		WORK INSTRUCTION E						Effec	ctivity Date:		February 10, 2022				
			Process Name/Title:	TAPING ASSEMBLY PROCESS				Valid	dity Date:		n/a				
			Model Code/Part Number:	780B	1	7R0103-7022	Customer:	TRMX			Doci	ument No.:		WI-ENG-PDE-3	97B
			Purpose:	F	PROTOTYPE		PRE-LAUNCH	MASS	PRO		Revi	sion No.:	0	Page No.:	1 of 3
PARTS:		Assy parts: Black tape [1pc.]						JIG: n/a							
N	0.	Р	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION					TOOLS/PPE	C	UALITY POIN	ITERS			
1		P2	Table Lay-out			Assy parts		ck tape/ e holder	TO THE ROOM OF THE PARTY OF THE	I DI	du 1. 2. w	Be sure to wear prescribed personal rotective equipme ring operation (glo finger cots, etc.)  Housekeeping Maintain and alway practice 5's. Personal things on orkplace is prohibit (seep it in your locked)  Alert level or any trouble, infone Assembly Assista Supervisor or Line, eader for immedia corrective action.	al lent lent lent lent lent lent lent len	ng parts/tools s parts/tools	
	!	·		Revision History					1	Prepared by	Reviewed by	Approved by	Noted by		
02/10/22	0		ue. or from Gray (GR) to Green (G) ( E-254A; WI-ENG-PDE-397A	MRSW CP T	VSSf 0.3 fro	om GR-B/W to MRSW CP	TVSSf 0.3 G-B/W); Refer to Cl	 M. Catapang	J. Loterte	C. Villanueva	A. Arañes	Almoutage	San	# Trill	
												M. Catapang	J. Loverte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change Prepared R.					Reviewed	Approved	Noted	Est. Date:	December 07, 2020		-		

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			Effectivity Date:		February 10, 2022									
	Process Name/Title:  Model Code/Part Number:		TAPING ASSEMBLY PROCESS					Validity Date:		n/a				
			780B	/ 7R0103-7	<b>7022</b> Cus	stomer: <b>T</b>	RMX	Document No.:		W	VI-ENG-PDE	E-397B		
	Purpose:		☐ PF	ROTOTYPE	PRE-	-LAUNCH	MASSPRO	Revision No.:		0 Pa	age No.:	2 of 3		
PARTS:	Black tape     Assy parts								JIG	n/a				
NO.	Р	ROCESS NAME		WORK	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUA	ALITY PO	INTERS		
2		Taping 1 Vinyl tube to wire near connector	2. Hold the Vinyl tube using left hand. Get the Black tape using right hand and start taping using both hands. Refer to WI-PRO-ASY-001 for taping procedure.  3. After taping, check the measurement and taping condition.					6789401234	MEASURING TAPE  2. No pe  3. No loc  4. No m  5. No wi  6. No wi  Note:  Please  measurements			No flip-out tape No peel-off tape No loose tape No missing tape No wrong use of tape No wrong dimension  Note: Please use calibrated/verified measuring tape when getting the measurement.		
3	P2	Taping 2 COT to Sunprene tube near to PCB	1. Hold the C up to the edghand.	176±3mm  3 4 6 6 7 8 9 00 1 2 3  COT using left hand. Measuge of hotmelted wire 176±  176±3mm  176±3mm	ure the end of COT		2. Hold the COT using left hand. Get the Black tape using right hand and start taping using both hands.  Refer to WI-PRO-ASY-001 for taping procedure.	6 7 8 9 (1) 1 2 3 4	5 6 7 8 9		off tape e tape ing tape g use of tap g dimension use calibrated ing tape whe	ı		

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		WORK INSTRUCTION						February 10, 2022 n/a		
	Process Name/Title:	Name/Title: TAPING ASSEMBLY PROCESS Validity Date:								
	Model Code/Part Number:	780B / 7R0103-	<b>7022</b> Customer:	TRMX	Document No.:		WI-ENG-PDE-397B			
	Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		0	Page No.:	3 of 3	
PARTS:	Black tape     Assy parts	·								
NO.	PROCESS NAME	WORK	TOOLS/	PPE	QUALITY POINTERS					
		No wide interval	tape width	Note: Do not exert excessive force during pulling & winding of tape.			VISU.	YELLOW TA ALIZATION	APE FOR EAS OF SHIFTIN UAL SHOULI	
		Fix the corrugated and Vinyl tube thands.  See illustration for correct facing of contents.  See illustration for correct facing of contents and the second se	onnector. 2. Start taping at the	he middle of combined Corrugated be, make 1 winding pre-tape before				ip-out tape		

P2 Y-taping

3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width) tape shifting 1/3 below

taping direction

tape width

before cut the tape. After taping, check the condition of tape.

taping direction

taping direction tape width tape shifting 1/2 below

tape width

5. Winding the tape 1/2 shifting going to other side of corrugated tube then 3 windings

shifting then winding the tape going to corrugated tube

and vinyl tube (2 windings). (must be tape width)

tape width

4. Winding the tape backward 1/2 shifting.

MEASURING TAPE 6789 1123456789 **EASY** TING ULD

2. No peel-off tape

3. No loose tape

4. No missing tape

5. No wrong use of tape

6. No wrong dimension

7. No wide interval between the COT



**Connector Orientation** 

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tape shifting 1/2 below