



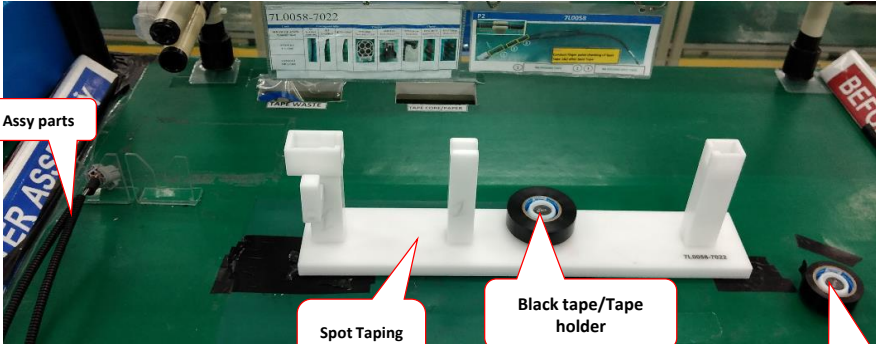
WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	November 25, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-228B		
Revision No.:	3	Page No.:	1 of 4

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number: **150B / 3 7L0058-7023** Customer: **TRQSS**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		3 1. Assy parts; Black tape [2pcs.]		JIG:	1. Spot taping jig
NO.	PROCESS NAME		3 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	3 Table Lay-out	<div>Table Lay-out</div> <div></div>	<div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Prepared by	Reviewed by	Approved by	Noted by
11/25/21	3	Change part number from 7L0058-7022 to 7L0058-7023 due to additional clamp (82711-52090 (W)) (Refer to WI-ENG-PDE-228D). Improve work procedure and illustration. Additional table lay-out.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
02/01/21	2	Transfer process owner from Production (WI-PRO-ASY-134B) to (WI-ENG-PDE-228B); Add Y-taping orientation in 2Y-taping process for reference; Add measuring tape illustration and instruction on pg. 1~2	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes
03/13/20	1	Additional work procedure in taping	J. Silang	A. Morcozo	O. Merin	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
			Est. Date:	October 17, 2018		

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROPCESS

Model Code/Part Number:

150B

/ 3

7L0058-7023

Customer:

TRQSS

Purpose:

☐ PROTOTYPE

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

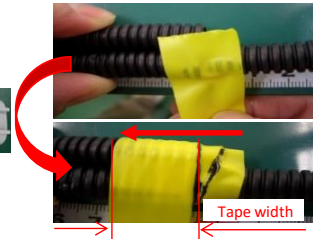
2

P2

Y-taping

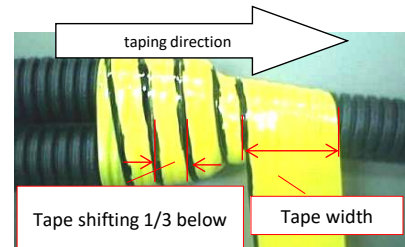


1. Fix the corrugated tube .

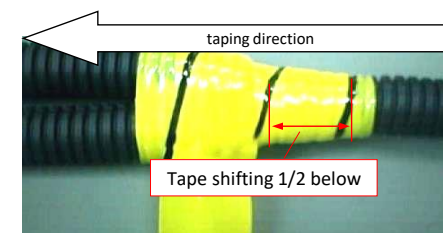


Note: Do not exert excessive force during pulling & winding of tape

2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side, width must be same with tape (19mm)



3. Wind the tape $\frac{1}{3}$ shifting until it reach the other side of corrugated tube (must be tape width)



4. Wind the tape backward $\frac{1}{2}$ shifting

MEASURING TAPE



Note:

USE **YELLOW TAPE** FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE **BLACK 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

Y-TAPING ORIENTATION



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PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

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Page No.:

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

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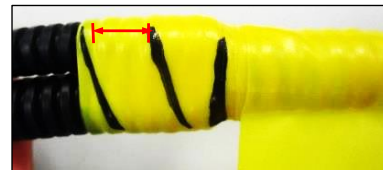
TOOLS/PPE

