



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Part Number: 920B / 7R0118-7021

Customer:

TRMX

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Effectivity Date:

March 8, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-645B

Revision No.:

0

Page No.:

1 of 4

PARTS:

1. Black tape [1pc.]

JIG:

n/a

NO.

PROCESS NAME

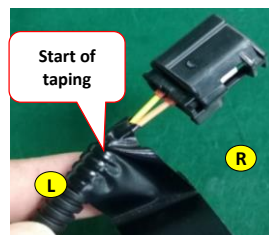
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

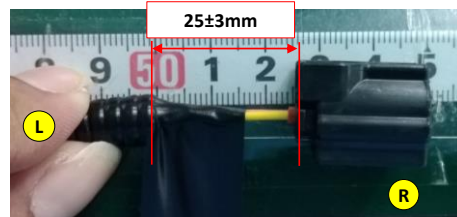
QUALITY POINTERS

1

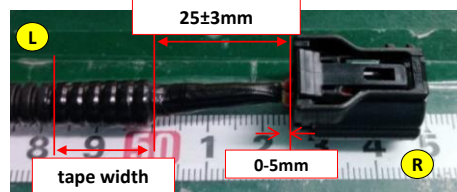
P2

Taping 1
COT to wire near
connector

1. Hold the COT then get **Black tape** using right hand then start taping process using both hands.



2. Measure from end of COT up to edge of connector **25±3mm** then continue the taping process using both hands.



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

Safety Instruction

Be sure to wear prescribed 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.

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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
03/08/23	0	Initial issue	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	D. Castillo	J. Loterte	C. Villanueva	A. Arañes

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 8, 2023

Model Code/Part Number: **920B / 7R0118-7021**

Customer:

TRMX

Document No.:

WI-ENG-PDE-645B

Purpose:



PROTOTYPE



PRE-LAUNCH



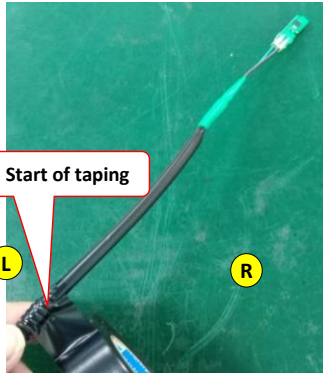
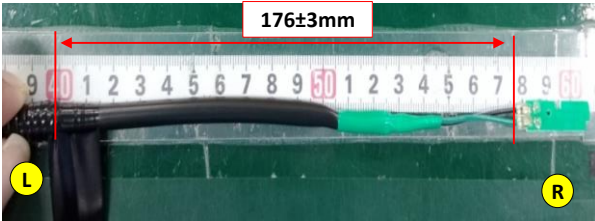


MASSPRO

Revision No.:

0

Page No.:

2 of 4

PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	<p>Taping 2 COT to sunprene tube near PCB</p>    <p>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</p> <p>2. Measure from end of COT up to PCB 176±3mm then continue the taping process using both hands. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p> <p>3. After taping, check the measurement and taping condition.</p>	<p>MEASURING TAPE</p> 	<p>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</p> <p>Important reminders/Note/s: <i>1. Please use calibrated/verified measuring tape when getting the measurement.</i></p>

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 8, 2023

Model Code/Part Number:

920B / 7R0118-7021

Customer:

TRMX

Document No.:

WI-ENG-PDE-645B

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

3 of 4

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE


QUALITY POINTERS

4

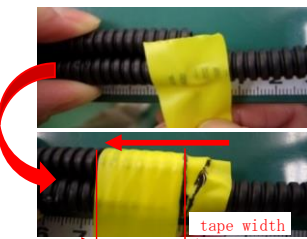
P2

Y-Taping

No gap between tubes



1. Fix the corrugated tube .

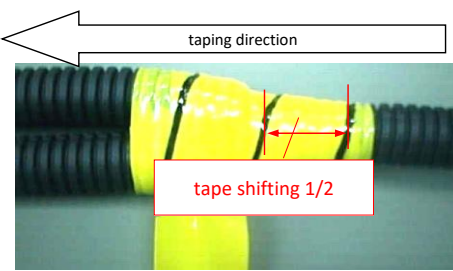


Note: Do not exert excessive force during pulling & winding of tape

tape width

2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side, width must be same with tape (19mm)

