

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Process Name/Title:

Model Code/Part Number: **920B / 7R0118-7020B**

Customer:

TRMX

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

December 06, 2022

Validity Date:

n/a

Document No.:

WI-ENG-PDE-552B

Revision No.:

1

Page No.:

1 of 5

PARTS:

1. Assy parts: Black tape [1pc.]

JIG:

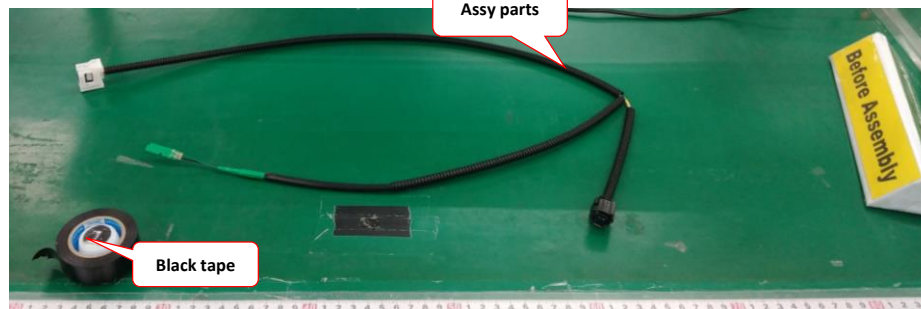
n/a

NO.**PROCESS NAME****1****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P2

Table Lay-out

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

Prepared by

Reviewed by

Approved by

Noted by

12/06/22 1 Additional table lay-out ; Quality checkpoints - as improvement of documentation and process. Improve work procedure/illustration/quality pointers in all process.

M. Catapang J. Loterte C. Villanueva A. Arañes

06/29/22 0 Initial issue

M. Catapang J. Loterte C. Villanueva A. Arañes

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Est. Date:

June 29, 2022

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PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

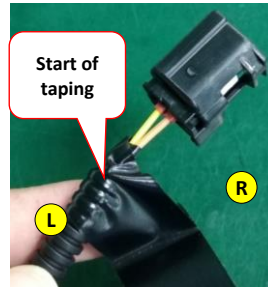
TOOLS/PPE

1 QUALITY POINTERS

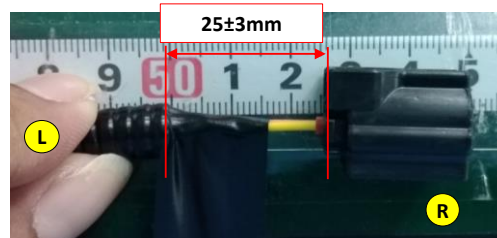
2

P2

Taping 1
COT to wire near
connector



1. Hold the COT then get **Black tape** using right hand then start taping process using both hands.

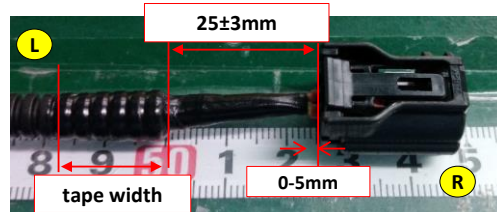


2. Measure from end of COT up to edge of connector **25±3mm** then continue the taping process using both hands.

MEASURING TAPE



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



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

Important reminders/Note/s:

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

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1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

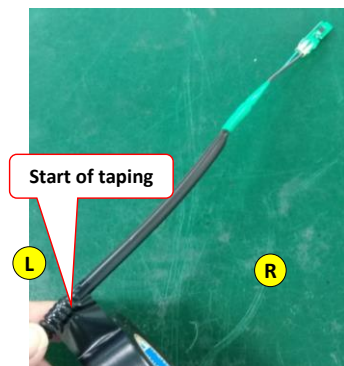
1

QUALITY POINTERS

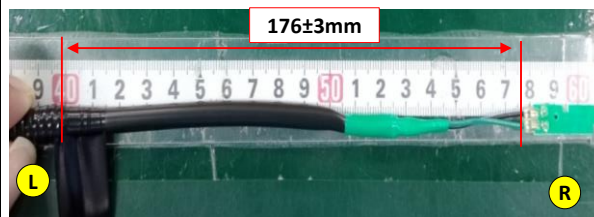
3

P2

Taping 2
COT to sunprene tube
near PCB



1. Hold the COT using left hand, get the **Black tape** using right hand then start pre-taping using both hands.



2. Measure from end of COT up to PCB **176±3mm** then continue the taping process using both hands. **Refer to WI-PRO-ASY-001 for taping procedure.**

