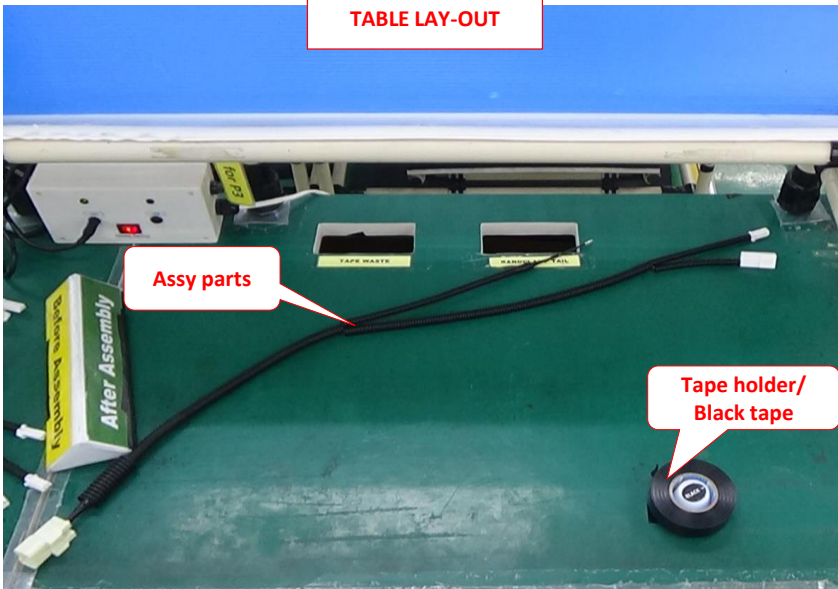

	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date: <b>June 14, 2023</b>	
	Process Name/Title:				Validity Date: <b>n/a</b>	
	Model Code/Product Number: <b>200D / 7R0130-7022</b>		Customer: <b>TRMX</b>		Document No.: <b>WI-ENG-PDE-563C</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.: <b>5</b> Page No.: <b>1 of 6</b>	

<b>PARTS:</b> 1. Assy parts; Black tape		JIG n/a	
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3 Table Lay-out	<div style="text-align: center;">  <p><b>TABLE LAY-OUT</b></p> <p>Assy parts</p> <p>Tape holder/ Black tape</p> </div>	<div style="border: 1px dashed red; padding: 5px;"> <p><b>Safety Instruction</b></p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b></p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<p>1. No missing parts/tools 2. No excess parts/tools</p> <div style="text-align: center;">  <p><b>BAND CLAMP ILLUSTRATION</b></p> <p>GOOD NG</p> <p>82711-16830 (B) 82711-34490 (B)</p> </div> <p><b>Important reminders/Note/:</b></p> <p>1. Please check the clamp first before start assembly to avoid wrong use of clamp.</p>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
06/14/23	5	Changed Table lay-out; Changed Quality Checkpoints; Changed MP from 3MP to 4MP. Additional process (checking of tape in Corrugated tube to wire near connector); Transferred process no.3 and 4 from P2 to P3 due to new process distribution.	M.Ariola	J. Loterte	C. Villanueva	A.Arañes	
12/02/22	4	Merge from P3 to P2. Transfer process of Y-Taping 2 from P2 to 3. Integrate spot taping jig to Clamp assembly jig due to process improvement. Inclusion of Quality checkpoint. Change table lay-out	M.Ariola	J. Loterte	C. Villanueva	A.Arañes	
11/04/22	3	Improve quality pointers; Reminders/notes and references on pages no. 1 to 10 due to document improvement. Additional measurement illustration for straight harness. Improve work procedure/illustration on process no.7- Visual/By two's inspection.	M.Ariola	J. Loterte	C. Villanueva	A.Arañes	
Eff.Date	Rev.No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: July 14, 2022