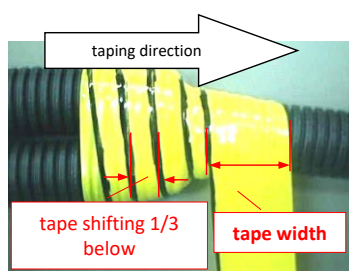
taping direction



tape shifting 1/2

4. Wind the tape backward 1/2 shifting

taping direction

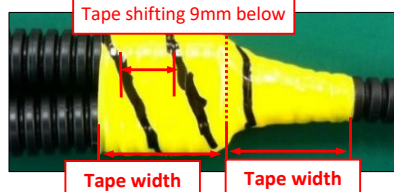


tape shifting 1/3 below

tape width

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

Tape shifting 9mm below



Tape width

Tape width

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

n/a

Important reminders/Note/s:
1. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK 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

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 8, 2023

Validity date

n/a

Model Code/Part Number:

920B / 7R0118-7021

Customer:

TRMX

Document No.:

WI-ENG-PDE-645B

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

4 of 4

PARTS:

1. Assy parts

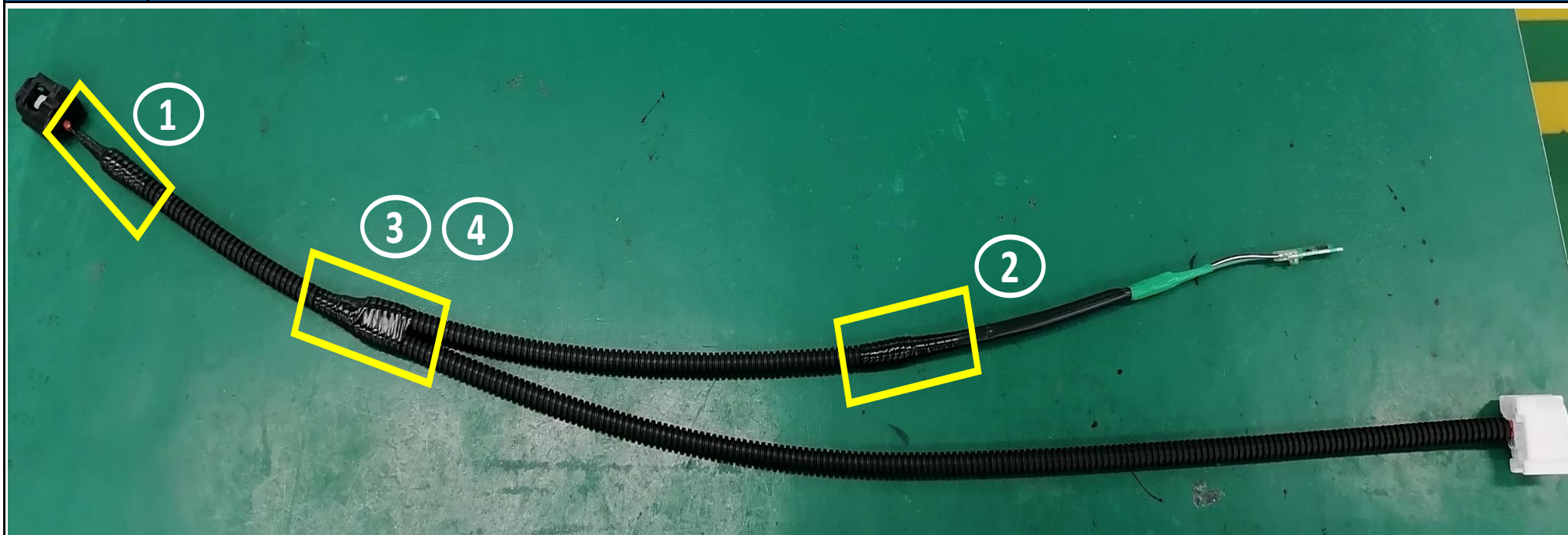
JIG

n/a

QUALITY CHECKPOINTS

P2

7R0118-7021



① ② ③ No MISSING TAPE

④ Correct Facing of Y-taping

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp