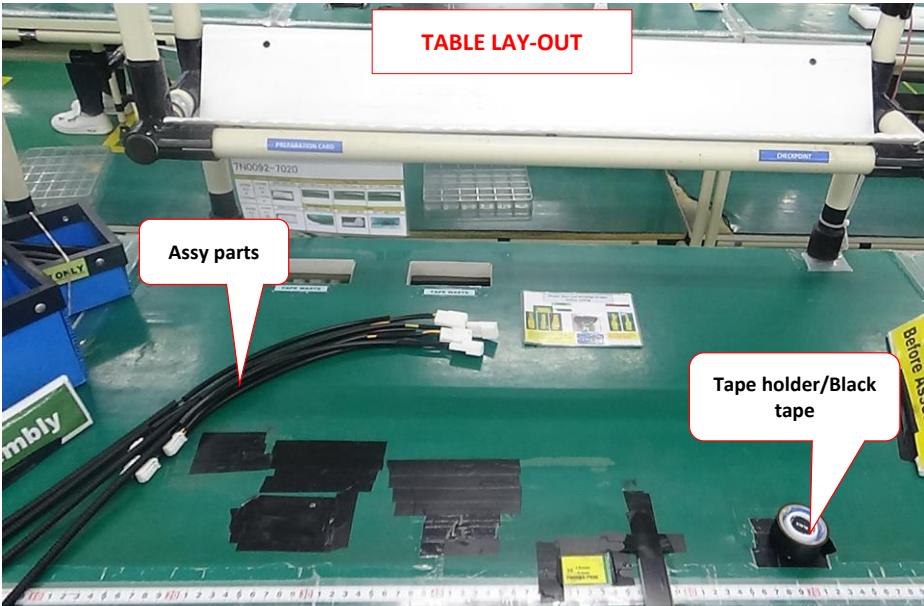




	WORK INSTRUCTION						Effectivity Date:		April 4, 2023	
	Process Name/Title: TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Model Code/Product Number: 895B / 7N0092-7020		Customer: TRJ		Document No.:		WI-ENG-PDE-500B			
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		7		Page No.:		1 of 4	

PARTS:		1. Assy parts 2. 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> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1. No missing parts/ tools 2. No excess parts/ tools

Revision History						Prepared by	Reviewed by	Approved by	Noted by	
04/04/23	7	Inclusion of Quality Checkpoints on page no.4. as document process improvement.	M. Ariola	J. Loterte	C. Villanueva	A.Arañes	 M. Ariola	 J. Loterte	 C. Villanueva	 A. Arañes
03/30/23	6	Remove process of Y-taping and transfer to P3 due to new process distribution. Change Table lay-out; Standarized tube description; SV tube (Vinyl)	M. Ariola	J. Loterte	C. Villanueva	A.Arañes				
11/10/22	5	Interchange sequence and process from (1) Black corrugated tube to wire near terminal and (2) Black corrugated tube to vinyl tube to (1) Black corrugated tube to vinyl and (2) Black corrugated tube to wire near terminal to resolve the encountered broken connector.	M.Catapang	J. Loterte	C. Villanueva	A.Arañes				
Eff.Date	Rev.No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	May 23, 2022	

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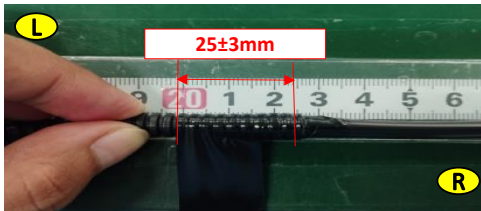
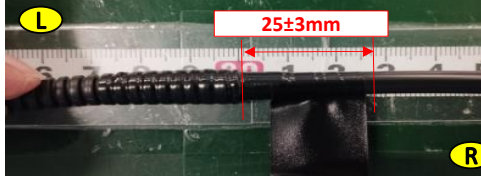
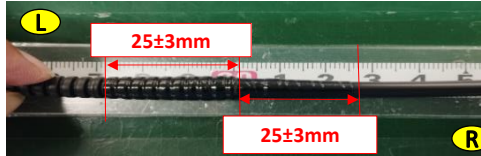

