

	WORK INSTRUCTION					Effectivity Date:		April 27, 2022	
	TAPING ASSEMBLY PROCESS					Validity Date:		n/a	
	Process Name/Title:			Model Code/Product Number: N/A / 7H0389W7020A		Customer: NBS		Document No.: WI-ENG-PDE-468B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.:		1	Page No.:

PARTS:	1. Assy parts 2. Black Sunprene tube Ø9 L= 97±3mm 3. Black Tape					JIG	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Table Lay-out		<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p style="color: red; margin: 0;">Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p style="color: red; margin: 0;">Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p style="color: red; margin: 0;">Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	1. No Missing parts/ tools. 2. No Excess parts/tools.

Revision History					Prepared by		Reviewed by		Approved by		Noted by	
04/27/22	1	Change from Pre-Launch to Masspro. Additional Table Lay-out	M.Ariola	J. Loterte	C.Villanueva	A.Arañes						
04/07/22	0	Initial Issue.	M.Ariola	J. Loterte	C.Villanueva	A.Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes		
Eff.Date	Rev.No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	April 07, 2022				

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PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

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PARTS:

1. Assy parts

2 Black Sunprene tube Ø9 L= 97±3mm

3.Black Tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

Wire insertion to
Sunprene tube
Ø9 L= 97±3mm



1. Get the **Sunprene tube Ø9 L= 97±3mm** using right hand and insert the wires using left hand.

n/a

1. No wrong use of parts
2. No damaged terminal

3

P2

Taping 3
COT to Sunprene tube



1. Hold the assy parts using left hand. Measure from Sunprene tube to terminal pointed tip **31±3mm**.



2. Hold the assy parts using left hand. Get the Black tape and start taping using right hand.
Refer to WI-PRO-ASY-001 for taping procedure.

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

MEASURING TAPE



1. Check the tape from COT to Vinyl (Conduct bending for verification)
2.No flip out tape.
3.No tape peeling.
4.No loose tape

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

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☐ PROTOTYPE

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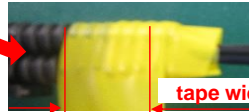
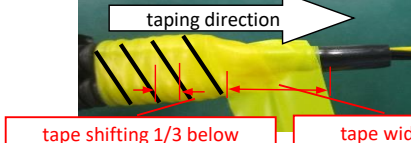
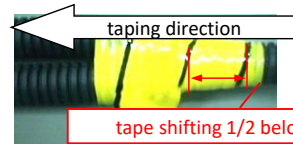
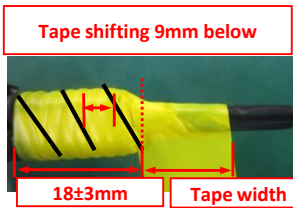
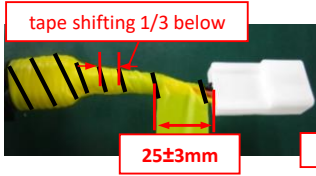
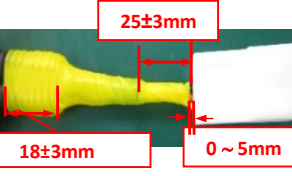





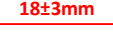




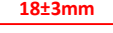

3 of 3

PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Y-Taping	MEASURING TAPE	<p>Note: Used yellow tape to easily visualize the tape shifting but actual should be BLACK.</p> <ol style="list-style-type: none">1. No peel-off2. No wrong location3. No missing tape <p>CONNECTOR ORIENTATION</p>  <p>1. Fix the corrugated tube and vinyl tube. Follow the correct connector orientation.</p>  <p>2. Start taping at the middle of combined COT & vinyl tubes, then wind the tape going to 2 corrugated tubes (2 windings), width must be same with tape (18mm)</p>  <p>3. Wind the tape 1/3 shifting until it reach the vinyl tube (must be tape width)</p>  <p>4. Wind the tape backward 1/2 shifting</p>  <p>5. Wind the tape 1/2 shifting going to vinyl tube. Cover the vinyl tube & wire 1/3 shifting. Measure vinyl tube up to connector 25±3mm then make 3 windings on wire before cutting of tape.</p>  <p>6. Check the tape condition.</p>               

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