QUALITY POINTERS

2

P2

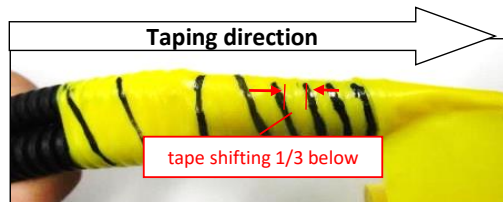
Y-taping
(continuation)



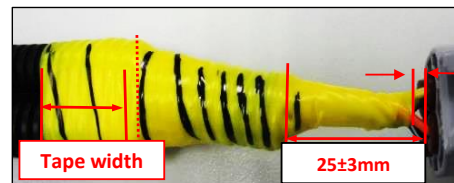
5. Wind the tape $\frac{1}{2}$ shifting going to other side of corrugated tube.



6. Make the half of tape outside the COT then wind it 2-3 times as Pre-Taping.



7. Wind the tape $\frac{1}{3}$ shifting until it reach the wire , make 3 winds to wires then cut.



Note: 0 - 5mm
→ End tape up to coupler (includes rubber seal)

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

MEASURING JIG



1. No flip-out tape
2. No peel-off tape
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4. No missing tape
5. No wrong dimension
6. No wrong use of tape

Note:

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

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JIG

1. Spot Taping jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

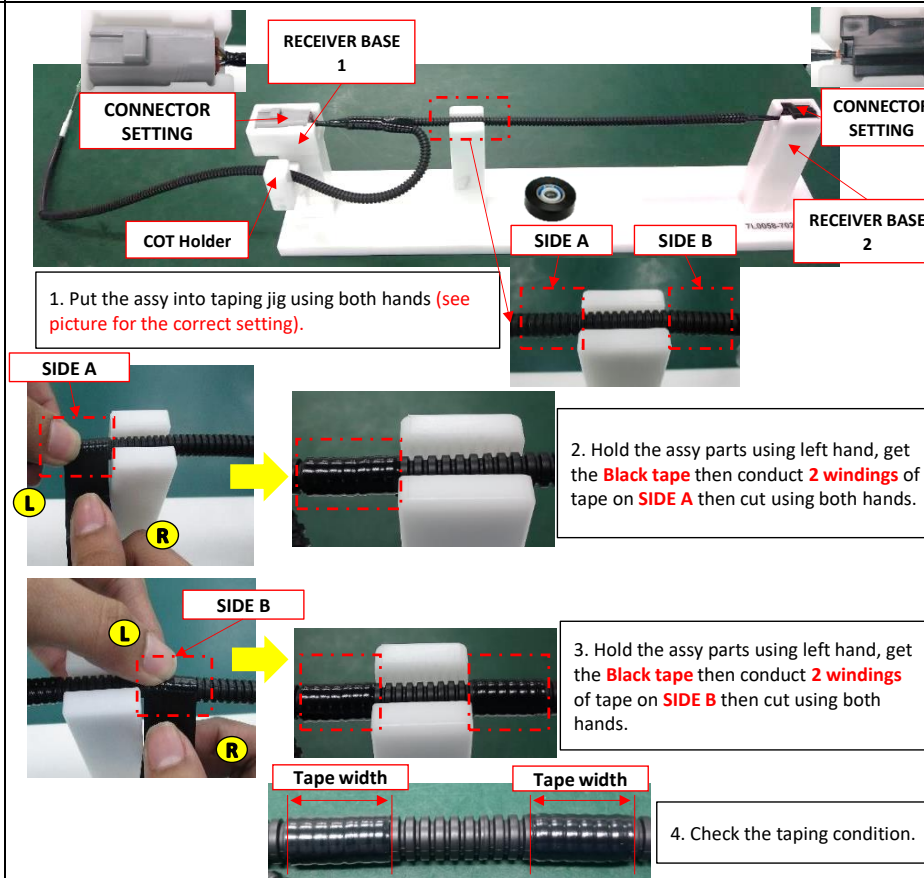
TOOLS/PPE

QUALITY POINTERS

3

P2

Spot taping



n/a

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