



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Part Number:

D94L / 7N0030-7020

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

June 7, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-054C

Revision No.:

4

Page No.:

1 of 5

PARTS:

1. Assy parts; Black tape

JIG:

N/A

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

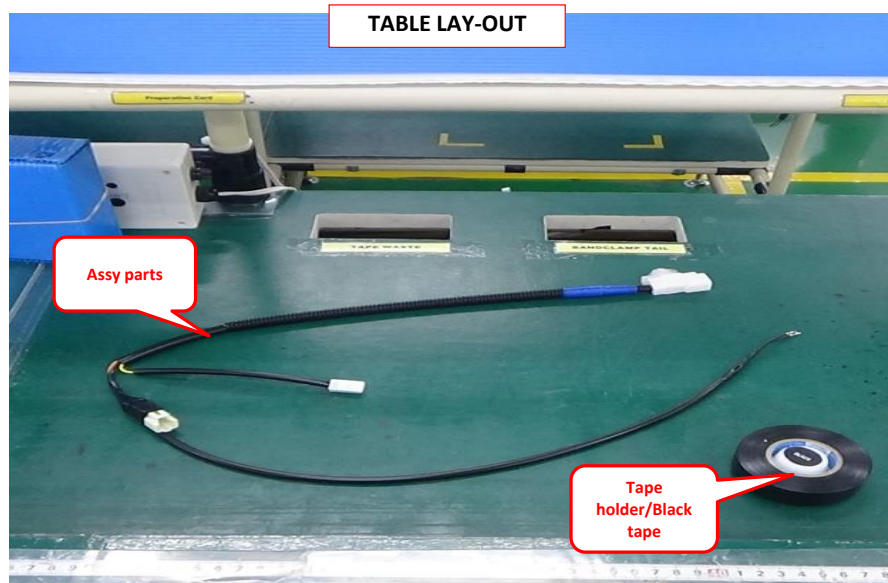
TOOLS/PPE

QUALITY POINTERS

1

P3

Table Lay-out

**Safety Instruction**

Be sure to wear required 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.

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

06/07/23

4

Transfer process no. 1,3,4 and 5 to Clamp Assembly Process; Transfer process of Taping 1 (COT to SV tube (Vinyl)); Taping 2 (Pre-taping: SV tube to wire) due to change process distribution. Additional table lay-out. Inclusion of Quality Checkpoints. Standardized tube description: SV tube (Vinyl).

M. Ariola

J. Loterte

C. Villanueva

A. Arañes

04/26/21

3

Change clamp color in accordance with color standardization for plastic parts refer to GL-COM-003. Rephrase the band cut instruction ; Put taping measuring tape instruction on measurement.

J. Loterte

R. Peñaloza

A. Shimamura

A. Arañes

10/07/20

2

Remove cycle time; Apply some improvement.

M. Catapang

J. Loterte

A. Shimamura

A. Arañes

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

December 7, 2019

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PARTS:

1. Black tape

JIG

n/a

NO.

PROCESS NAME

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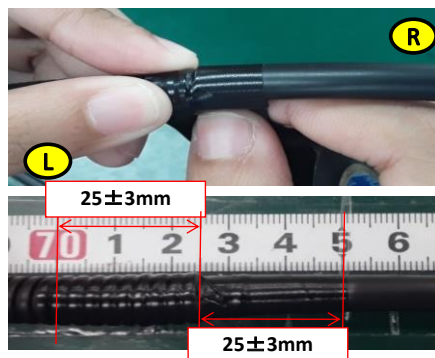
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

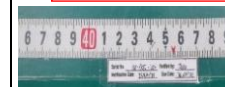
4

Taping 1
COT to SV tube (Vinyl)
near wire

1. Fix the corrugated tube to SV tube (Vinyl) and then hold the black corrugated tube using left hand and start taping using right hand.

2. After taping, check the tape condition & measurement.

MEASURING 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

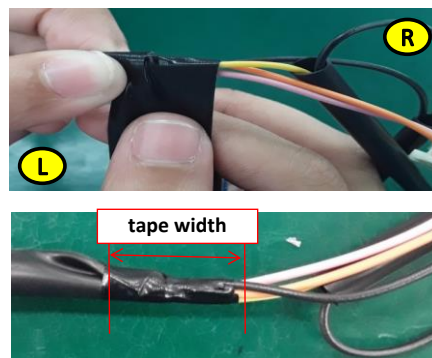
Important reminders/note/s:

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

P3

3

4

Pre-taping Black SV tube
(Vinyl) to wire

1. Get the tape and make **2 windings** pre-taping.
Note: Taping should start from end of vinyl tube (Ø7 L=74±3mm) up to wire.

