

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 6, 2023

Model Code/Part Number:

910B / 7L0126-7023

Customer:

TRQSS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-636C

Revision No.:

2

Page No.:

1 of 7

PARTS:

1. All parts: Assy parts; Black tape ; Brown tape ; Black VM tube (Sunprene) Ø5 L=147±3mm

JIG:

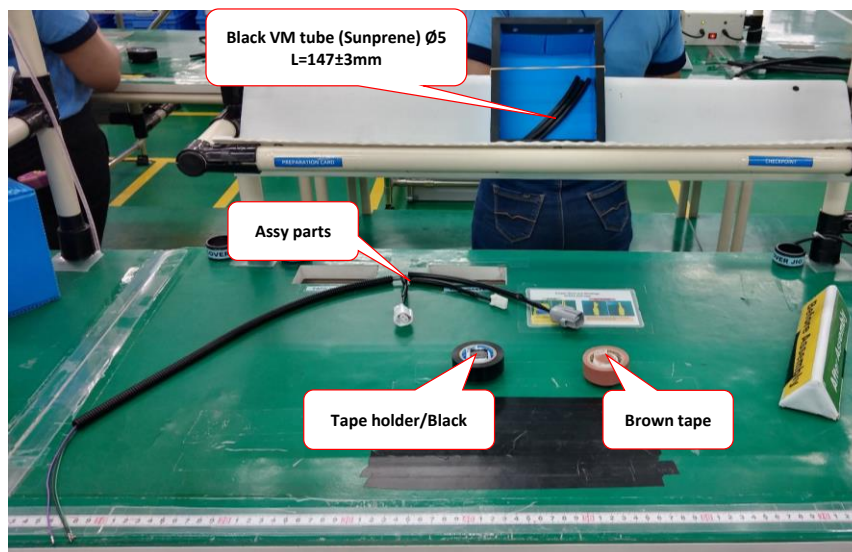
n/a

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

1

P3

Table lay-out

TABLE LAY-OUT**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 missing parts/tools
2. No excess parts/tools
3. No wrong position of parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	Prepared by	Reviewed by	Approved by	Noted by
06/06/23	2	Change sequences of process no. 4,5,6 and 7 as process improvement.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
04/17/23	1	Document purpose from prelaunch to masspro. Change taping: From VM tube sunprene to wire near terminal to Spot taping (Brown tape). Additional table layout and quality pointers. Improve work procedure due to improvement. Align quality checkpoints on finished assy parts.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
03/02/23	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	March 02, 2023		

