



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

November 19, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

ES1 / 7N0165-7020C

Customer: TRJ

Car Model: SUBARU-FORESTER

Document No.:

WI-ENG-PDE-1164B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 7

PARTS: 1. Assy Parts ; Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

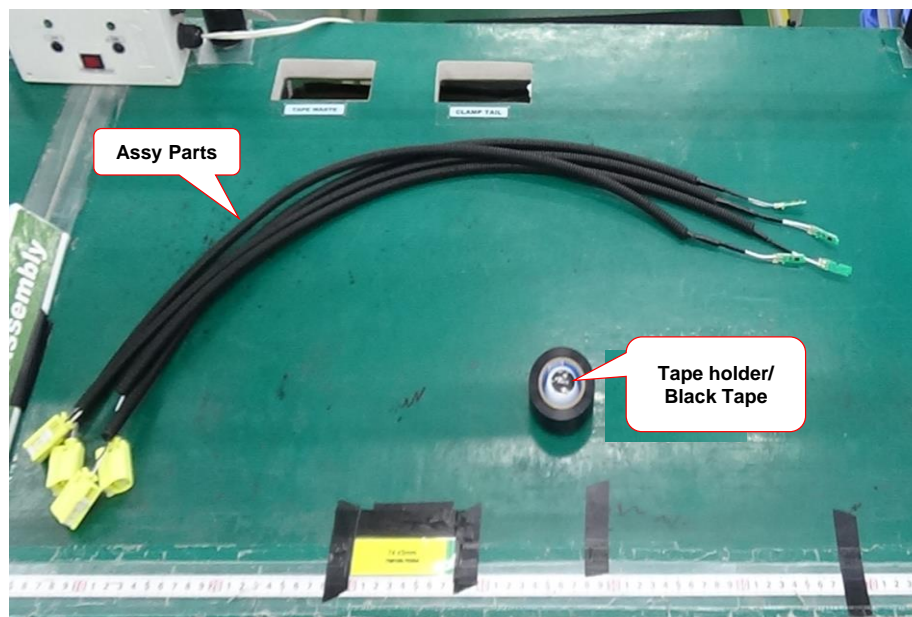
QUALITY POINTERS

1

P2

Table Lay-out

Table Lay-out

**Safety Instruction**

Be sure to wear required 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

11/19/25 1 Change pre-launch to mass pro.

A.Hernandez

C. Villanueva

A. Arañes

n/a

11/18/24 0 Initial issue.

A.Hernandez

C. Villanueva

A. Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

November 18, 2024

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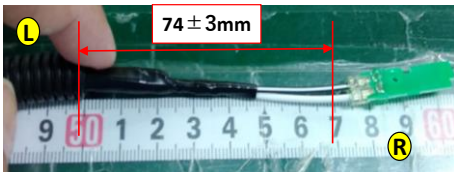
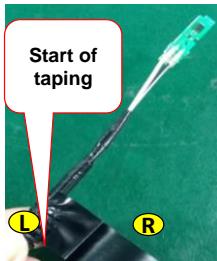
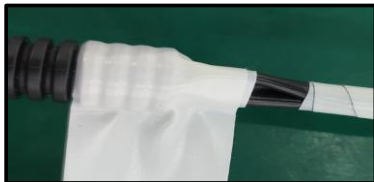

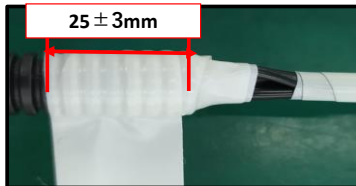

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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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 Taping 2 Black COT (no slit) to Black SV tube (Vinyl) near PCB	<div><p>1. Measure from end of COT up to end of PCB 74±3mm using both hands.</p></div> <div><p>Start of taping</p><p>2. Hold the tube using left hand, get the Black tape using right hand then start taping process using both hands.</p></div> <div><p>TAPING PROCEDURE</p><div><p>3. 1 wind pre-tape in the middle of COT and SV tube (Sunprene)</p></div><div><p>4. Shift the tape 1x shifting going to COT must be tape width</p></div><div><p>5. Conduct 1 wind before shifting</p></div></div>		<div><p>MEASURING TAPE</p></div>	<p>Important reminders/Note/s:</p> <p>1. Used WHITE TAPE to easy visualization of shifting lines, but in actual should be BLACK TAPE</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>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</p>

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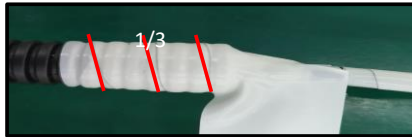

