



WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Effectivity Date:

January 18, 2022

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: 150B / 2 7L0059-7022

Customer: TRQSS

Document No.:

WI-ENG-PDE-291B

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

2

Page No.:

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PARTS: 2 1. All parts: Assy parts; Black sunprene tube Ø5 L=125±3mm; Black corrugated tube Ø5 L=396±3mm (no slit); Black tape [1pc.]; Blue tape [1pc.]

JIG:

1. Terminal cover jig

NO.

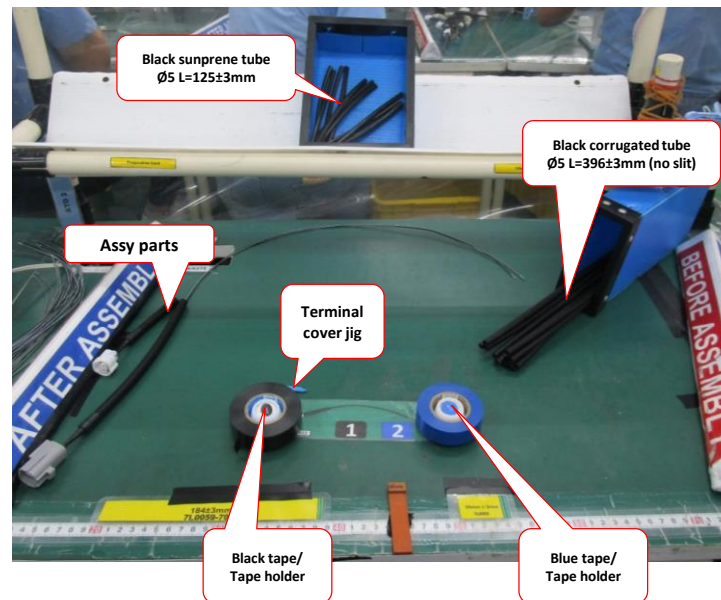
PROCESS NAME

2 WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

01/18/22 2 Change part number from 7L0059-7021 to 7L0059-7022 due to additional quantity of clamp (82711-52090 (W)) (Refer to WI-ENG-PDE-291C). Improve work procedure and illustration. Additional table lay-out.

M. Catapang J. Loterte C. Villanueva A. Arañes

08/05/21 1 Transfer process owner from Production (WI-PRO-ASY-150B) to Engineering (WI-ENG-PDE-291B). Improve process illustration and quality pointers.

J. Loterte C. Villanueva A. Shimamura A. Arañes

08/10/19 0 Previously established in Production. Initial issue.

J. Silang W. Carbillon O. Merin n/a

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Est. Date:

August 10, 2019

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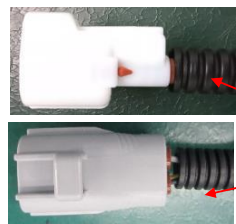



### PARTS:

1. Assy parts
2. Black corrugated tube (no slit) Ø5 L=396±3mm

3. Black tape

### JIG

1. Terminal cover jig

| NO. | PROCESS NAME   | WORK PROCEDURE/ ILLUSTRATION   | TOOLS/PPE   | QUALITY POINTERS   |
|-----|--|--|---|--|
| 2   | Wire insertion to Black corrugated tube (no slit) Ø5 L=396±3mm | <div><p>1. Get the terminal cover jig using right hand then insert the GR and B/W wires.</p></div> <div><p>2. Get the Corrugated Ø5 L=396±3mm (no slit) using right hand and insert the GR and B/W wires</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div> | <div>TERMINAL COVER JIG</div>  | <div>2</div> <ol style="list-style-type: none"><li>1. No wrong usage of parts</li><li>2. No deformed terminal</li></ol>  |
| 3   | Y-Taping   | <div><p>1. Fix the corrugated tube</p></div> <div><p>Note: Do not exert excessive force during pulling &amp; winding of tape</p></div> <div><p>tape shifting 1/3</p><p>taping direction</p></div> <div></div>     | n/a   | <p><b>Note:</b><br/>USE <b>YELLOW TAPE</b> FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE <b>BLACK TAPE</b>.</p> <ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ol> |

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## PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

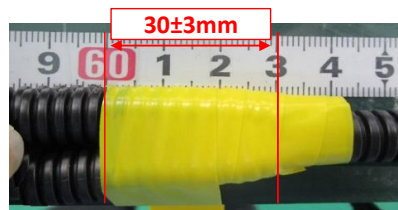
QUALITY POINTERS

3

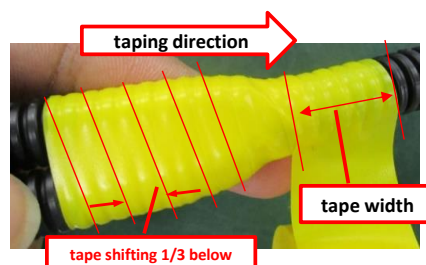
P2

Y-Taping  
(Continuation)

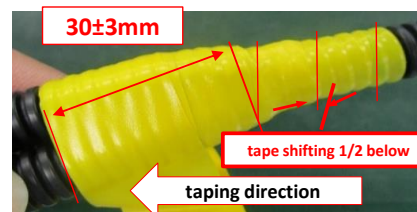
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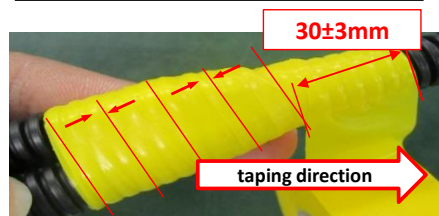
3. Confirm **30±3mm** measurement from end of tape up to end of corrugated tube then continue the taping process using both hands.