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

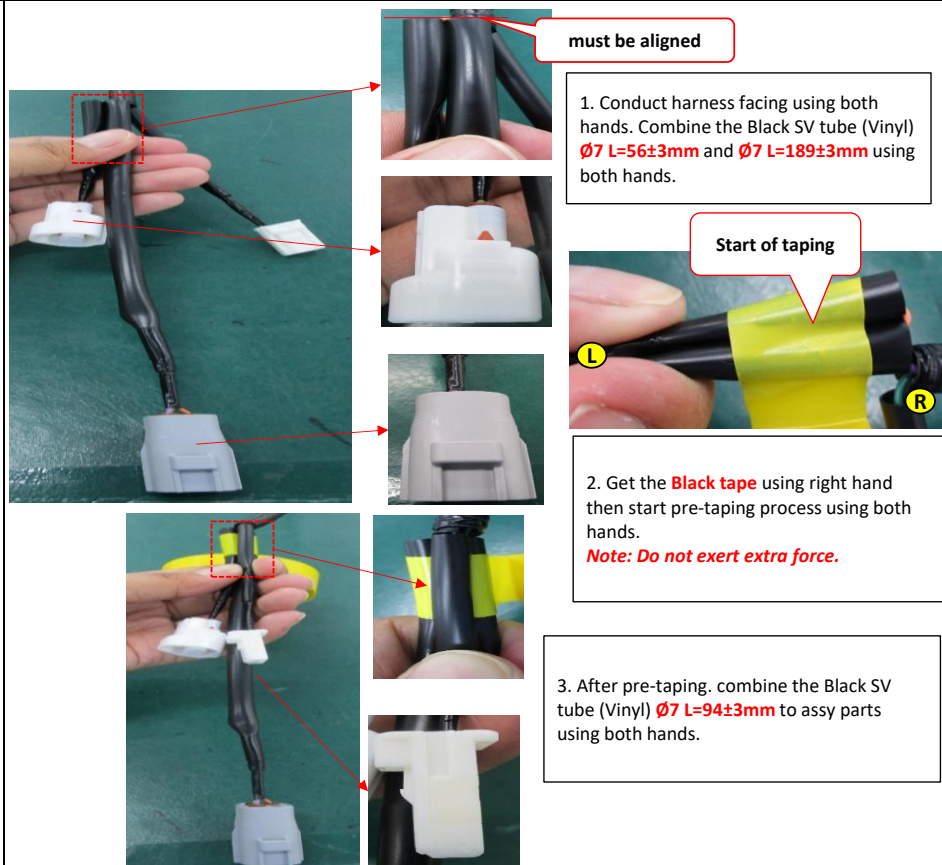
TOOLS/PPE

QUALITY POINTERS

2

P3

Y-Taping



must be aligned

1. Conduct harness facing using both hands. Combine the Black SV tube (Vinyl) $\text{Ø7 L=56}\pm\text{3mm}$ and $\text{Ø7 L=189}\pm\text{3mm}$ using both hands.

Start of taping

2. Get the **Black tape** using right hand then start pre-taping process using both hands.
Note: Do not exert extra force.

3. After pre-taping, combine the Black SV tube (Vinyl) $\text{Ø7 L=94}\pm\text{3mm}$ to assembly parts using both hands.

MEASURING TAPE

Important reminders/Note/s:

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.

1. No flip-out tape
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 wrong orientation of assembly parts

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

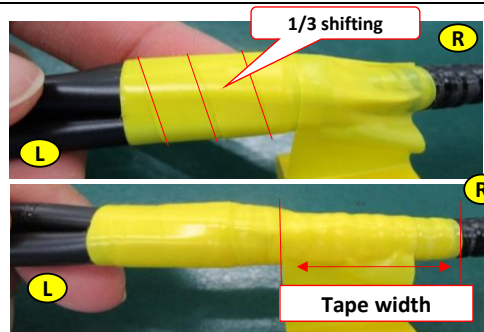
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

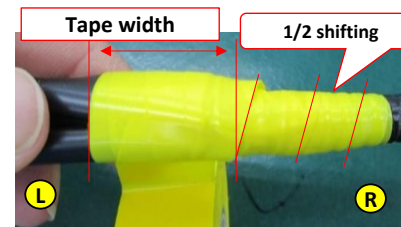
QUALITY POINTERS

3

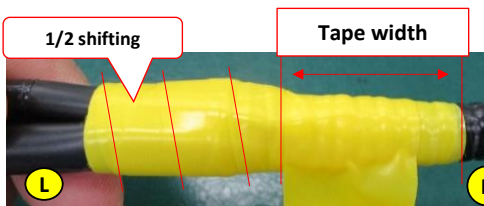
P3

Y-Taping
(Continuation)

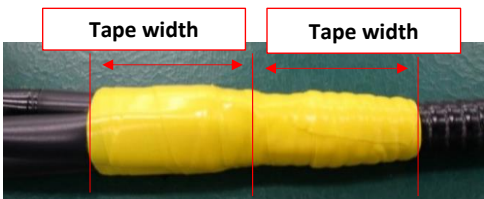
4. Make **2 windings** of tape before shifting then wind **1/3 shifting** going to COT using both hands.
Note: Do not exert extra force.



5. Make **1/2 shifting** going to vinyl tube then make **2 windings** of tape before final shifting.

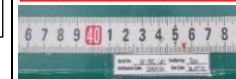


6. Make **1/2 shifting** going to COT then make **3 windings** of tape then cut the tape.



7. After taping, check the measurement and taping condition.

MEASURING TAPE



Important reminders/Note/s:

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.

1. No flip-out tape
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 wrong orientation of assy parts

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☒ MASSPRO

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PARTS:

1. Assy parts
2. Black tape

3. Black VM tube (Sunprene) Ø5 L=147±3mm

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

2

Wire insertion to
Black VM tube (Sunprene)
Ø5 L=147±3mm



1. Get the **Black VM tube (Sunprene) Ø5 L=147±3mm** using right hand then insert the **B-G-B wires** using left hand.

176 ± 3mm



1. Measure from COT up to terminal pointed tip **176±3mm** using both hands.

MEASURING TAPE



5

2

P3

Taping 1
Black VM tube (Sunprene)
to wire near terminal



136 ± 3mm

2. Measure from COT up to end of **Black VM tube (Sunprene) L=136±3mm** using both hands.



3. Get the **Black tape** using right hand then start taping process using both hands.

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

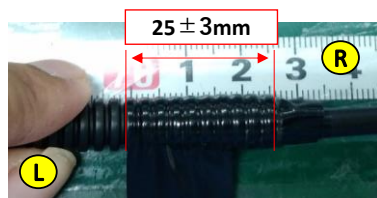
QUALITY POINTERS

6

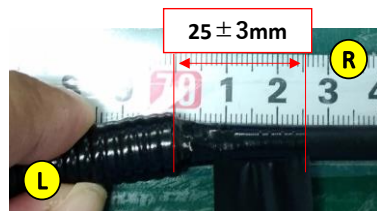
2

P3

Taping 1
Black VM tube (Sunprene)
to wire near terminal
(Continuation)



4. Confirm **25±3mm** measurement on COT the continue the taping process using both hands.



5. Confirm **25±3mm** measurement on tube the continue the taping process using both hands.



6. After taping, check the measurement and taping condition.

MEASURING TAPE



Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. Wire must be free to move inside the tube.

