
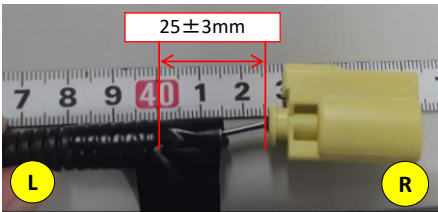
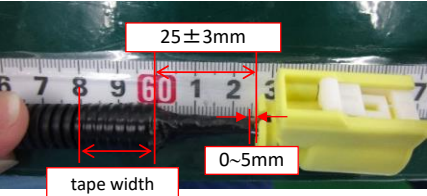



	WORK INSTRUCTION				Effectivity Date:		April 29, 2021	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Product Name/Code: ES1 / 7M0508-7020B		Customer: TRJ		Document No.: WI-ENG-PDE-039B	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		4	Page No.: 1 of 3

PARTS:	1. Black tape 2. Assy parts	JIG:	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Taping COT to wire near connector	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>1. Hold the corrugated tube using left hand and conduct pre-taping using right hand.</p> </div> <div style="text-align: center;">  <p>2. Measure the corrugated tube up to the connector 25mm using right hand then continue the taping process. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure</i></p> </div> </div> <div style="display: flex; justify-content: space-around; margin-top: 20px;"> <div style="text-align: center;">  <p>3. After taping, check the dimension and taping condition.</p> </div> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div> <div style="border: 1px dashed red; padding: 5px;"> MEASURING TAPE  </div>	1. No loose tape 1. No flip-out ape 3. No peel-off tape 4. No wrong measurement <div style="color: red; font-size: small;"> Note: Please use calibrated/verified measuring tape when getting the measurement. </div>

Revision History								Prepared by	Reviewed by	Approved by	Noted by
04/29/21	4	Remove validity date	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes					
10/23/20	3	Remove cycle time, update pictures and apply some improvements; excluded taping jig counter set-up	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes					
03/06/18	n/a	Previously established as Engineering Instruction (EI-ENG-PDE-020). Initial issue.	S. Manalo	R. Alcantara	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Established Date: September 24, 2018				

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WORK INSTRUCTION

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

Product Name/Code: **ES1 / 7M0508-7020B**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

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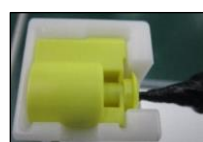
PARTS:

1. Assy parts
2. Gray tape (10mm)

JIG

1. Spot taping jig

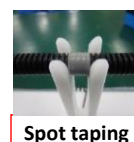
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2	Spot taping	n/a	



Connector setting

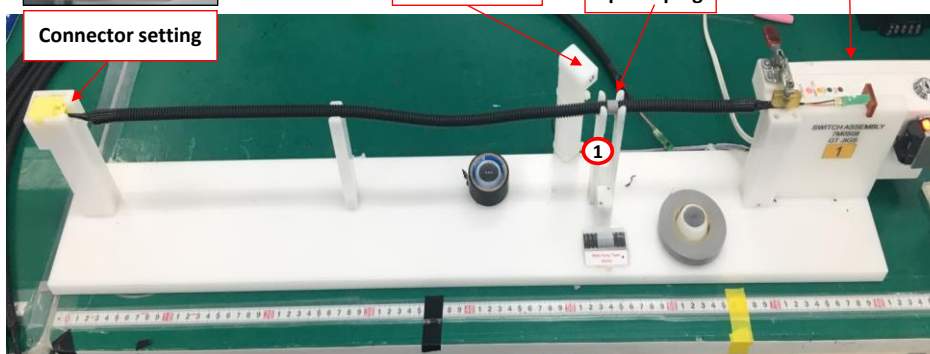


Color Sensor



Spot taping

Controller



1. Put assy on the Jig using both hands. Put first the connector to receiver base, second, put the PCB into stopper jig then pull the toggle clamp using both hands.

Note: See above illustration for proper setting.

3. Conduct **POINT CHECKING** after taping and before removal from jig.

2. Get the Gray tape using right hand and start spot taping on **location 1** using both hands make 3 winds and press the SW button. Go buzzer will be heard if the color sensor detects Gray tape If encountered abnormality, **STOP** the process, **CALL** the Leaders and **WAIT** for instructions.



NO GAP

Make sure no gap between PCB and stopper jig

1. No wrong use of tape
2. No excess/lacking tape windings

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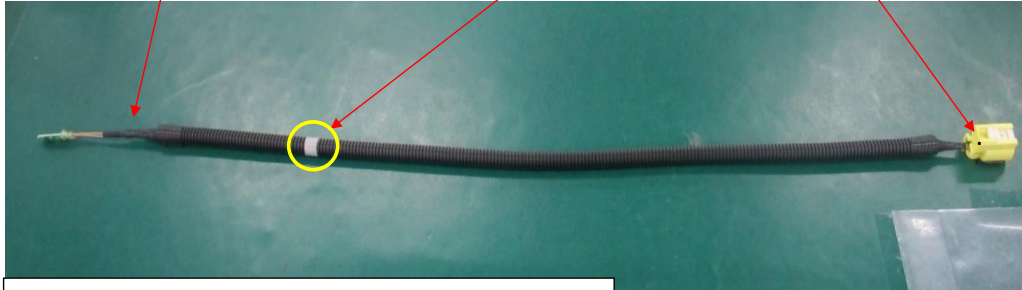

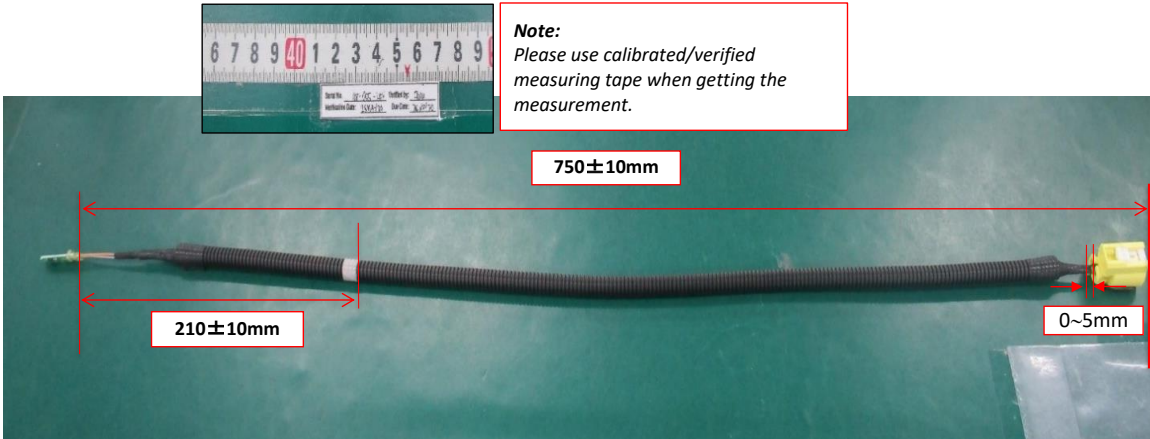
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PARTS:	n/a			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Visual/By Two's Inspection	<div>1. Check the taping condition.</div> <div>2. Check the presence of <u>Gray tape</u>.</div> <div>3. Check the connector lock and rubber seal if properly inserted.</div> <div></div> <div>4. Compare to Master Sample <i>Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy</i></div> <div><i>Note: Refer to Taping jig counter set up WI-ENG-PDE-182</i></div>		MASTER SAMPLE 
4		Measurement	<div></div> <div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div>		NOTE: FOR HATSUMONO AND OWARIMONO 1. No wrong dimension

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