of harness2. No wrong orientation of connector |

Revision History

| Eff. Date | Rev. No | Details of Change | Revised | Checked | Approved | Noted | Prepared by | Reviewed by | Approved by | Noted by |
|-----------|---------|--|-------------|------------|---------------|-----------|-------------|-------------|---------------|-----------|
| 05/04/22 | 1 | Change document purpose from pre-launch to masspro | M. Catapang | J. Loterte | C. Villanueva | A. Arañes | M. Catapang | J. Loterte | C. Villanueva | A. Arañes |
| 04/29/22 | 0 | Initial issue | M. Catapang | J. Loterte | C. Villanueva | A. Arañes | M. Catapang | J. Loterte | C. Villanueva | A. Arañes |

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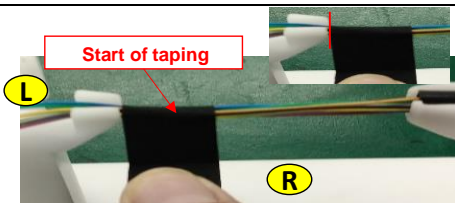
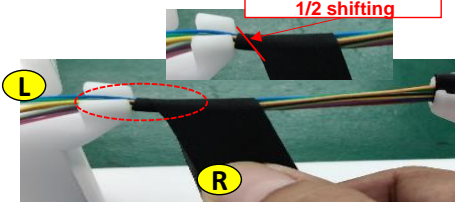
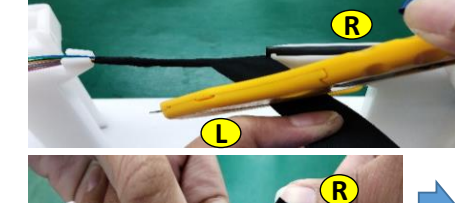


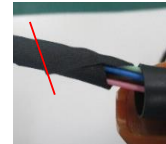
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PARTS:

1. Assy parts
2. Tesa tape 51036

JIG

1. Taping jig

| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|-----|--|---|---|--|
| 2 | P5 Taping 1 & 2 Wire taping (Tesa) (Continuation) | <div><p>3. Using the guide, make 1 winding of tape before shifting.</p></div> <div><p>4. Wind the 1/2 shifting or 3-4 winds going to the right side near vinyl tube using both hands.</p></div> <div><p>5. Use the provided cutter to cut the tesa tape using both hands.</p></div> <div><p>6. Remove the connector 4F1640-000 (W) (with Black sunprene tube) from jig using left hand then press the tape using right hand. Avoid touching the adhesive.</p></div> |  | <div><p>The end tape must be half wrap</p></div> <ol style="list-style-type: none">1. No loose tape2. No excessive tape winding3. No damage on parts4. No peel off tape5. No bend wire6. No NG of end tape |

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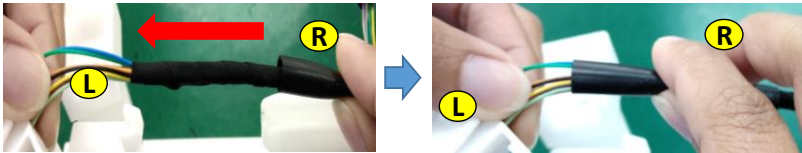
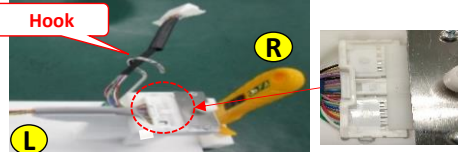
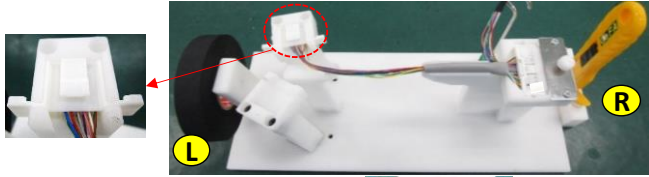
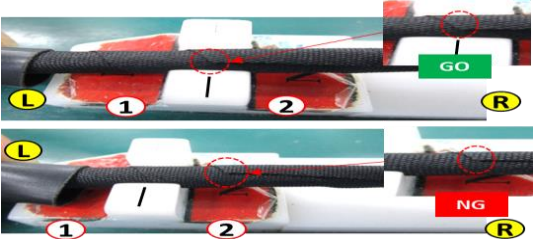


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PARTS:

1. Assy parts
2. Tesa tape 51036

JIG

1. Taping jig
2. Measuring jig

| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|-----|--|---|---|--|
| 2 | P5 Taping 1 & 2 Wire taping (Tesa) (Continuation) |  <p>7. After taping, pull the vinyl tube to the left side position using right hand.</p>  <p>8. Place the assy parts with Black sunprene tube to Hook.</p>  <p>9. Set the assy with Light Gray sunprene tube then repeat the process from step 3 to 7.</p>  <p>10. After taping, check the END POINT TAPE using measuring jig. Note: END POINT TAPE should be within the limit GO. If end point tape reaches the location 1 and 2 it will be considered as NG.</p> |  <p>OLFA Cutter</p> | <p>The end tape must be half wrap</p>  <ol style="list-style-type: none">1. No loose tape2. No excessive tape winding3. No damage on parts4. No peel off tape5. No bend wire6. No NG of end tape |

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4 of 4**PARTS:**

1. Assy parts

JIG

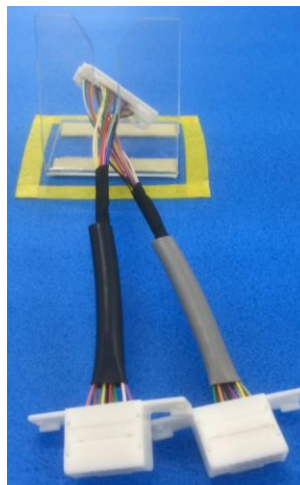
1. WIP Holder

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

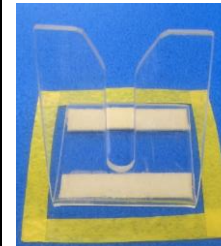
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P5

Pass WIP to P6



1. Pass WIP to WIP Holder.

Note: One piece flow.**WIP HOLDER**

1. No WIP overflow

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