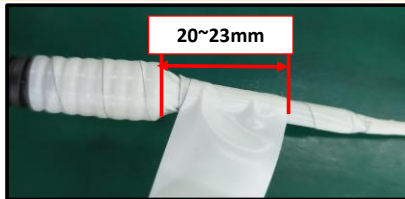

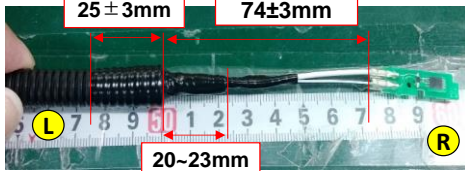


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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Taping 2 Black COT (no slit) to Black SV tube (Vinyl) near PCB (Continuation)	<div></div> <div>6. Shift the tape 1/3 shifting going to VT see above illustration for proper shifting <i>note: 1/3 shifting must be within the COT</i></div> <div></div> <div>7. Shift the tape 1x shifting until reach the tape width</div> <div></div> <div>8. Conduct 2x windings before end of</div> <div></div> <div>9. Conduct 3x pressing at the end of tape to prevent peel off</div> <div></div> <div>10. After taping, check the taping condition and measurement.</div>		<div>MEASURING TAPE</div> 	<div>Important reminders/Note/s:</div> <div>1. Used WHITE TAPE to easy visualization of shifting lines, but in actual should be BLACK TAPE</div> <div>2. Please use calibrated/verified measuring tape when getting the measurement.</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>NG TAPING ILLUSTRATION</div> <div></div> <div>Exceed 24mm consider as NG dimension</div>

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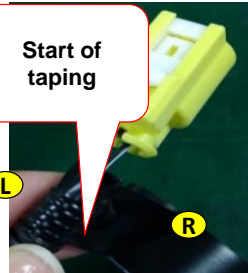

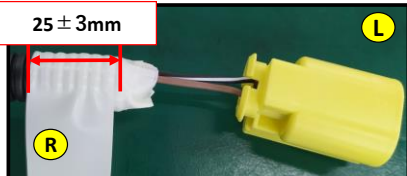
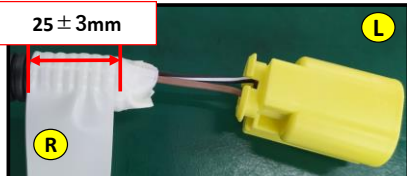
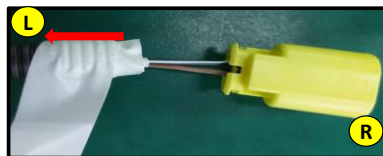
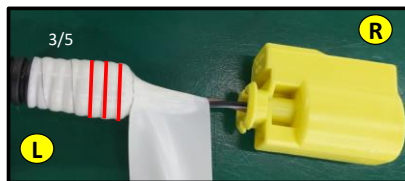
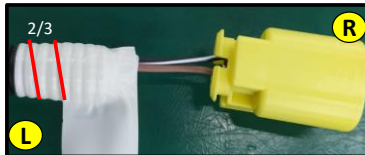
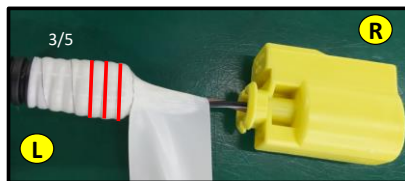

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	<div><div><div><div>Start of taping</div></div><div><div>1. Hold the Corrugated tube using left hand, get the Black tape using right hand then start taping procedure using both hands. (Please refer below for taping procedure)</div><div>TAPING PROCEDURES</div><div></div><div><div>2. 2 winds pre-tape in the middle of COT and wires</div><div></div><div><div>25 ± 3mm</div><div></div></div><div><div>3. Shift the tape 1x shifting going to COT must be tape width</div><div></div></div><div><div>4. Conduct 1 wind before shifting</div><div></div></div><div><div>5. Shift the tape 2/3 shifting upward refer to above illustration for shifting direction</div><div></div></div><div><div>6. Shift the tape 3/5 shifting upward note: 3/5 shifting must be within the cot</div><div></div></div></div></div><div><div>MEASURING TAPE</div></div></div></div>		<div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Used WHITE TAPE to easy visualization of shifting lines, but in actual should be BLACK TAPE</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>	

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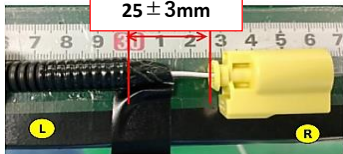



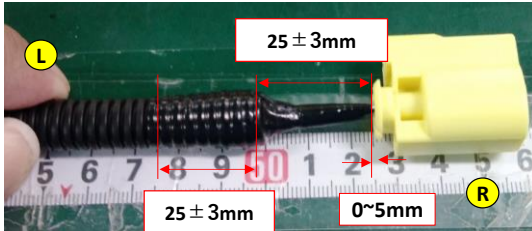

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 1 COT to wire near connector (Continuation)	<div><p>7. Shift the tape <u>1/2 shifting</u> upward until reach the 0~5mm from connector to tape</p></div> <div><p>8. Shift the tape <u>1/2 shifting</u> upward until reach the 0~5mm from connector to tape</p></div> <div><p>9. Conduct <u>2x windings</u> before end of tape</p></div> <div><p>10. Conduct <u>3x</u> pressing at the</p></div> <div><p>11. After taping, check the taping condition and measurement.</p></div>		<div>MEASURING TAPE</div> 	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Used <u>WHITE TAPE</u> to easy visualization of shifting lines, but in actual should be <u>BLACK TAPE</u> 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

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Measurement	<div><p>NOTE: (A) - Taping (B)</p></div>	<div>MEASURING TAPE </div>	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P2

7N0165-7020C



① No **Missing Tape**
(COT to wire near
Connector)

② No **Missing Tape**
(COT to wire near
SV tube)

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