



WORK INSTRUCTION

Process Name/Title: **Taping Assembly Process**

Model Code/Part Number: **715W / 7H0338W7020A** Customer: **NBS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

May 19, 2022

Validity Date:

n/a

Document No.:

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Revision No.:

1

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PARTS: 1. Assy parts; Black Vinyl tube Ø5 L=58±3mm; Black tape

JIG:

1. Measuring Jig

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

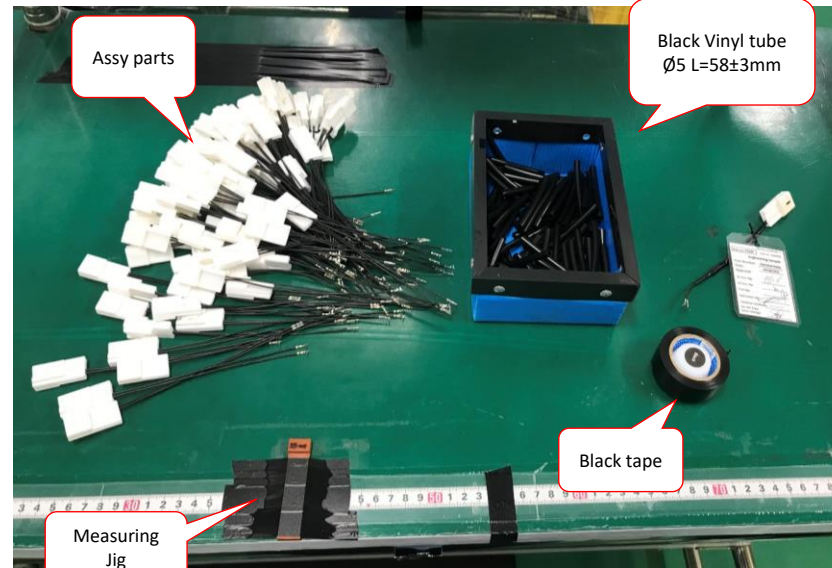
QUALITY POINTERS

1

n/a

Table Lay-out

TABLE LAY-OUT



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 work place is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/ tools.
2. No excess parts/tools.

Revision History

Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/19/22	1	Change Pre-launch to Masspro. Additional Table Lay-out.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
04/29/22	0	Initial Issue.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revise	Check	Approve	Noted	Est. Date:	April 29, 2022		

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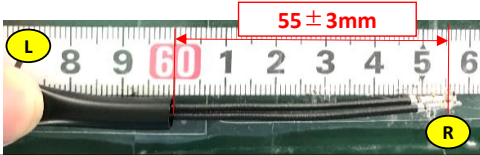
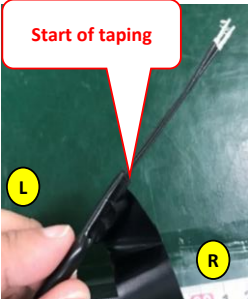
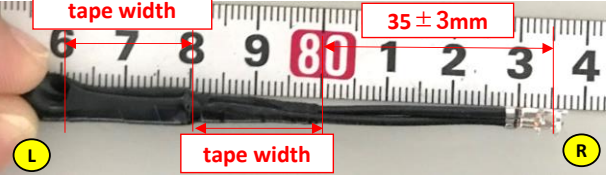

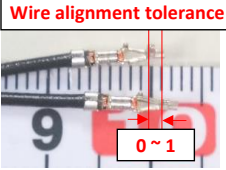
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PARTS:		1. Assy parts 2. Black Vinyl tube $\varnothing 5$ L=58 \pm 3mm 3. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black vinyl tube $\varnothing 5$ L= 58 \pm 3mm	 <p>1. Get the Vinyl tube $\varnothing 5$ L= 58\pm3mm using right hand then insert the B-B wires.</p>	n/a	1. No wrong usage of parts 2. No deformed terminal
3	P1 Taping 1 Vinyl tube to wire near terminal	 <p>1. Measure from end of Vinyl tube up to terminal pointed tip 55\pm3mm then continue the taping process using both hands.</p>  <p>2. Get the Black tape using right hand then start taping process using both hands. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>3. After taping, check the measurement, terminal appearance and taping condition.</p>	 <p>Measuring Tape</p>	<p><i>Note:</i> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p> <p>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</p>  <p>Wire alignment tolerance</p>

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PARTS:

1. Assy parts
2. black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

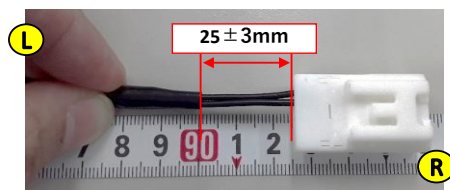
TOOLS/PPE

QUALITY POINTERS

4

P1

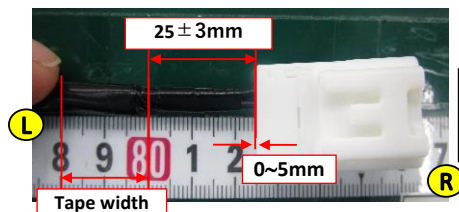
Taping 2
Vinyl tube to wires near
connector



1. Measure from end of Vinyl tube to connector **25mm** using both hands.



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



3. After taping, check the measurement and taping condition

MEASURING TAPE



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

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

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PARTS:

n/a

JIG

n/a

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

5

P1

Visual/By Two's inspection

1. Check the connector lock.

2. Check the taping condition

3. Check the terminal appearance. Make sure no deformed terminal.

4. Compare to Master Sample

*Note: Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-Assy.***MASTER SAMPLE**

6

Measurement

*Note:**Please use calibrated/verified measuring tape when getting the measurement.***172±3mm****0~5mm****35±3mm****NOTE: FOR HATSUMONO AND OWARIMONO**

1. No wrong dimension

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