

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

Effectivity Date:

May 05, 2022Model Code/Part Number: **724W / 7H0352W7020C**Customer: **NBS**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-477

Revision No.:

1

Page No.:

1 of 3**PARTS:**1. Assy parts: Black vinyl tube $\phi 5$ L=149 \pm 3mm; Black tape [1pc.]

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out	<div>Table Lay-out</div> 	<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Reviewed by	Approved by
05/05/22	1	Change document purpose from pre-launch to masspro. Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
04/19/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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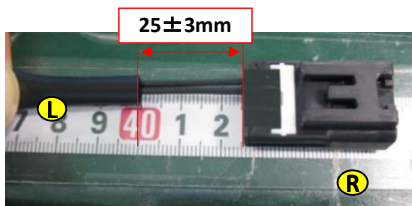
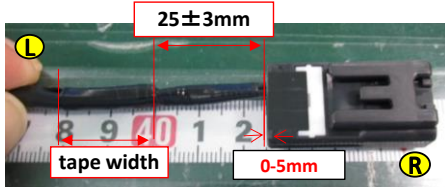
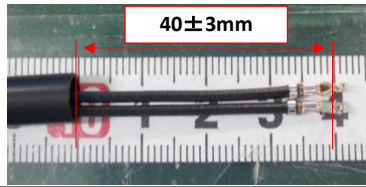
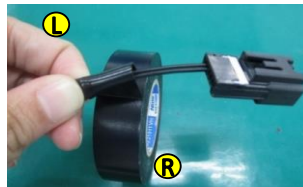

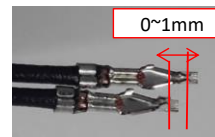
☒ MASSPRO

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PARTS:		1. Assy parts 2. Black vinyl tube $\phi 5$ L=149 \pm 3mm	3. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2		Wire insertion to Black vinyl tube $\phi 5$ L=149 \pm 3mm	 <p>1. Get the Vinyl tube $\phi 5$ L=149\pm3mm using right hand then insert the B-B wires.</p>	n/a	1. No wrong use of parts
3	P1	Taping 1 Black vinyl tube to wire near connector	 <p>1. Hold the Vinyl tube and measure from end of the vinyl tube up to edge of connector 25\pm3mm using both hands.</p>  <p>2. After taping, check the measurement, wire alignment and tape condition.</p>  <p>4. Confirm measurement of 40\pm3mm from end of tube up to terminal pointed tip using both hands.</p>	 <p>2. Get the BLACK TAPE and start taping using both hands. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p> <p>MEASURING TAPE</p> 	 <p>Wire alignment tolerance 0~1mm</p> <p>1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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4	P1	Visual/By two's inspection	<div>1. Check the double lock.</div> <div>2. Check the taping condition.</div> <div>3. Check the terminal appearance, make sure no deformed terminal.</div> <div>4. Compare to Master sample. <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-assy.</i></div> 		MASTER SAMPLE 
5		Measurement	<div></div> <div><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div></div>		FOR HATSUMONO AND OWARIMONO ONLY 1. No wrong dimension

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