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Taping 1 Black Corrugated tube to SV tube (Vinyl)	<div><div><p>1. Fix the COT and vinyl tube using both hands.</p></div><div><p>2. Fix the corrugated tube to SV tube (Vinyl) using left hand then get black tape and start taping using right hand.</p></div></div> <div><div><p>3. Confirm measurement of 25±3mm from end of tape up to end of COT then continue the taping process using both hands.</p></div><div><p>4. Confirm measurement of 25±3mm from end of COT up to end of tape using both hands.</p></div><div><p>5. After taping, check the measurement and taping condition.</p></div></div> <div><div></div><p>MEASURING TAPE</p></div> <div><ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape<p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p></div>			

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

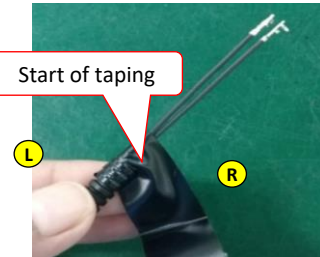
TOOLS/PPE

QUALITY POINTERS

3

P2

Taping 2
Black Corrugated to Wire
near terminal



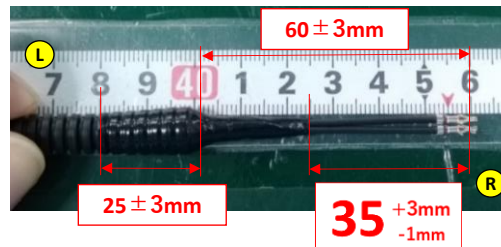
1. Hold the COT using left hand, get the **Black tape** using right hand then start pre-taping using both hands.



2. Measure from end of COT up to terminal pointed tip **60±3mm** then continue the taping process using both hands.



3. Confirm measurement of **35(+3/-1mm)** from end of tape up to terminal pointed tip then continue the taping process using both hands.

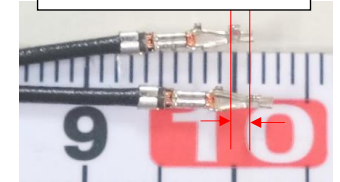


4. After taping, check the measurement, taping condition and terminal appearance.

MEASURING TAPE



Wire alignment tolerance



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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WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

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Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

n/a

JIG

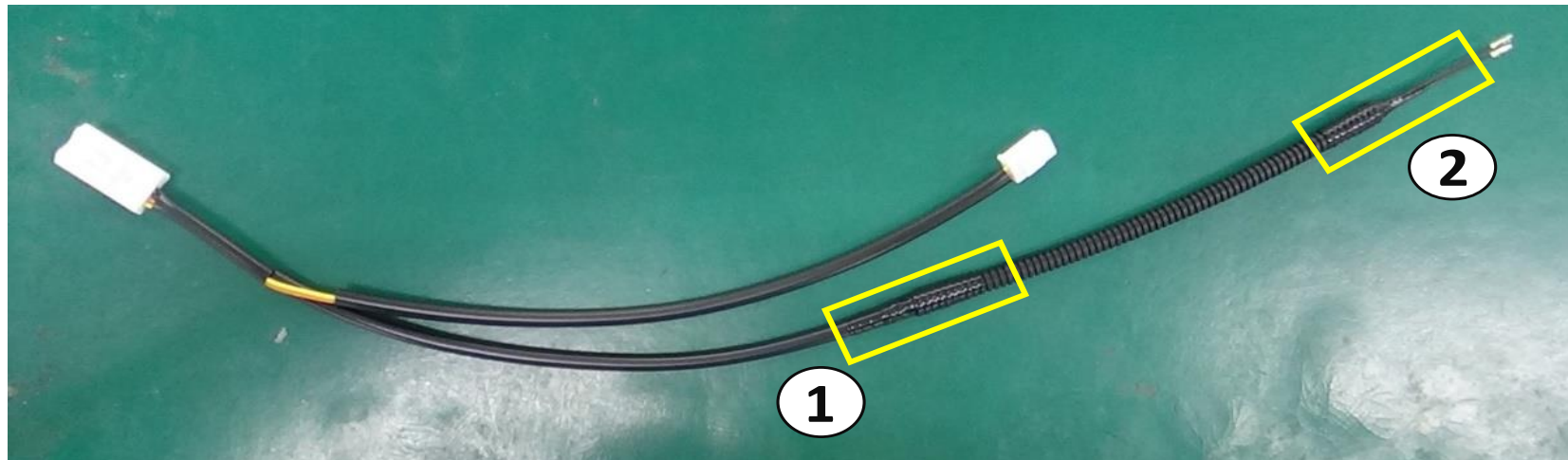
n/a



QUALITY CHECKPOINTS

P2

7N0092-7020



1 2 No Missing tape

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