

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**Model Code/Part Number: **900B/910B / 7N0101-7020B** Customer: **TRJ**Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

August 15, 2023

Validity Date:

n/a

Document No.:

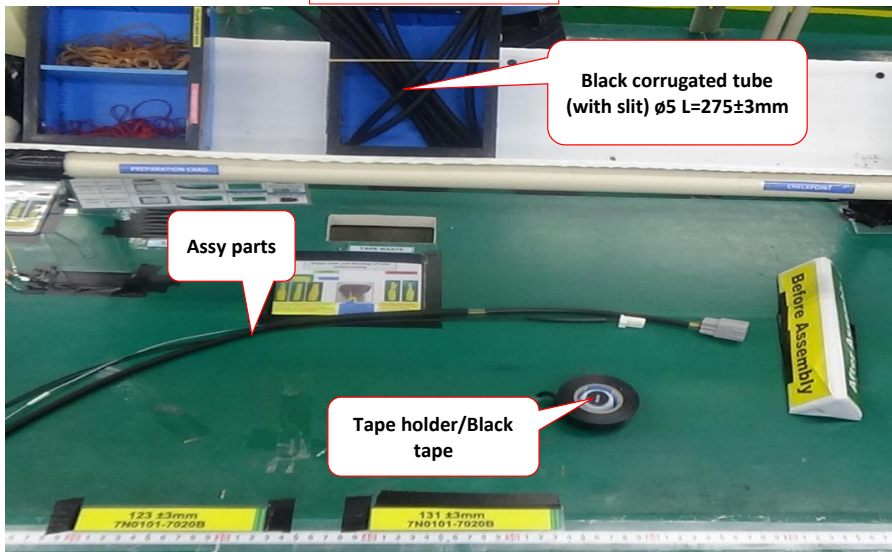
WI-ENG-PDE-458B

Revision No.:

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PARTS:		1. Assy parts: Black corrugated tube (with slit) $\phi 5$ L=275 \pm 3mm; Black tape				JIG:		1. Terminal cover jig 2. COT Adaptor	
NO.	PROCESS NAME	4	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS
1	P2	Table Lay-out	<div><div>Table Lay-out</div></div>				<div><div>Safety Instruction</div><div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>		1. No missing parts/tools 2. No excess parts/tools
Revision History									
08/15/23	4	Change table lay-out; Change Quality checkpoints. Transferred process of Taping 1- Black SV tube (Vinyl) to wire near connector 6188-0175 (GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6098-3810 (W) from P1 to P2; Removed and Transferred process of Half wrap taping; Wire insertion to Black VM tube (Sunprene); Taping 2: Black sunprene tube to Black COT near PCB and terminal and Y-taping 1 to P3 due to new process distribution.				M. Ariola	J. Loterte	C. Villanueva	A. Arañes
04/06/23	3	Work instruction improvement. Change 4MP to 3MP. Transfer process from (Page 2, 5-10). Change term for Sunprene tube to VM tube (Sunprene). Inclusion of Quality Checkpoints (page 10)				D. Castillo	J. Loterte	C. Villanueva	A. Arañes
10/14/22	2	Improve quality pointers: Reminders/notes and references in process no.2,3 and 7 due to document improvement.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Prepared by	Reviewed by	Approved by	Noted by
						M. Ariola	J. Loterte	C. Villanueva	A. Arañes
						Est. Date:	April 12, 2022		

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts
2. Black tape

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

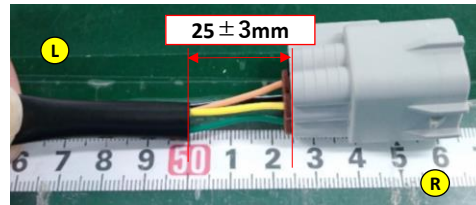
QUALITY POINTERS

4

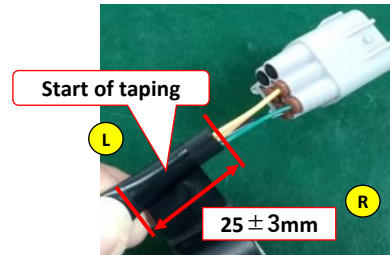
2

P2

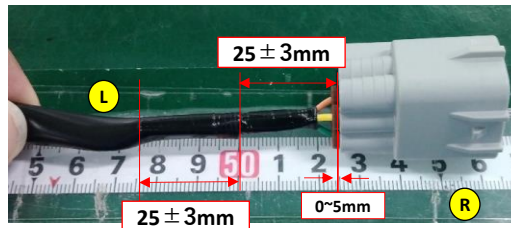
Taping 1
Black SV tube (Vinyl) to wire
near connector



1. Measure from end of tube up to edge of connector **25±3mm** using both hands.



2. Hold the SV tube (Vinyl) using left hand, get the **Black tape** using right hand then start taping process using both hands.



