



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 12, 2022

Model Code/Product Number: 740B / 7H0422W7020

Customer:

NBS

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-514

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts: Black corrugated tube (no slit) Ø5 L=39±2mm (With slit L=25±5mm); Black vinyl tube Ø5 L=100±3mm; Black tape [1pc.]

JIG:

1. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

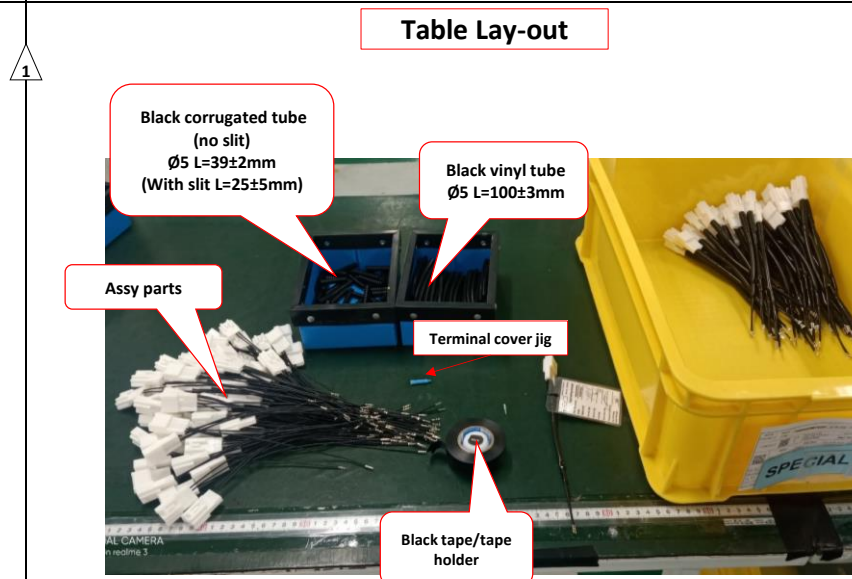
TOOLS/PPE

QUALITY POINTERS

1

P1

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 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

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/12/22	1	Change document purpose from pre-launch to masspro. Additional table layout.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
05/04/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

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PARTS:		1. Assy parts 2. Black tape			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P1	Wire insertion to Black corrugated tube (no slit) Ø5 L=39±2mm (With slit L=25±5mm)	 <div>1. Get the terminal cover jig using right hand then insert the B-B wires using left hand.</div>  <div>2. Get the Black corrugated tube Ø5 L=39±2mm (With slit L=25±5mm) using right hand and insert the B-B wires using left hand.</div>  <div>3. After insertion, remove the terminal cover jig using right hand.</div>	<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts 2. No deformed terminal	
3		Wire insertion to Black vinyl tube Ø5 L=100±3mm	 <div>1. Get the Black vinyl tube Ø5 L=100±3mm using right hand and insert the B-B wires using left hand.</div>	n/a	1. No wrong use of parts	

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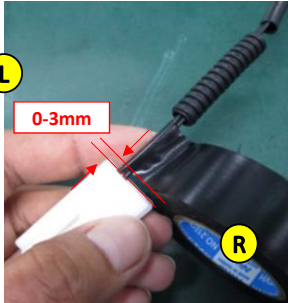
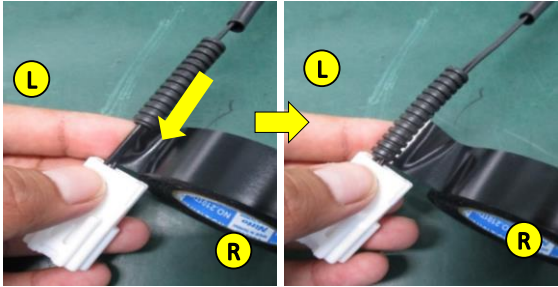
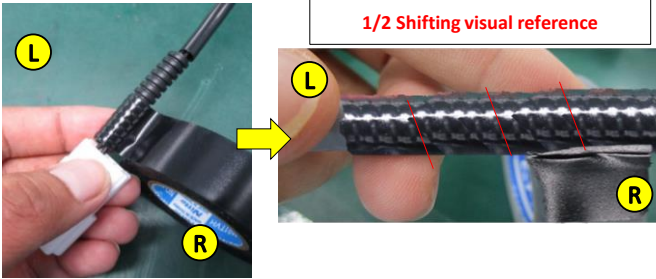