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**TAPING ASSEMBLY PROCESS**

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**2 of 6****PARTS:**

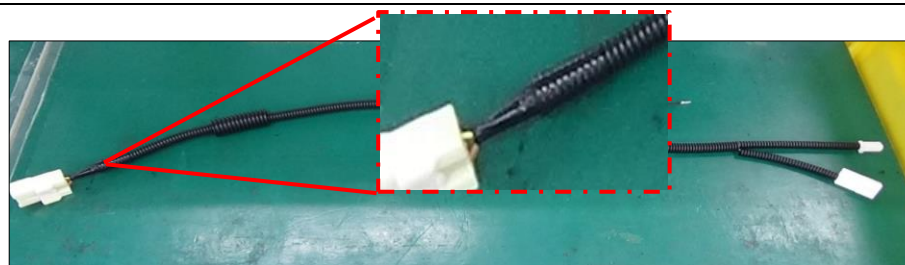
1. Assy parts
2. Black tape

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

3

5

Checking of tape in Corrugated tube to wire near connector

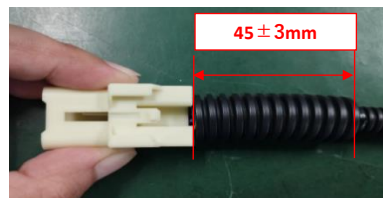


1. No Missing tape

4

5

P3

Taping 3  
COT Ø13 L=45±3mm to COT  
Ø7 L=268±3mm wire near  
connector1. Measure from end of COT Ø13 up to end of connector **45±3mm** using both hands.2. Hold the assy parts using left hand. Get **Black tape** using right hand and conduct Pre-taping in the middle **3** windings.**MEASURING 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
6. No wrong dimension
7. No insufficient windings of tape.
8. No Excessive windings of tape.

**Important reminders/Note/s:**

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

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**3 of 6****PARTS:**

1. Assy parts
2. Black tape

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

4

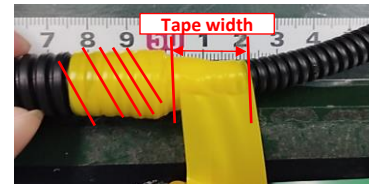
5

P3

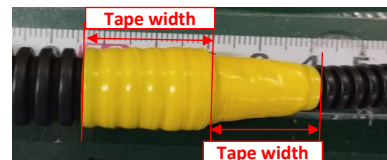
Taping 3  
COT Ø13 L=45±3mm to COT  
Ø7 L=268±3mm wire near  
connector  
(Continuation)



3. Conduct **2** windings before shifting. width must be **tape width**.



4. Shift the tape going to COT, First shifting **2/3**, second shifting **3/5** until it reach the other side of corrugated tube, width must be **tape width**. Then Conduct **6-7** windings before end of tape.



5. After taping, check the measurement 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 use of tape
6. No wrong dimension
7. No insufficient windings of tape.
8. No Excessive windings of tape.

**Important reminders/Note/s:**

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

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# WORK INSTRUCTION

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### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

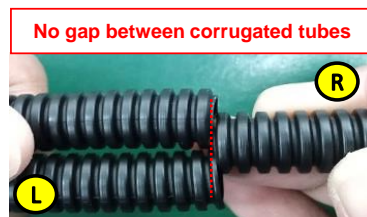
TOOLS/PPE

QUALITY POINTERS

5

P3

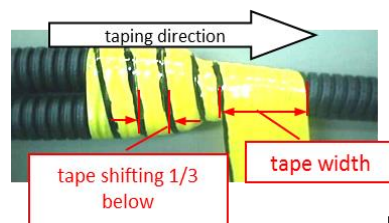
Y-Taping 1



1. Fix the corrugated tube.



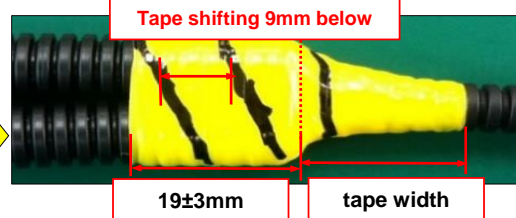
2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be **19±3mm**.



3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be **20mm**.



4. Winding the tape backward 1/2 shifting.



5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.