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

n/a

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

Important reminders/Note/s:

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

Document reference/s:

1. Please refer to WI-PRO-ASY-001 for taping procedure.

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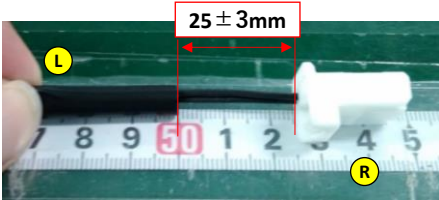
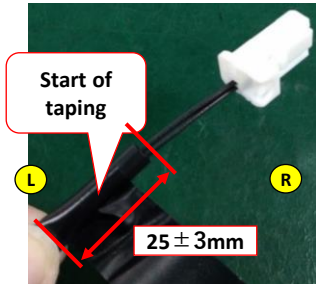
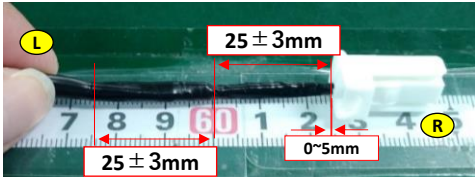

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		JIG			1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 2 Black SV tube (Vinyl) to wire near connector	 <p>1. Measure from end of tube up to edge of connector 25±3mm using both hands.</p>  <p>2. Hold the SV tube (Vinyl) using left hand, get the Black tape using right hand then start taping process using both hands.</p>  <p>3. After taping, check the measurement and taping condition.</p>			<p>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</p> <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Please refer to WI-PRO-ASY-001 for taping procedure.</p>

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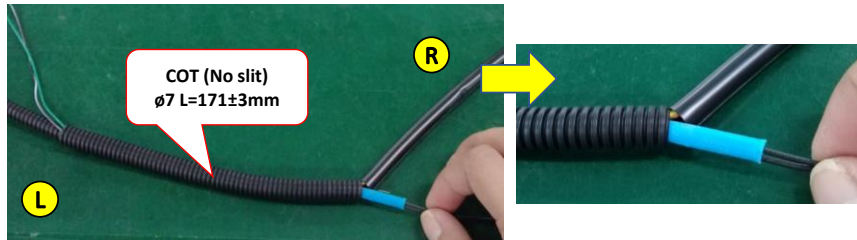
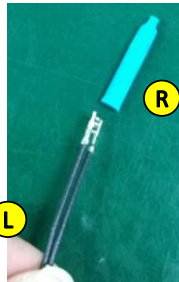

WI-ENG-PDE-458BPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts			JIG	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Wire insertion to assy parts	<div><div><div>1. Get the cover jig then insert to B-B wires using right hand.</div></div><div><div>2. Hold the corrugated tube (no slit) Ø7 L=171±3mm using left hand then insert B-B wires using right hand.</div></div><div><div>3. After insertion, remove the cover jig using right hand.</div></div></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong insertion 2. No deformed terminal

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Purpose:



PROTOTYPE



PRE-LAUNCH



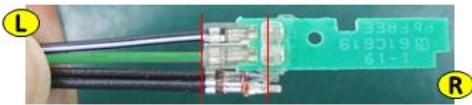


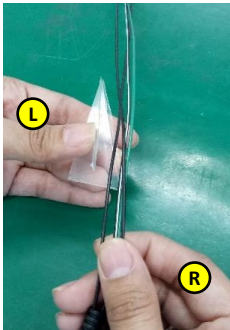
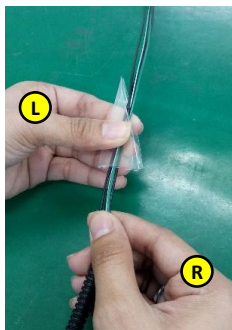
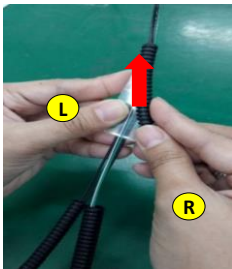

MASSPRO

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PARTS:	1. Assy parts 2. Black tape	3. Black corrugated tube (w/ slit) $\phi 5$ L=275 \pm 3mm	JIG	1. COT Adaptor
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Taping 3 Spot taping	  	n/a	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
6	Wire insertion to Black Corrugated tube (w/slit) $\phi 5$ L=275 \pm 3mm	   	COT Adaptor	1. No wrong use of parts 2. No wires left inside COT with slit

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☐ PRE-LAUNCH

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

7

P2

Taping 4
Black Corrugated tube
(w/slit) to wire near PCB and
terminal tip

Start of
taping

L

R

1. Hold the corrugated tube using left hand
then start taping using right hand.

$25 \pm 3\text{mm}$

L

R

2. Confirm measurement of $25 \pm 3\text{mm}$ from end of tape up
to COT then continue the taping process using both
hands.

$123 \pm 3\text{mm}$

L

R

$131 \pm 3\text{mm}$

3. Measure from end of COT up to terminal pointed tip $L=131 \pm 3\text{mm}$;
and COT to PCB $L=123 \pm 3\text{mm}$ then continue the taping process using
both hands.

$25 \pm 3\text{mm}$

L

R

4. Confirm measurement of $25 \pm 3\text{mm}$
from COT up to end of tape then
continue the taping process using
both hands.

$123 \pm 3\text{mm}$

L

R

$25 \pm 3\text{mm}$

$25 \pm 3\text{mm}$

$131 \pm 3\text{mm}$

5. After taping, check the
measurement, terminal and
PCB appearance and taping
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

Important reminders/Note/s:
**1. Please use calibrated/verified
measuring tape when getting the
measurement.**

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PROTOTYPE



PRE-LAUNCH



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PARTS:

n/a

JIG

n/a



QUALITY CHECKPOINTS

P2

7N0101-7020B

1

25 ± 3MM SV tube (Vinyl) TO CONNECTOR
25 ± 3MM TAPING LENGTH

131 ± 3MM COT TO TERMINAL
123 ± 3MM COT TO PCB

1

1

25 ± 3 MM TAPE WIDTH

1

No Missing Tape

**Proper alignment
of B-B wires and
hotmelt**

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