2. After taping, check the tape condition & measurement.

MEASURING 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

Important reminders/note/s:

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

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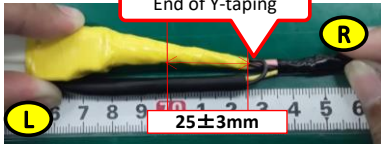




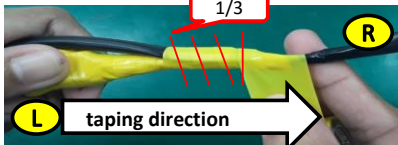

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

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Model Code/Part Number: **D94L / 7N0030-7020** Customer: **TRJ**
Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Black tape 2. Assy parts		JIG	N/A		
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
4	P3	Y-Taping 2	<div></div> <div>1. Measure the end of tape from y-taping 1 and end of Black SV tube (Vinyl) (Ø5 L=119±3mm) 25mm.</div>	<div></div> <div>2. Get the black tape and fix the wire tape to black SV tube (Vinyl) . Make 2 windings before shifting.</div>	<div><div>MEASURING TAPE</div></div>	<div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension</div> <div>Important reminders/Note/s:</div> <div>1. Used <u>YELLOW TAPE</u> for easy visualization of tape shifting. But actual should be BLACK.</div> <div>2. Make sure end of first y-taping and the SV tube (Vinyl) is a line together before taping.</div> <div>3. Please use calibrated/verified measuring tape when getting the measurement.</div> <div><div>GOOD FACING</div><div>NG FACING</div></div>	
			<div></div> <div>3. Make 1/3 shifting to the right side and continue taping up to SV tube (Vinyl) . <i>Note: Vinyl tube covered by tape must be 25mm.</i></div>				<div></div> <div>4. Make 1 wind and then 1/3 shifting to the left.</div>

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2. Assy parts

JIG

N/A

NO.

PROCESS NAME



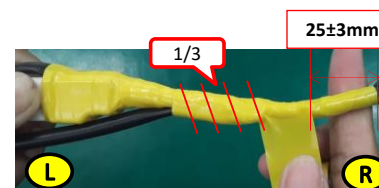
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

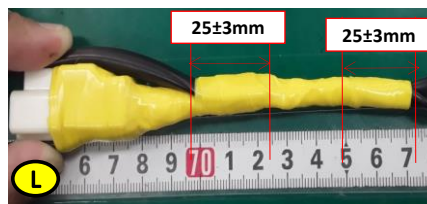
QUALITY POINTERS

4

P3

Y-Taping 2
(Continuation)

5. Make **1 wind** and then **1/3** shifting to the right until SV tube (Vinyl) and make **3 winds** then cut.



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

MEASURING TAPE



Important reminders/Note/s:

1. Used **YELLOW TAPE** for easy visualization of tape shifting. But actual should be **BLACK**.
2. Make sure end of first y-taping and the SV tube (Vinyl) is a line together before taping.
3. 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

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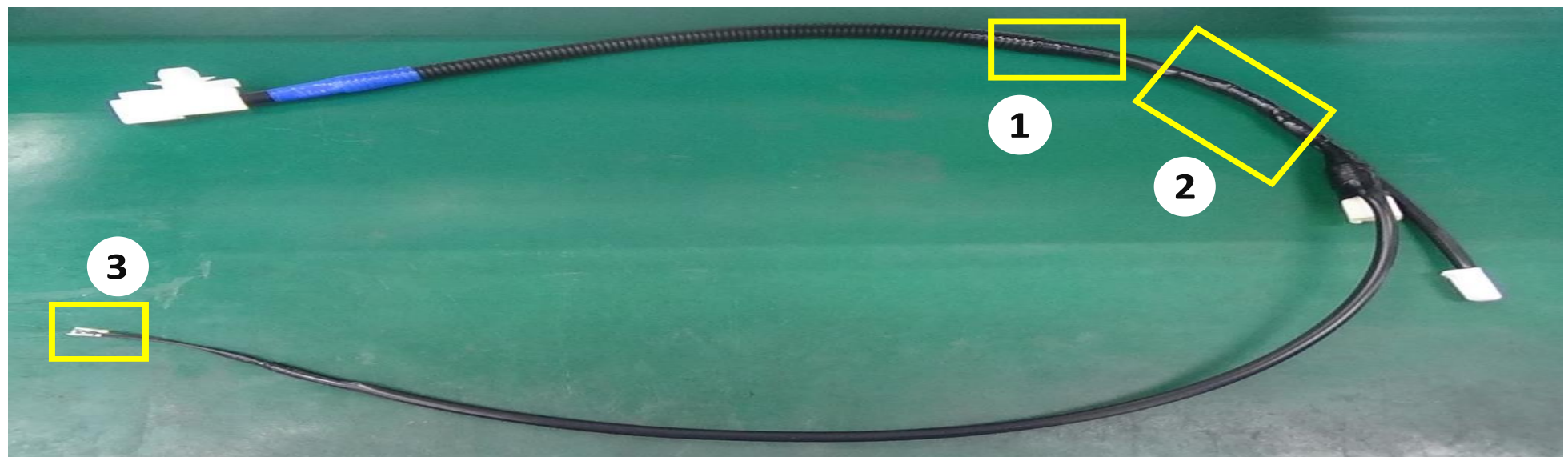
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5 of 5**PARTS:**

N/A

JIG

N/A

**QUALITY CHECKPOINTS****P3****7N0030-7020****1****No Missing Tape****2****No Missing Tape for y-taping****3****No Deformed terminal**

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