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 1 Wire to Black corrugated tube (no slit) (With slit L=25mm) to Black vinyl tube near terminal	 <p>1. Hold the connector using left hand and attach the Black tape on wires using right hand (see picture for illustration) then make 2 windings and do not cut the tape. Note: Attachment of tape to wire must be from 0-3mm</p>  <p>2. After taping, insert the COT w/slit into Black tape using left hand.</p>  <p>3. After insertion, conduct 2 windings of tape then make 1/2 shifting going to right side until it covers the COT with slit.</p>	MEASURING TAPE 	Note: <i>Please use calibrated/verified measuring tape when getting the measurement.</i> 1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape

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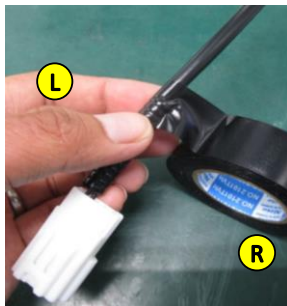
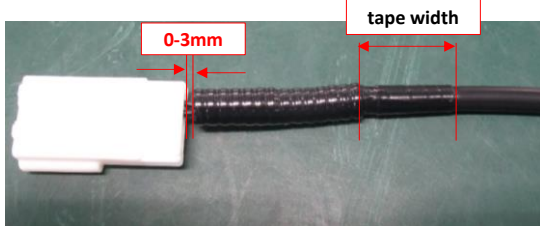

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Taping 1 Wire to Black corrugated tube (no slit) (With slit L=25mm) to Black vinyl tube near terminal (Continuation)	 	MEASURING TAPE 	<i>Note:</i> <i>Please use calibrated/verified measuring tape when getting the measurement.</i> 1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape

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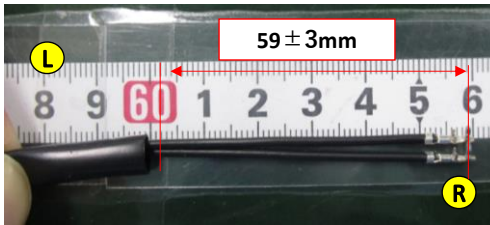
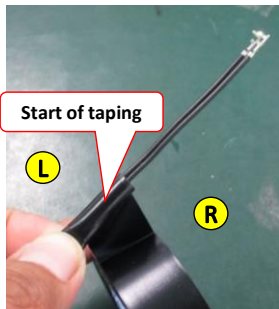
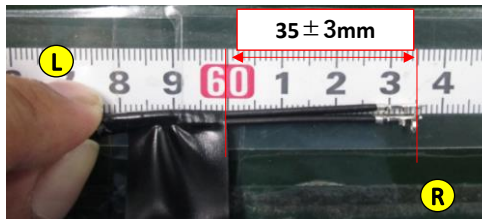
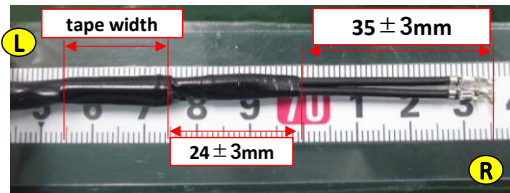

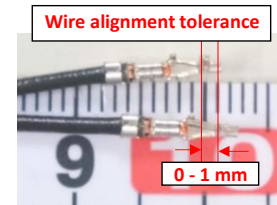
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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 Taping 2 Black vinyl tube to wire near terminal	 <p>1. Measure from end of vinyl tube up to terminal pointed tip 59±3mm using both hands.</p>  <p>2. Hold the vinyl tube using left hand, get Black tape and start taping process using both hands. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p>  <p>3. Confirm measurement of 35±3mm from end of tape up to terminal pointed tip then continue the taping process using both hands.</p>  <p>4. After taping, check the measurement, terminal appearance and taping condition.</p>	 <p>MEASURING TAPE</p>	 <p>Wire alignment tolerance 0 - 1 mm</p> <ol style="list-style-type: none">1. No peel-off tape2. No flip-out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape <p><i>Note: Please use calibrated/verified measuring tape when getting the measurement.</i></p>

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PARTS:

1. Assy parts

JIG

n/a

NO.

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TOOLS/PPE

QUALITY POINTERS

6

P1

Visual/By Two's inspection

1. Check the double lock condition.

2. Check the taping condition.

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

4. Compare to MASTER SAMPLE.
Please refer to GL-PRO-ASY-007 for By Two's inspection of sub-assy.

MASTER SAMPLE



7

Measurement

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

NOTE: FOR HATSUMONO AND OWARIMONO

1. No wrong dimension

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