

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**Product Name/Code: **241B / 7L0049-7021A**Customer: **TRQSS**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

April 27, 2021

Validity Date:

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WI-ENG-PDE-176B

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2

Page No.:


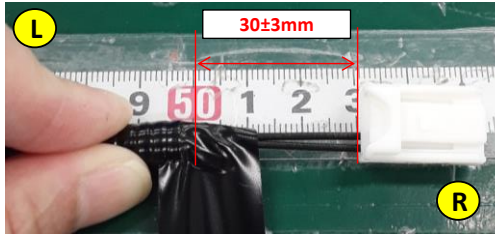
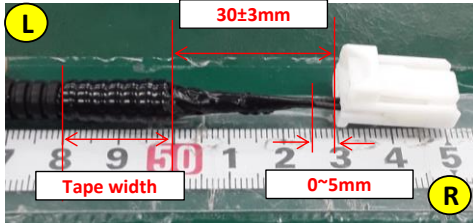

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PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	<p>Taping 1 COT to wire near Connector</p>   <p>1. Hold corrugated tube using left hand then get black tape and conduct pre-taping using right hand.</p> <p>2. Measure the end of the corrugated tube up to the edge of connector $30 \pm 3\text{mm}$. Continue taping process. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>3. After taping, check the measurement and tape condition.</p>	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <p>MEASURING TAPE</p> 	<p>1.No peel-off tape 2.No flip out tape 3.No loose tape</p> <p>Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p>

Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by	Reviewed by	Approved by	Noted by
04/27/21	2	Put assy parts on pg.4~6 parts section	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
09/30/20	1	Changed process owner from Production (WI-PRO-ASY-114B) to Engineering (WI-ENG-PDE-176B); Apply some improvements; Update some pictures	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes				
03/16/18	0	Previously established Engineering Instruction (EI-ENG-PDE-026). Initial issue.	S. Manalo	R. Alcantara	A. Arañes	n/a	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes

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PARTS:

1. Assy parts

JIG

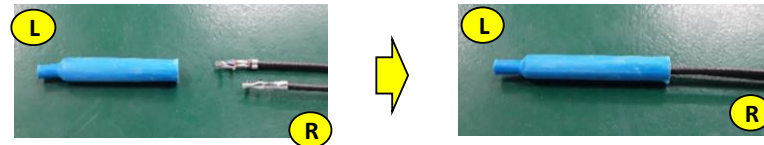
1. Terminal cover jig

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

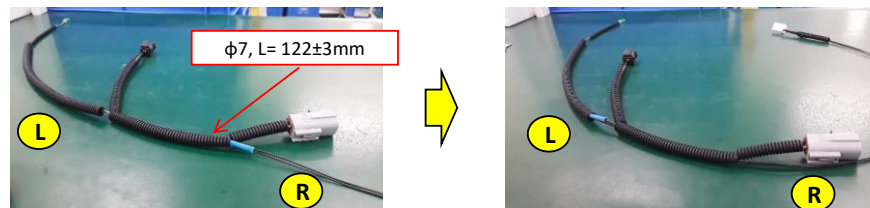
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P2

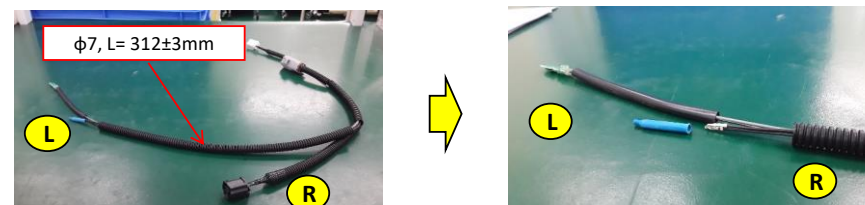
Wire insertion to Assy



1. Get the terminal cover jig using left hand. Hold the 2 Black wires and insert to terminal cover jig using right hand.



2. Get the assy parts using left hand. Insert the 2 Black wires in COT (no slit) $\phi 7, L = 122 \pm 3 \text{mm}$ and $\phi 7, L = 312 \pm 3 \text{mm}$.



3. Remove the terminal cover jig after insertion.

TERMINAL COVER JIG

1. No wrong insertion to corrugated.

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☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

Wire insertion to sunprene tube
Ø5 L=106±3mm



1. Hold the Sunprene tube Ø5 L=106±3mm using left hand and insert the 2 Black wires using right hand.

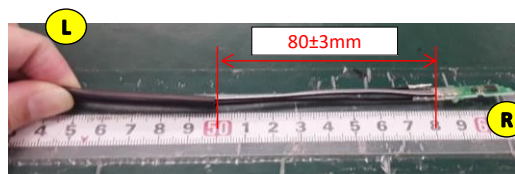
n/a

1. No wrong insert
2. No deformed terminal

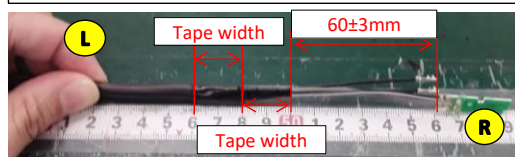
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P2

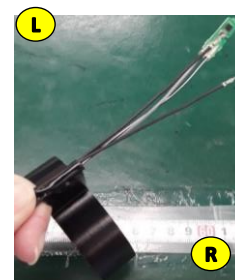
Taping 2
Sunprene tube to wire
near terminal/Hotmelted
wire