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

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PARTS:

1. Assy parts
2. Brown tape

JIG

n/a

NO.

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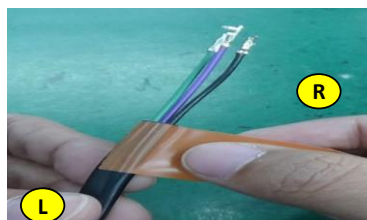
TOOLS/PPE

QUALITY POINTERS

7

P3

Spot taping



1. Get the **Brown tape** using right hand then conduct **2 windings of spot taping** using both hands. **Brown spot tape** must be near terminal pointed tip.



Spot taping tolerance



2. After taping, check the measurement and taping condition.

n/a

Important reminders/Note/s:

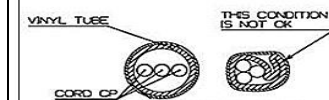
1. **Spot taping appearance should NOT exceed on tube but with 0~3mm exposed tube above spot tape**

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape

SPOT TAPING ILLUSTRATION

GOOD

NO GOOD



Spot taping location



GOOD



NG

1. No wrong usage of parts
2. No damaged rubber seal

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PARTS:

1. Assy parts

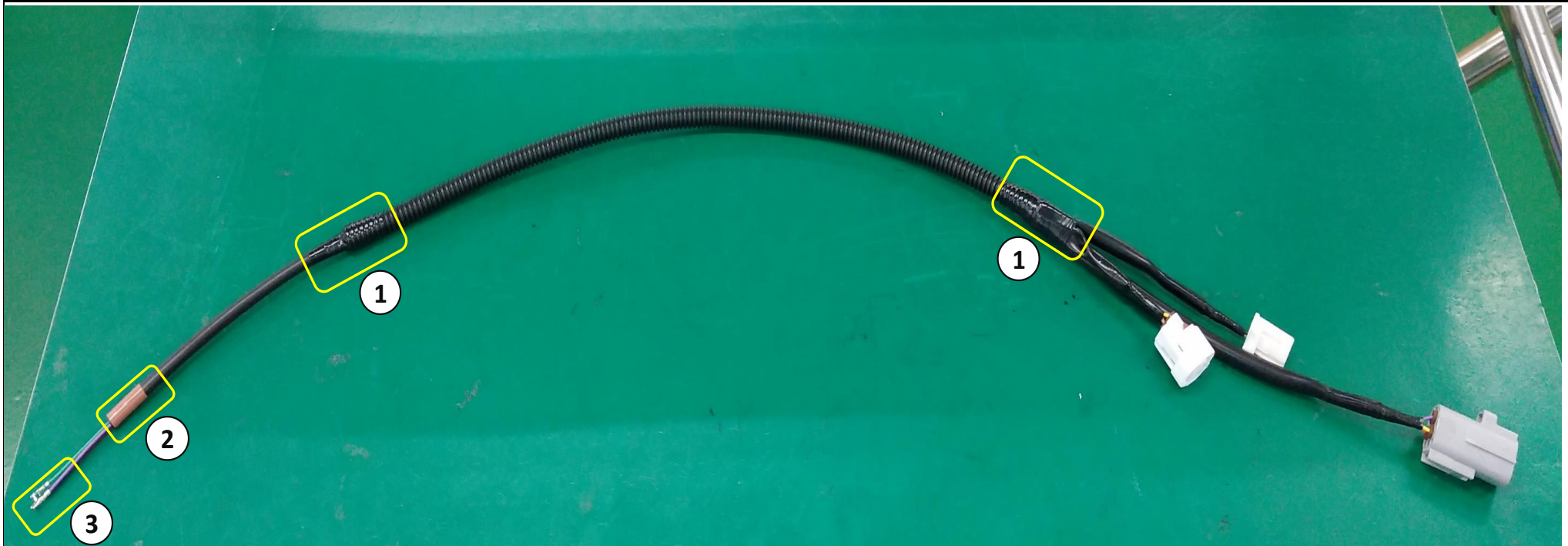
JIG

n/a

QUALITY CHECKPOINTS

P3

7L0126-7023



① No Missing Tape

③ No Deformed Terminal

② No Missing Spot tape (Brown tape)

④ Correct facing of Y-Taping

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