


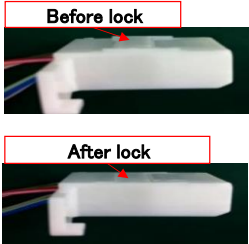
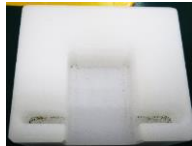
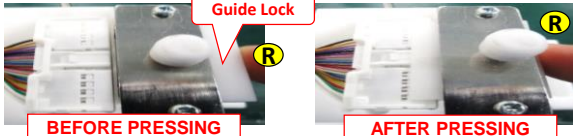
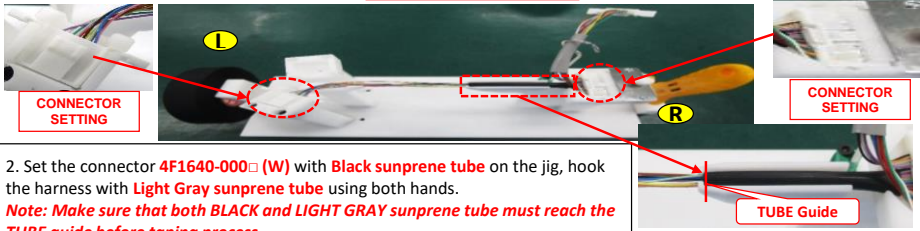


# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:	August 12, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-299E		
Revision No.:	0	Page No.:	1 of 4

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Product Name/Code:	970A / 17J711-7051P	Customer:	NBC
Purpose:	<input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO		

PARTS:		1. Assy parts 2. Tesa tape 51036		JIG:	1. Locking jig 2. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Connector Lock	 <p>1. Put the connector to locking jig using right hand then press down the connector to locking jig <b>2x</b> using right thumb. 2. Touch the connector lock after locking. <i>Note: Please refer to GL-PRO-ASY-017 for the verification of connector lock.</i></p> 		<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>1. No damaged double lock. 2. No halfed lock connector</p>  <p><b>NOTE: MANUAL LOCKING MAY CAUSED DAMAGED LOCK.</b></p>
2	P5 Taping 1 & 2 Wire taping (Tesa)	 <p>1. Set the connector <b>1827842-1 (W)</b> then push the guide lock using right index finger.</p>  <p>2. Set the connector <b>4F1640-000 (W)</b> with <b>Black sunprene tube</b> on the jig, hook the harness with <b>Light Gray sunprene tube</b> using both hands. <i>Note: Make sure that both BLACK and LIGHT GRAY sunprene tube must reach the TUBE guide before taping process.</i></p>			<p>1. No wrong setting of harness 2. No wrong orientation of connector</p>

### Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
08/12/21	0	Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
							Est. Date:	August 12, 2021		

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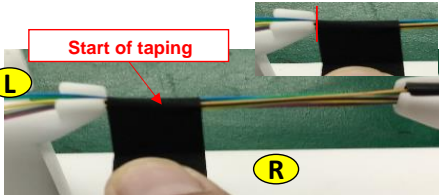
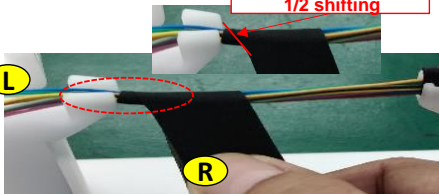





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**PARTS:**

1. Assy parts

**JIG**

1. Taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P5 Taping 1 & 2 Wire taping (Tesa) (Continuation)	<div><p>Start of taping</p></div> <div><p>1/2 shifting</p></div> <div><p>OLFA Cutter</p></div> <div></div> <div></div> <div>3. Using the guide, make <b>1 winding</b> of tape before shifting.</div> <div>4. Wind the <b>1/2 shifting or 3-4 winds</b> going to the right side near vinyl tube using both hands.</div> <div>5. Use the provided cutter to cut the tesa tape using both hands.</div> <div>6. Remove the connector <b>4F1640-000□ (W) (with Black sunprene tube)</b> from jig using left hand then press the tape using right hand. Avoid touching the adhesive.</div>		<div><p>The end tape must be half wrap</p></div> <div>1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend wire 6. No NG of end tape</div>

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☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

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#### PARTS:

1. Assy parts

#### JIG

1. Taping jig
2. Measuring jig

#### NO.

#### PROCESS NAME

#### WORK PROCEDURE/ ILLUSTRATION

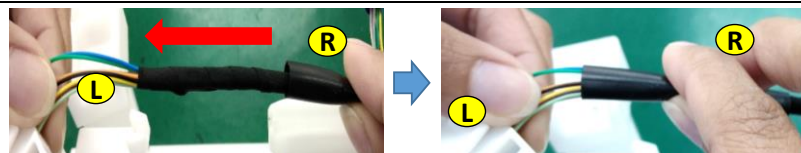
#### TOOLS/PPE

#### QUALITY POINTERS

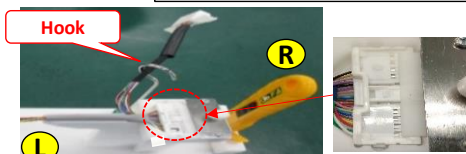
2

P5

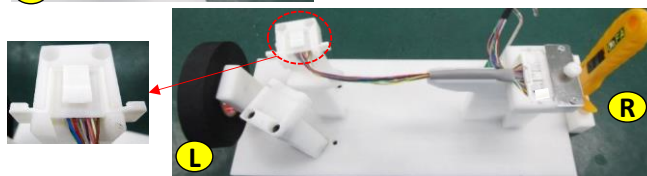
Taping 1 & 2  
Wire taping (Tesa)  
(Continuation)



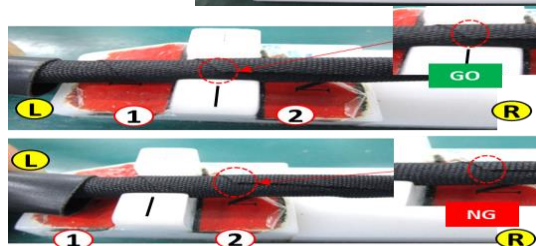
7. After taping, pull the vinyl tube to the left side position using right hand.



8. Place the assy parts with **Black sunprene tube** to Hook.



9. Set the assy with **Light Gray sunprene tube** then repeat the process from step 3 to 7.



10. After taping, check the **END POINT TAPE** using measuring jig.

**Note: END POINT TAPE should be within the limit GO. If end point tape reaches the location 1 and 2 it will be considered as NG.**

OLFA Cutter



The end tape must be half wrap



1. No loose tape
2. No excessive tape winding
3. No damage on parts
4. No peel off tape
5. No bend wire
6. No NG of end tape

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**PARTS:**

1. Assy parts

**JIG**

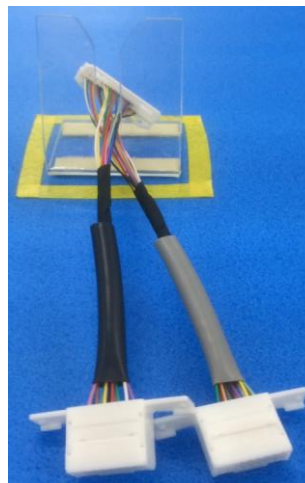
1. WIP Holder

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

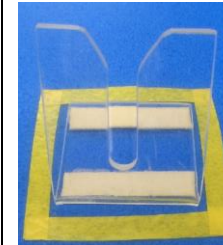
3

P5

Pass WIP to P6



1. Pass WIP to WIP Holder.

**Note: One piece flow.****WIP HOLDER**

1. No WIP overflow

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