1. Measure the end of the Sunprene tube up to the end of the terminal pointed tip and edge of hotmelted wire 80±3mm.



3. After taping, check the measurement, wire alignment & tape condition.



2. Hold the vinyl tube using left hand then start taping using right hand.
Refer to WI-PRO-ASY-001 for taping procedure.

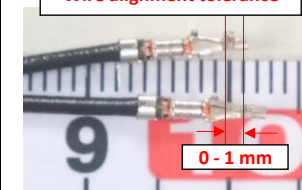
MEASURING TAPE



- 1.No flip out tape.
- 2.No tape peeling.
- 3.No loose tape
4. No wrong dimension

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

Wire alignment tolerance



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PARTS:

2

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

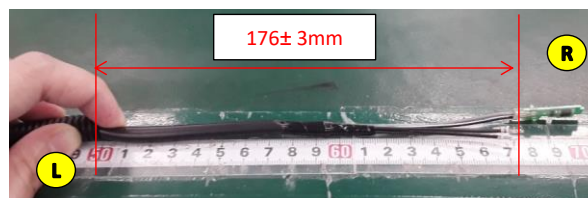
TOOLS/PPE

QUALITY POINTERS

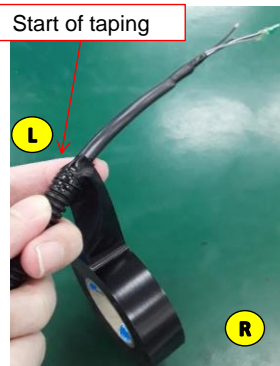
5

P2

Taping 3
COT to Sunprene tube



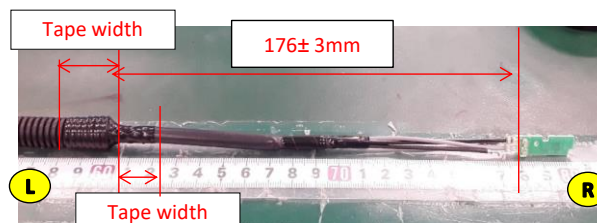
Start of taping



1. Measure the end of the corrugated tube up to the edge of hotmelt and terminal pointed tip **176±3mm**.

2. Hold corrugated tube using left hand then start taping using right hand.
Refer to WI-PRO-ASY-001 for taping procedure.

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



MEASURING TAPE



- 1.No flip out tape.
- 2.No tape peeling.
- 3.No loose tape
4. No wrong dimension

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

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PARTS:



1. Black tape
2. Assy parts

JIG

n/a

NO.

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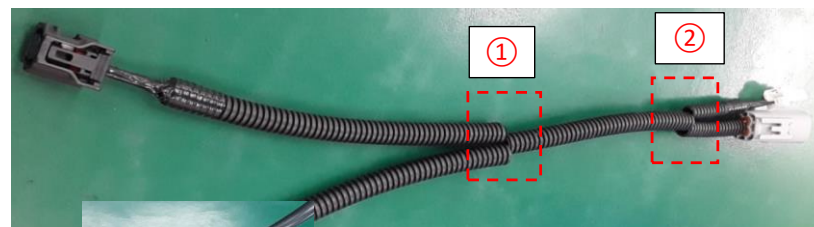
TOOLS/PPE

QUALITY POINTERS

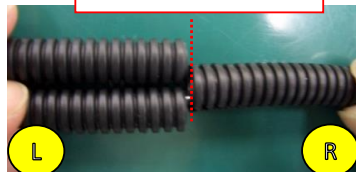
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P2

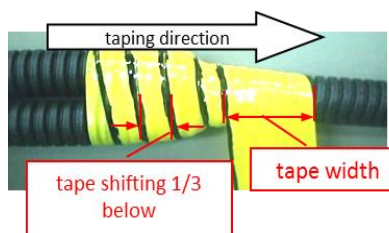
Y-Taping



No wide interval

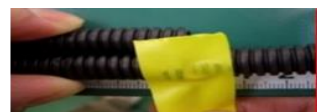


1. Fix the corrugated tube of portion 1.



tape shifting 1/3 below

tape width



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

18±3mm

2. Start taping at the middle of combined Corrugated tubes, then wind the tape going to 2 corrugated tubes, width must be 18±3mm.

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

n/a



Correct Facing

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong dimension
5. Do not exert excessive force during pulling & winding of tape

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PARTS:

3

1. Black tape
2. Assy parts

JIG

n/a

NO.

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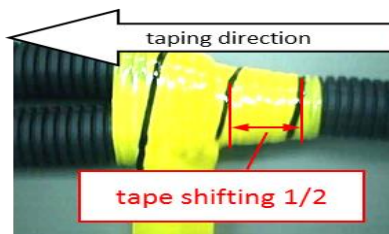
TOOLS/PPE

QUALITY POINTERS

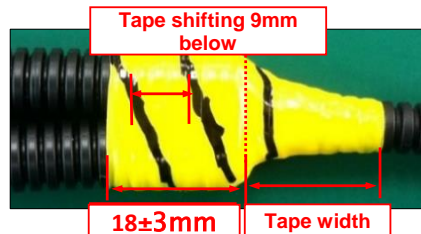
6

P2

Y-Taping
(continuation)



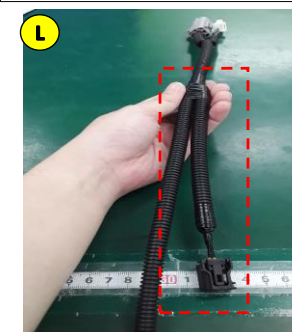
4. Wind the tape backward 1/2 shifting.



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

NOTE:
USED YELLOW TAPE TO EASY VISUALIZE THE TAPE SHIFTING, BUT ACTUAL SHOULD BE BLACK.



Correct Facing

1. No peel-off tape
- 2.No flip out tape
- 3.No loose tape
4. No wrong dimension
5. Do not exert excessive force during pulling & winding of tape

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