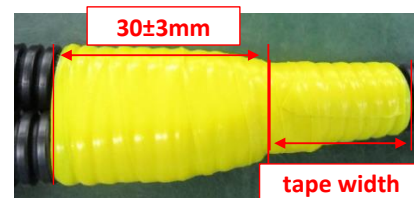
4. Wind the tape **1/3 shifting** until it reach the other side of corrugated tube (must be tape width).



5. Make **2 windings** of tape then wind **1/2 shifting** going to other side.



6. Make **2 windings** of tape then wind the tape **1/2 shifting** going to other side of corrugated tube then make **3 windings** of tape and cut.



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

## MEASURING TAPE



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

**Note:**

Please use calibrated/verified measuring tape when getting the measurement.

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**7L0059-7022**

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**TRQSS**

Purpose:



PROTOTYPE



PRE-LAUNCH



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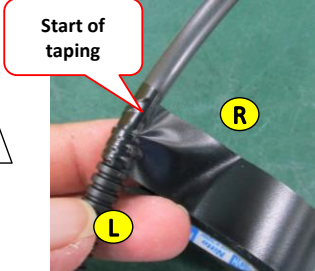
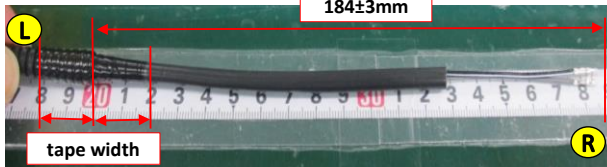

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| PARTS: |  | 1. Assy parts<br>2. Sunprene tube Ø5 L=125±3mm  | 3. Black tape | JIG  | n/a  |
|--------|--|---|---------------|--|--|
| NO.    | PROCESS NAME                                       | 2 WORK PROCEDURE/ ILLUSTRATION  |               | TOOLS/PPE  | QUALITY POINTERS   |
| 4      | Wire insertion to Black sunprene tube Ø5 L=125±3mm |  <p>1. Get the sunprene tube Ø5 L=125±3mm using right hand and then insert the GR-B/W wires using left hand.</p>  |               | n/a  | 1. No deformed terminal<br>2. No wrong usage of parts  |
| 5      | Taping 2 Black COT to Black sunprene tube          |  <p>1. Hold the assy parts then measure from end of sunprene tube up to terminal point tip 184±3mm using both hands.</p>  <p>2. Fix the COT and vinyl tube using both hands.</p>  <p>3. Hold the assy using left hand, get the Black tape then start taping process using both hands.<br/><i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>4. After taping, check the measurement and taping condition.</p> |               |  <p><b>MEASURING TAPE</b></p> | 1. No flip-out tape<br>2. No peel-off tape<br>3. No loose tape<br>4. No missing tape<br>5. No wrong dimension<br>6. No wrong use of tape<br><br><b>Note:</b><br><i>Please use calibrated/verified measuring tape when getting the measurement.</i> |

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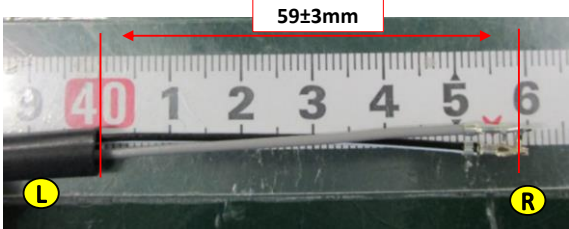
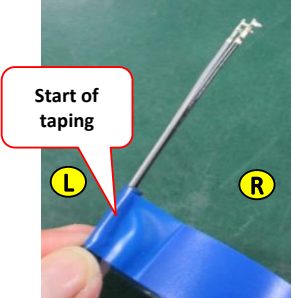
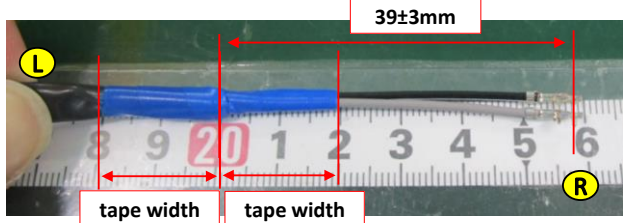

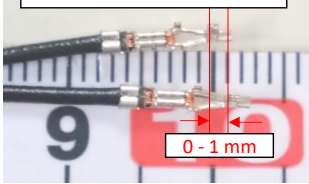
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**PARTS:**

1. Assy parts
2. Blue tape

**JIG**

n/a

| NO. | PROCESS NAME   | WORK PROCEDURE/ ILLUSTRATION   | TOOLS/PPE  | QUALITY POINTERS  |
|-----|--|--|--|---|
| 6   | P2<br>Taping 3<br>Black COT to wire near<br>terminal | <p><b>2</b></p>  <p>1. Hold the assy parts using left hand, measure from end of sunprene tube up to end of terminal pointed tip <b>59±3mm</b> using both hands.</p>  <p>2. Hold the sunprene tube using left hand, get the <b>Blue tape</b> then start taping process using both hands.<br/><i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>3. After taping, check the measurement, wire alignment and taping condition.</p> | <p><b>2</b></p> <p><b>MEASURING TAPE</b></p>  | <p><b>NOTE: USE BLUE TAPE ONLY</b></p>  <p>1. No flip-out tape<br/>2. No peel-off tape<br/>3. No loose tape<br/>4. No missing tape<br/>5. No wrong dimension<br/>6. No wrong use of tape</p> <p><b>Note:</b><br/>Please use calibrated/verified measuring tape when getting the measurement.</p> |

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