



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	August 12, 2021		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-300F		
Revision No.:	0	Page No.:	1 of 4

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

Product Name/Code: **240B / 17J613-7091P** Customer: **NBC**

Purpose: ☐ PROTOTYPE ☒ PRE-LAUNCH ☐ MASSPRO

PARTS:		1. Assy parts 2. Black TESA Tape No 51036		JIG:	1. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P6 Taping 3 Wire taping (Tesa)	<p>1. Set the connector 1827842-1 (W) then push the guide lock using right index finger.</p> <p>2. Continue to set the harness on Jig 2. (See picture for the correct setting).</p>		<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>1. No wrong setting of harness 2. No wrong orientation of connector</p>

Revision History

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

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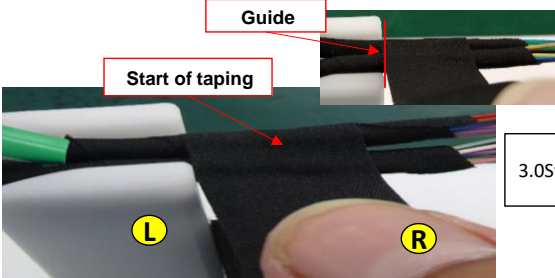
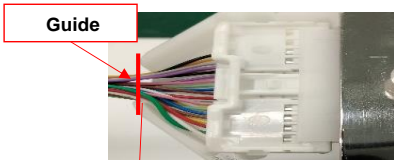
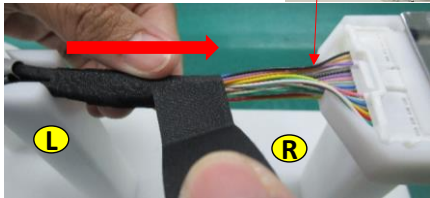
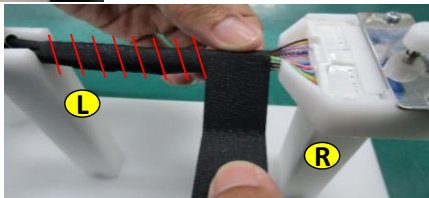
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PARTS:

1. Assy parts

JIG

1. Taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P6 Taping 3 Wire taping (Tesa) (Continuation)	    <p>3.0 Start taping using guide 1 1/2 winding.</p> <p>4. Make 7~8 windings from pre-tape going to right side until it reach the guide near connector. DO NOT PULL THE TAPE TOO TIGHT DURING TAPING TO AVOID STRESS ON WIRES.</p> <p>5. Once it reaches the guide, make 2 windings of tape. DO NOT PULL THE TAPE TOO TIGHT DURING TAPING TO AVOID STRESS ON WIRES.</p>	n/a	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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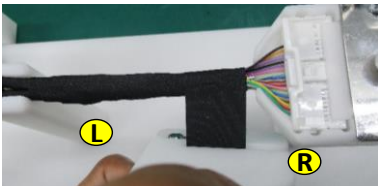
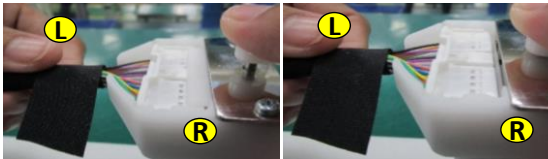
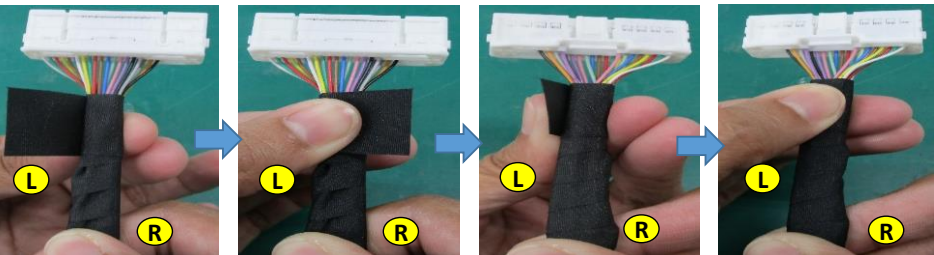

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PARTS:

1. Assy parts

JIG

1. Taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P6 Taping 3 Wire taping (Tesa) (Continuation)	 <p>6. Cut the tape using provided cutter only using both hands.</p>  <p>BEFORE PRESSING</p> <p>AFTER PRESSING</p> <p>7. Hold the assy parts then press the lock button using right thumb. Remove the harness from jig.</p>  <p>8. Press the end tape using left hand. Do not touch the adhesive</p>	 <p>Use only this cutter</p>	<ol style="list-style-type: none">1. No loose tape2. No excessive tape winding3. No damage on parts4. No peel off tape5. No bend wire6. No NG of end tape

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4 of 4**PARTS:**

n/a

JIG

n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****1****P6**Taping 3
Wire taping (Tesa)
(Continuation)

8. After taping, check the alignment and condition of tape.

9. Proceed to **Continuity checking**, refer to **WI-ENG-PDE-308** if encountered problem, refer to **Treatment on Levercon continuity checker NG WI-ENG-PDE-001**.10. Refer to **WI-ENG-PDE-309 End Tape Pressing**.11. Refer to **IS-ENG-PDE-003 17J613-7091P Inspection Guide**.

n/a

1. No loose tape
2. No excessive tape winding
3. No damage on parts
4. No peel off tape
5. No bend Wire

Note:
Refer to Work instruction of
Continuity checking, End Tape
Pressing and Inspection Guide for
their separate cycle time.

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