MEASURING TAPE



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



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

Important reminders/Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

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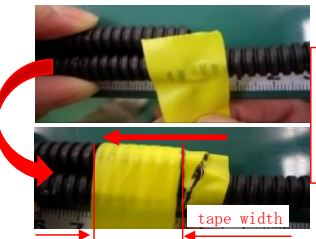
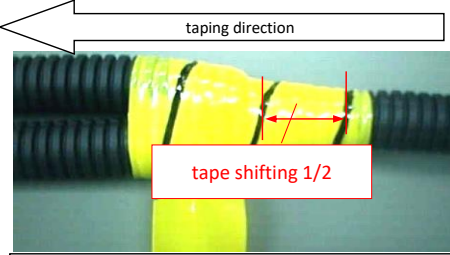
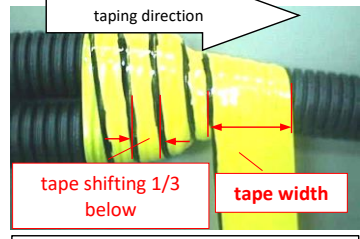
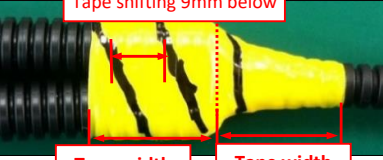
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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	1 QUALITY POINTERS
4	P2 Y-Taping	<p>No gap between tubes</p>  <p>1. Fix the corrugated tube .</p>  <p>Note: Do not exert excessive force during pulling & winding of tape</p> <p>tape width</p> <p>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side, width must be same with tape (19mm)</p>  <p>taping direction</p> <p>tape shifting 1/2</p> <p>4. Wind the tape backward 1/2 shifting</p>  <p>taping direction</p> <p>tape shifting 1/3 below</p> <p>tape width</p> <p>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)</p>  <p>Tape shifting 9mm below</p> <p>Tape width</p> <p>5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p>	n/a	<p>Important reminders/Note/s:</p> <p>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape

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1. Assy parts

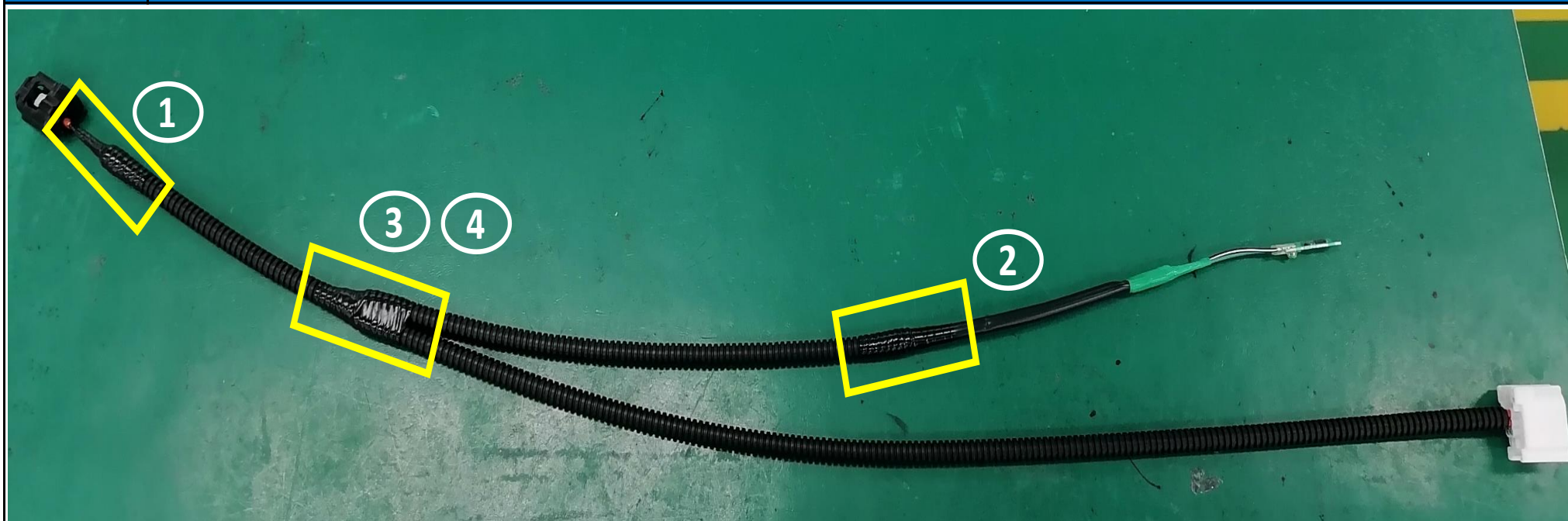
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n/a

1 QUALITY CHECKPOINTS

P2

7R0118-7020B



1 2 3 No MISSING TAPE 4 Correct Facing of Y-taping

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