



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

March 1, 2021

Process Name/Title:

Validity Date:

-

Product Name/Code:

780B



7R0102-7020B

Customer:

TRMX

Document No.:

WI-ENG-PDE-201B

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

1 of 3

## PARTS:

1. Black tape
2. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

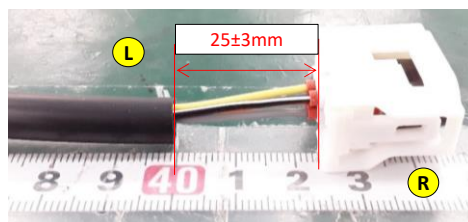
TOOLS/PPE

QUALITY POINTERS

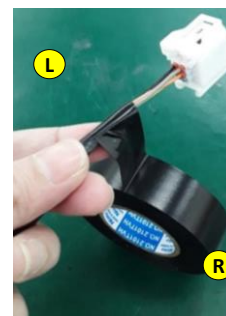
1

P2

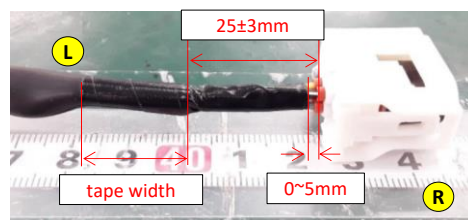
Taping 1  
Vinyl tube to wire near  
connector



1. Hold the Vinyl tube using left hand. Measure the end of Vinyl up to the connector  $25\pm 3\text{mm}$  using right hand.



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



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**

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

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

## Revision History

Prepared by:

Reviewed by:

Approved by:

Noted by:

03/01/21

1

Part number change; change status from pre-launch to masspro; change dimension of taping from COT to PCB from 152mm to 176mm and change illustration

J. Loterte

C. Villanueva

A. Shimamura

A. Arañes

J. Loterte

C. Villanueva

A. Shimamura

A. Arañes

Eff. Date

Rev. No

Details of Change

Revise

Check

Approve

Noted

Est. Date:

December 1, 2020

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PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

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### PARTS:

1. Black tape
2. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P2



Taping 2  
COT to Sunprene



1. Hold the COT using left hand. Measure the end of COT up to the edge of hotmelted wire  $176\pm3\text{mm}$  using right hand.



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

MEASURING TAPE



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

**Note:**

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



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

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

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Page No.:

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### PARTS:

1. Black tape
2. Assy parts

### JIG

n/a

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

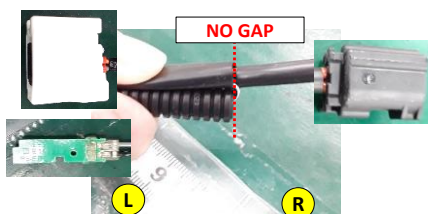
### TOOLS/PPE

### QUALITY POINTERS

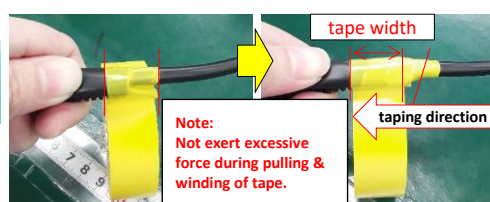
3

P2

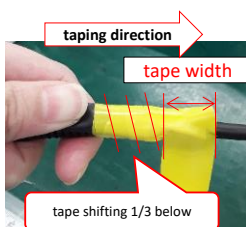
Y-taping



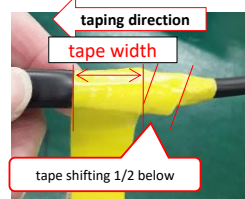
1. Fix the corrugated and Vinyl tube.



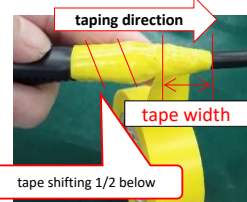
2. Start taping at the middle of combined Corrugated tube and vinyl tube Make 1 wind pre-tape before shifting then wind the tape going to corrugated tube and vinyl tube, width must be same with tape (19mm).



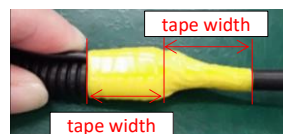
3. Wind the tape 1/3 shifting until it reach the other side of Vinyl tube (must be tape width)



4. Wind the tape backward 1/2 shifting.



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



### MEASURING TAPE



**Note:**  
Used **Yellow** tape to easily visualize the tape shifting.  
But actual should be **Black**.

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wide interval between the COT
5. No wrong use of tape

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



### Connector Orientation

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