



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 17, 2023

Validity Date:

n/a

Model Code/Part Number: 920B / 7R0122-7021A

Customer:

TRMX

Document No.:

WI-ENG-PDE-656B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 6

PARTS:

1. All parts: Assy parts: Clamp 82711-52070 (W); Black tape

JIG:

1. Tesa cutter

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

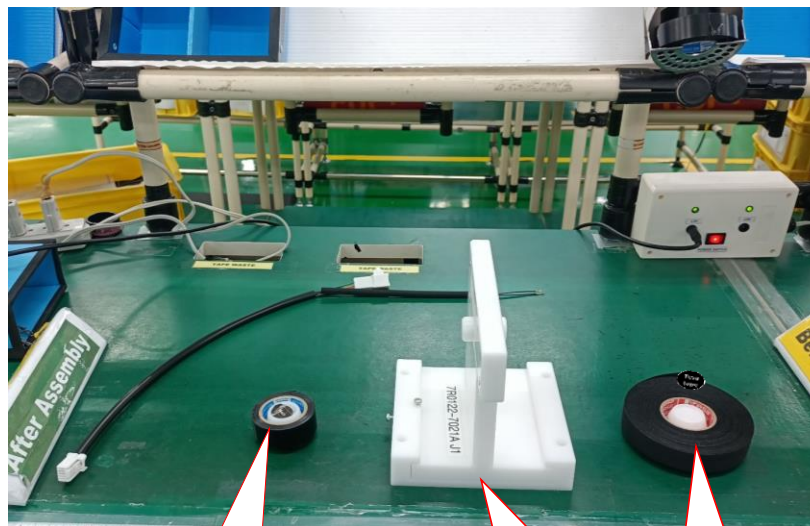
QUALITY POINTERS

1

P2

Table Lay-out

Table Lay-out

Black tape/
Tape holder

Tape cutter

Tesa tape/ Tape
holder

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.

TAPE CUTTER



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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/17/23	1	Change document purpose from pre-launch to masspro. Inclusion of table lay-out. Transfer process from P1.	D. Castillo	J. Loterte	C. Villanueva	A. Arañes	D. Castillo	J. Loterte	C. Villanueva	A. Arañes
03/23/23	0	Initial issue.	D. Castillo	J. Loterte	C. Villanueva	A. Arañes	D. Castillo	J. Loterte	C. Villanueva	A. Arañes

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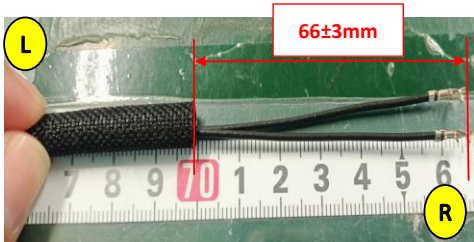
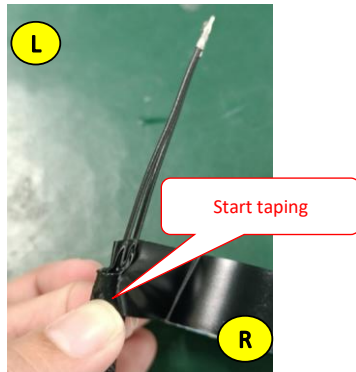
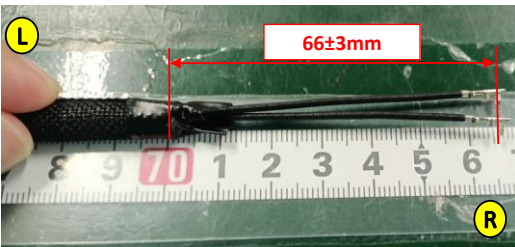

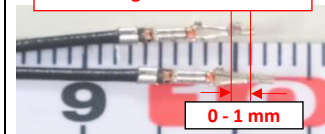
2 of 6

PARTS:

1. Assy parts.
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Spot taping 2	<div></div> <div>1. Measure from Black twist tube 2420F 66±3mm up to terminal tip.</div> <div></div> <div>2. Hold the assy parts using left hand . Get Black the black tape using right hand.</div> <div></div> <div>3. After taping, Check the measurement taping condition and wire alignment.</div>	<div>MEASURING TAPE</div> 	<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement. <div></div>

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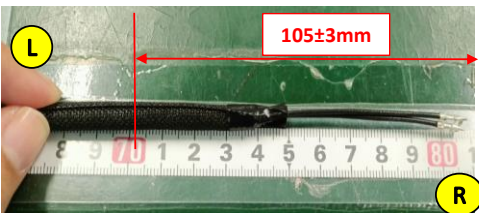
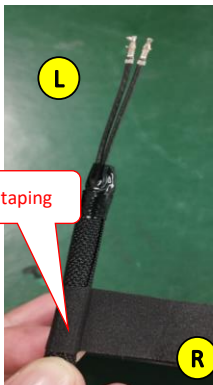
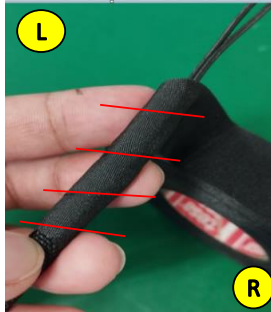


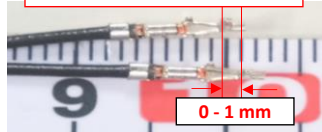
3 of 6

PARTS:

1. Assy parts.
2. Black tesa tape (Tesa 51036)

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	<div>1</div> <div>P2</div> <div>Taping 1 Black twist tube 2420F to Wire near terminal</div>	<div><div></div><div><div></div><div><div></div><div><div></div></div></div></div></div>	<div>MEASURING TAPE</div> <div></div>	<div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</div> <div>Important reminders/Note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div><div>Wire alignment tolerance</div><div></div></div>

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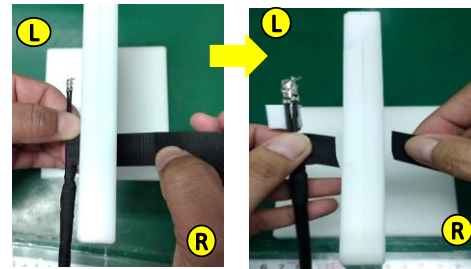
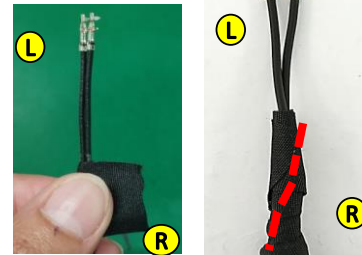
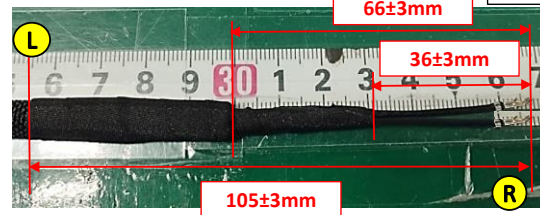
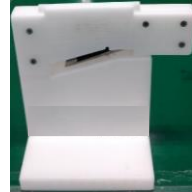

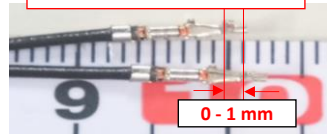
☒ MASSPRO

Revision No.:

1

Page No.:

4 of 6

PARTS:		1. Assy parts		JIG	1. Tape cutter
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div><div>1</div><div>P2</div><div>Taping 1 Black twist tube 2420F to Wire near terminal (Continuation)</div></div>	<div><div><div></div><div></div><div></div><div></div></div></div>		<div><div>TAPE CUTTER</div><div></div><div>MEASURING TAPE</div><div></div></div>	<div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</div> <div><div>Important reminders/Note/s:</div><div>1. Please use calibrated/verified measuring tape when getting the measurement.</div></div> <div><div>Wire alignment tolerance</div><div></div></div>

