

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**October 28, 2022**

Model Code/Part Number:

**RE7 / 15F856-0020**

Customer:

**TRP**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-023C**

Revision No.:

5

Page No.:

1 of 4

**PARTS:**

1. EPT Sealer No.686 180x52x3
2. Assy parts

JIG:

1. EPT Sealer jig

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

1

P3

EPT Sealer attachment

**Guide**

**Receiver base lock**

**Vinyl tube**

**Size of EPT sealer should fit the jig**

**EPT Sealer**

1. Set the harness to EPT sealer attachment jig and lock the receiver base lock. Make sure vinyl tube was not offset to jig.

2. Get the EPT sealer and attached initially at the bottom part of vinyl tube. (See illustration). Slowly wrap the EPT sealer on the vinyl tube in clockwise direction. Make 1.5 to 2 wraps around the vinyl tube.

3. Flatten the EPT sealer during attachment to maximize the length and to avoid shrinkage.

**1.5 to 2 Wraps around vinyl tube**

**Safety Instruction**

Be sure to wear prescribed 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 attachment

**NG**

Peel-off EPT sealer

2. No loose/tight attachment
3. No wrong attachment
4. Must be 1.5 to 2 wraps around vinyl tube.

**Revision History**

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
10/28/22	5	Improve Quality pointers: Reminders/Note/s and references on page no. 2 and 4; Improve Work procedure/Illustration on process no. 2 due to process improvement.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes					
04/12/22	4	Removal of validity date.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
01/09/21	3	Put assy parts in Parts section for page 1-2; Update effective and validity date; Remove cycle time	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes					

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Revision No.:

5

Page No.:

2 of 4

**PARTS:**

1. Assy parts

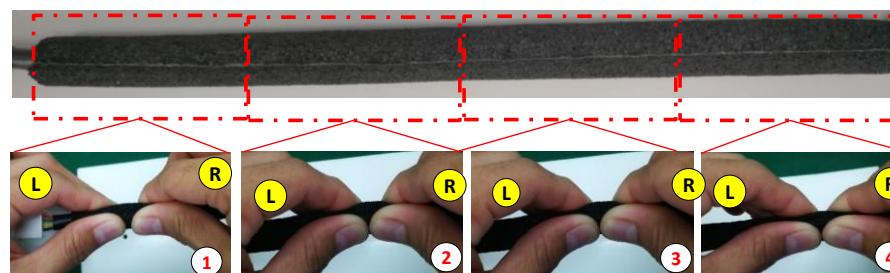
JIG:

1. EPT Sealer Attachment jig

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

1

P3

EPT Sealer attachment  
(continuation)

4. After attachment of EPT sealer, press using left and right thumb from left to right direction until all edge was pressed.  
Make sure all surface was pressed.

5

**Document reference/s:**

**1. Please refer to WI-PRO-ASY-159 for Continuity test and WI-PRO-ASY-167 for End Tape Process.**

**NG**

Peel-off EPT sealer



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☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

5

Page No.:

3 of 4

**PARTS:**

1. Assembled parts
2. Master sample

**JIG**

n/a

**NO.**

**PROCESS NAME**

**5 WORK PROCEDURE/ ILLUSTRATION**

**TOOLS/PPE**

**QUALITY POINTERS**

2

P3

Visual Inspection

1. Check the double lock & terminal condition.

2. Check the urethane attachment

3. Check the taping condition.

4. Check the presence of terminal claw on connector holes.

5. Compare to **Master sample** by tapping.



MASTER SAMPLE

ASSEMBLED PARTS

**Master Sample**



1. No skip checking during inspection.

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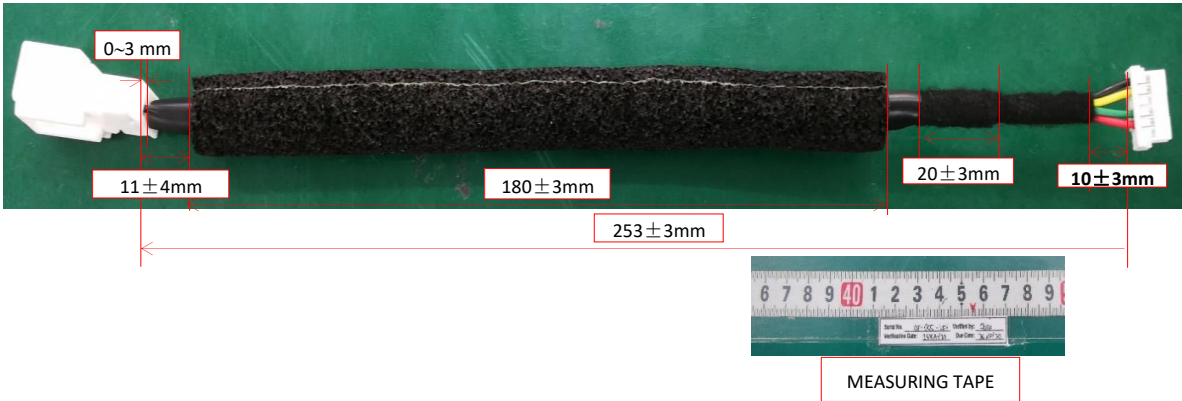
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PARTS:		n/a			JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3	Measurement				<p><b>5 Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono and Owarimono.</p>

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