### MEASURING TAPE



### Important reminders/Note/s:

1. Used **YELLOW TAPE** to easy visualize the tape shifting, but actual should be **BLACK TAPE**.
2. Do not exert excessive force during pulling & winding of tape.
3. Must be no gap between corrugated tubes

### Y- TAPING 1 ORIENTATION



Y-TAPING 1

Y-TAPING 2

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

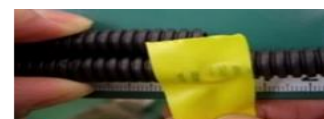
6

P3

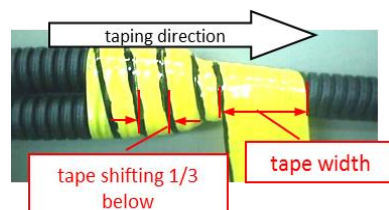
Y-Taping 2



1. Fix the corrugated tube.



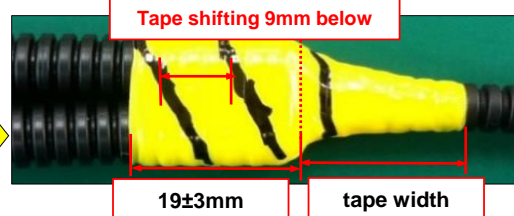
2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be **19±3mm**.



3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be **20mm**.



4. Winding the tape backward 1/2 shifting.



5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.

MEASURING TAPE

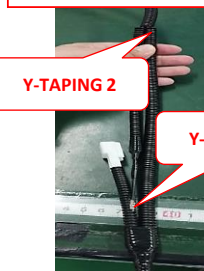


1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

**Important reminders/Note/s:**

1. Used **YELLOW TAPE** to easy visualize the tape shifting, but actual should be **BLACK TAPE**.
2. Do not exert excessive force during pulling & winding of tape.
3. Must be no gap between corrugated tubes

**Y- TAPING 2 ORIENTATION**



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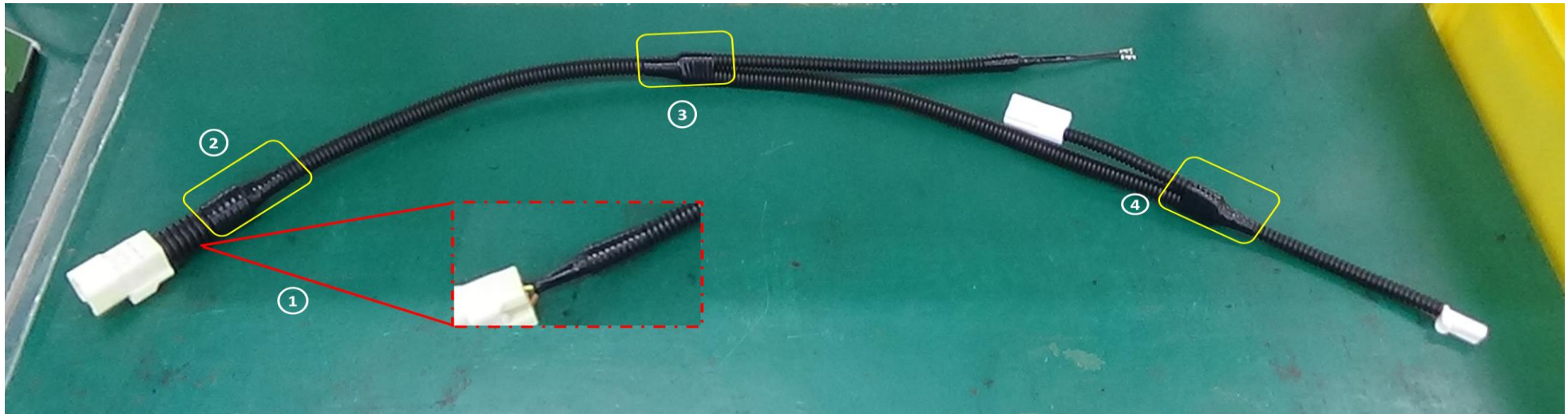
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**6 of 6****PARTS:**

n/a

**JIG**

n/a

**QUALITY CHECKPOINTS****P3****7R0130-7022****1****No Missing tape**

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