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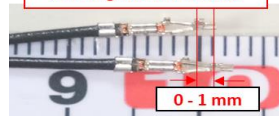

5 of 6

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 1 Spot taping 3	 <p>1. Hold the assy part using left hand then get the Black tape using right hand. then start taping process using both hands.</p> <p>2. Conduct windings of tape until it covers the end of tesa tape then make 2 windings of tape before end of tape using both hands.</p> <p>3. After spot taping, check the taping condition and alignment of wires. Note: End of tesa tape must not be visible</p>	n/a	<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement. <p>Wire alignment tolerance</p>  <p>SPOT TAPING APPEARANCE</p>  <p>Spot taping range should be from 20~25mm only</p>

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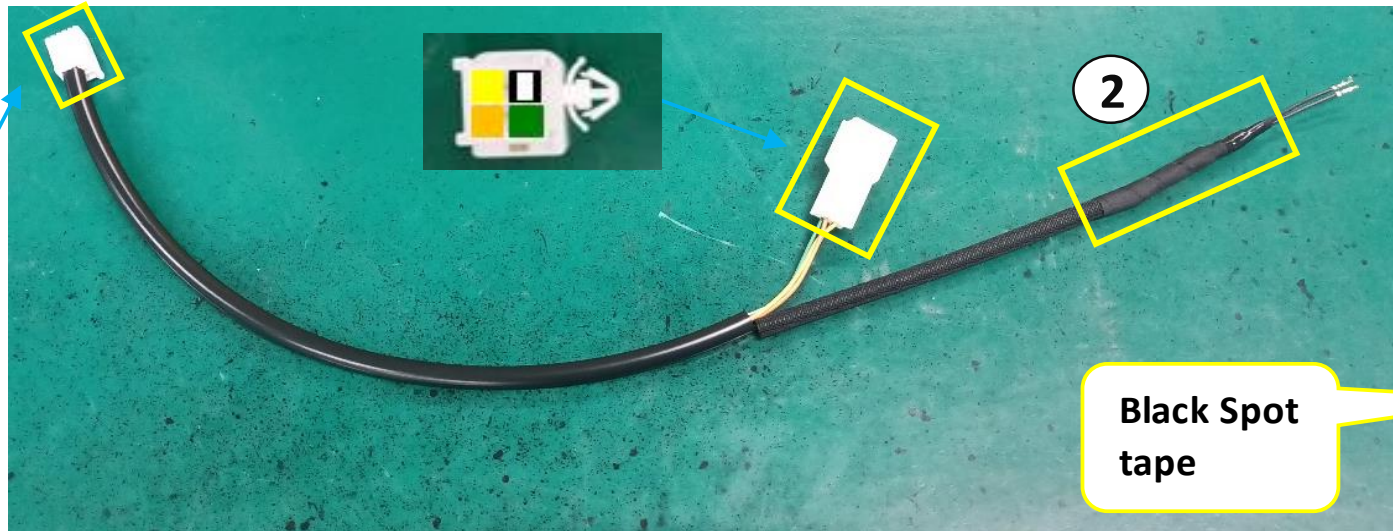
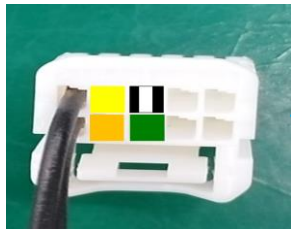
Page No.:

6 of 6**PARTS:**

1. Assy parts

JIG

n/a

QUALITY CHECKPOINTS**P2****7R0122-7021A****Black Spot
tape****① No Missing tape (Tesa tape)****② No Missing Spot tape**

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